

Epoxy, Methacrylate & Urethane Adhesives Specifications

	Mix Ratio Resin to Hrd'nr by wt.	Mix Ratio Resin to Hrd'nr by vol.	Gel Time (min)	Light Handling Time	Cure Time at 73°F (hr)	Cure Time at 140°F (min)	Mixed Viscosity (cps.)	Hardness (Shore D)	Lap Shear Strength(psi)	Peel Strength (pli)	Tensile Strength (psi)	Serviceable Temperature Typical/Max (°F)
Epoxy Adhesives												
Araldite® 2010-1	100:100	100:100	10	30 min	3	25	80,000	-	3,300	46	-	105/175
Araldite 2011	100:80	100:100	105	7 hours	10	45	45,000	80	2,700	29	4,800	110/175
Araldite 2012	100:100	100:100	4	20 min	1.75	25	30,000	82	2,700	31	-	105/175
Araldite 2013	100:60	100:100	75	4 hours	10	40	Paste	80	2,600	23	5,000	110/160
Araldite 2014	100:50	100:50	40	4 hours	5	25	90,000	84	2,600	17	5,500	185/285
Araldite 2015	100:100	100:100	40	4 hours	10	40	Paste	75	2,400	29	3,400	150/212
Araldite 2043	100:100	100:100	1	5 min	1	-	20,000*	83	3,100	-	-	flexible
Fastweld 10	100:100	100:100	4	10 min	4	-	250,000	85	2,840	-	3,850	-
AW 1258 / HV 1258	100:100	100:100	23	4 hours	6	-	Paste	89	2,840	-	5,600	-
AW 1253 /HV 1253	100:82	100:100	20	4 hours	6	-	Paste	73	1,990	-	2,130	-
AY 557 / HY 557	100:100	100:100	4	10 min	4	-	14,000	83	2,560	-	4,630	-
AV 8503 / HV 8503	100:92	100:100	30	3 hours	24	60	250,000	78	3,380	-	3,400	250
AV 8531 / HV 8531	100:187	100:200	40	3.5 hours	48	60	310,000	66	3,500	-	2,000	194
AW 8535 / HW 8535	100:75	100:100	60	5.5 hours	16	60	Paste	75	2,500	-	2,290	176
Araldite 8579	100:40	100:40	60	8 hours	8	-	125,000	-	2,500	-	-	248
AW8594 / HY994	100:40	100:55	75	-	not suggested	60	7,500	85	3,410	-	6,600	164
TDR-1100-11	100:42	100:50	95	8 hours	24	60	13,000	85	4,100	-	9,000	195/90
Freeman 505	100:100	100:100	3-5	15 min	4	-	10,400	85	-	-	2,500	200
Methacrylate Adhesives												
Araldite 2021	100:90	100:100	3	8 min	20 min	-	45,000	78	3,200	63	-	230
Araldite 2022	100:94	100:100	10	18 min	30 min	-	60,000	75	3,600	23	-	212
MP 55300	100:100	100:100	4-6	10-15 min	-	-	50,000	-	3,000-3,500	-	3,000-3,500	250
MP 55305	100:100	100:100	3-5	6-10 min	-	-	50,000	-	3,000-3,500	-	3,000-3,500	250
MP 55310	100:100	100:100	10-18	20-35 min	-	-	50,000	-	3,000-3,500	-	3,000-3,500	250
MP 55320	100:10	100:10	8-12	25-30 min	-	-	90,000	-	3,000-3,500	-	3,000-3,500	180
MP 55420	100:10	100:10	4-6	15-20 min	-	-	90,000	-	1,750-2,800	-	2,500-3,500	250

Cure Times = Time required for bond to reach 50% of final shear strength of 150 psi or greater
 Lap Shear Strength = After 7-day cure @ 73°F on aluminum
 Peel Strength = After 7-day cure @ 73°F on aluminum
 Serviceable Temperature = Typical Tg Value/Max Temperature giving LSS of 750 psi

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Polyurethane Adhesives												
Araldite 2018	100:95	100:100	40	4 hours	16	30	8,000	-	1,160	22	-	Flexible
Araldite 2027	100:97	100:100	8	1.5 hours	10	40	Paste	-	2,000	46	2,050	77/140
Araldite 2028	100:100	100:100	6	15	5	30	10,400 / 1,200	-	1,994	6.5	725	Flexible
Araldite 2040	93:100	100:100	15	10 hours	24	120	50,000	30	1,700	-	1,100	flexible
Araldite 2041	80:100	100:100	12	4 hours	16	120	50,000	85A	2,800	-	2,100	flexible
Araldite 2042	80:100	100:100	2.5	1 hour	6	60	50,000	85A	2,800	-	2,100	flexible
Araldite 2055	80:100	100:100	45	6 hours	20	60	Paste	-	1,305	6	-	140/194
AY 8650 / XMH 5090-1	100:500	100:400	80	-	24	180	6,000	-	2,300	-	1,800	140
AY 8683 / HY 8683	100:60	100:60	15	-	24	-	2,750	95A	-	100	3,500	-

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