

Advanced Materials**ARALDITE[®] AW 8535 Resin
Hardener HW 8535****TWO-COMPONENT EPOXY ADHESIVE****DESCRIPTION**

ARALDITE AW 8535 Resin/Hardener HW 8535 epoxy adhesive is a two-component epoxy paste designed for bonding metal substrates including oily metals. The system has excellent sag resistance and a 1:1 mix ratio by volume for easy of use.

APPLICATIONS

Metal to metal bonding

ADVANTAGES

Bonds oily metals
Room temperature curing
1:1 mix ratio by volume
Excellent sag resistance

**TYPICAL
PROPERTIES**

<u>Property</u>	<u>Test Method</u>	<u>Test Values⁽¹⁾</u>	
		<u>Resin</u>	<u>Hardener</u>
Color/appearance	Visual	Off-white	Dark gray
Specific Gravity	ASTM D-792	1.43	1.10
Viscosity, cP @ 77°F (25°C)	ASTM D-2393	Paste	Paste

TYPICAL MIXED PROPERTIES

<u>Property</u>	<u>Test Method</u>	<u>Test Values⁽¹⁾</u>
Reaction Ratio (by weight)	ASTM D-2471	100R/75H
Reaction Ratio (by volume)		100R/100H
Color	Visual	Gray
Pot Life, 100 gr. mass @ 77°F (25°C), min.	ASTM D-2471	60
Sag Resistance, 0.25 in./6mm bead, Vertical, 30 min. @ 320°F (160°C), in. (mm)	ASTM D-2471	<0.39 (10)
Mixed viscosity, @ 77°F (25°C), cP	ASTM D-2393	Paste

¹Tested after 7 days @ 77°F (25°C)**RECOMMENDED CURE SCHEDULES**

<u>Temperature</u>	<u>Handling Strength</u>	<u>Minimum Cure Time</u>
77°F (25°C)	5.5 hours	16 hours
140°F(60°C)	20 minutes	1 hour
212°F(100°C)	5 minutes	10 minutes

TYPICAL CURED PROPERTIES

Cured 7 days @ 77°F (25°C)

	<u>Test Values</u>	<u>Test Method</u>
Lap Shear Strength, psi (MPa) @ 77°F (25°C)	2,500 (17)	ASTM D-1002
@ 179°F (82°C)	890 (6)	
Hardness, Shore D	75	ASTM D-2240
Ultimate Tensile Strength, psi (MPa)	2,290 (16)	ASTM D-638
Ultimate Elongation, %	29	ASTM D-638
Tg per DMA, °F (°C)	190 (88)	ASTM D-4065
Coefficient of Thermal Expansion, in./in./°f	14x10 ⁻⁵	ASTM D-3386

¹Tested after 7 days @ 77°F (25°C) unless otherwise noted.

NOTE: These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed in establishing product specifications, please consult with our Quality Control Department.

STORAGE AND SHELF LIFE

ARALDITE epoxy adhesive components should be stored in their original, sealed containers at room temperature. When stored at temperatures from 59-77°F (15-25°C), the resin and hardener will remain in useable condition for 12 months from date of shipping from Huntsman.

**SAFETY/HANDLING
PRECAUTIONS**

Do not use or handle this product until the Material Safety Data Sheet has been read and understood

Personal Hygiene*Safety precautions at workplace*

Protective clothing	Yes
Gloves	Essential
Arm protectors	Recommended when skin contact is likely
Goggles/safety glasses	Yes

Skin protection

Before starting work	Apply barrier cream to exposed skin
After washing	Apply barrier or nourishing cream

Cleansing of contaminated skin

Dab off with absorbent paper, wash with warm water and alkali-free soap, then dry with disposable towels. Do not use solvents.

Clean shop requirements

Cover workbenches/areas with light colored paper. Use disposable beakers.

Disposal of spillage

Soak up with sawdust or cotton waste cloth and deposit in plastic-lined bin.

Ventilation

Of workshop	Renew air 3 to 5 times an hour
Of workplaces	Exhaust fans should be used to prevent operators from inhaling vapors.

FIRST AID

Contamination of the eyes by resin, hardener or mix should be treated immediately by flushing with clean, running water for 10 to 15 minutes. A doctor should then be consulted.

Material smeared or splashed on the *skin* should be dabbed off, and the contaminated area then washed and treated with a cleansing cream (see above). A doctor should be consulted in the event of severe irritation or burns. Contaminated clothing should be changed immediately.

Anyone taken ill after inhaling vapors should be moved out of doors immediately.

In all cases of doubt call for medical assistance.

CAUTION:

Huntsman Advanced Materials Americas Inc. maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material. Copies of the latest MSDS may be requested by calling our customer service group at 888-564-9318 or emailing your request to adhesives@huntsman.com.

**KEEP OUT OF REACH OF CHILDREN
FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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