

MA APPROVAL NUMBER	MAC-SAL-00055
FORM NUMBER	N/A
REVISION NUMBER	01
REVISION DATE	13/06/2014
MD SIGNATURE	

ARALDITE® 2011 (AW 106/HV 953U)

Two component epoxy paste adhesive

Key Properties:	<ul style="list-style-type: none"> High shear and peel strength Tough and resilient Good resistance to dynamic loading Bonds a wide variety of materials in common use
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Description:	Araldite®AW106/HV953U is a multipurpose, two-component, room temperature curing, paste adhesive of high strength and toughness.
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Product Data:	AW106	HV953U	Mixed
Colour (visual):	Neutral	Pale yellow	Pale yellow
Specific Gravity:	Ca. 1.15	Ca. 0.95	Ca. 1.05
Viscosity (Pas):	30-50	20-35	30-45
Pot Life (100 g at 25°C)	-	-	100 minutes
Shelf Life (2-40°C)	3 years	3 years	-

Processing:

Pretreatment:

The strength and durability of a bonded joint are dependent on proper treatment of the surfaces to be bonded. At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone, trichloroethylene or proprietary degreasing agent in order to remove all traces of oil, grease and dirt. Alcohol, gasoline (petrol) or paint thinners should never be used. The strongest and most durable joints are obtained by either mechanically abrading or chemically etching ("pickling") the degreased surfaces. Abrading should be followed by a second degreasing treatment.

Mix Ratio	Parts by weight	Parts by volume
Araldite AW106	100	100
Araldite HV953U	80	100

Application of adhesive:

The resin/hardener mix is applied with a spatula, to the pretreated and dry joint surfaces. A layer of adhesive 0.05 to 0.10mm thick will normally impart the greatest lap shear strength to the joint. The joint components should be assembled and clamped as soon as the adhesive has been applied. An even contact pressure throughout the joint area will ensure optimum cure.

Equipment Maintenance:

All tools should be cleaned with hot water and soap before the adhesive residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation. If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

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Storage:

AralditeAW106 and Araldite HV953U may be stored for up to 3-years at room temperature provided the components are stored in sealed containers.

Handling Precautions:

Caution: Araldite products are generally quite harmless to handle provided that certain precautions are taken when handling chemicals. The uncured materials must not for instance be allowed to come into contact with foodstuffs or food utensils and measures should be taken to prevent the uncured materials from coming into contact with the skin, since people with particularly sensitive skin may be affected. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents on the skin is to be avoided. Disposable paper – not cloth towels – should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in Araldite publication No. 24264/3/ e Hygienic precautions for handling plastics products of Araldite and in the Araldite Material Safety Data Sheets for the individual products. These publications are available on request and should be referred to for fuller information.

All recommendations for the use of our products, whether given by us in writing, verbally or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations, the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process and/or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility there for. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.