



ARALDITE® 2022-1 Structural Adhesive

Product Description

ARALDITE® 2022-1 structural adhesive is a two component, room temperature curing, methacrylate based, general purpose adhesive for rapid assembly operations with a wide variety of substrates.

Features

- Working time: 10-12 minutes
- One to one volume mix ratio
- High peel strength
- Multi-purpose
- Excellent bond to a wide range of plastics, composites and metals
- Suitable for service at temperatures up to 212°F (100°C)

Typical Properties*

Property	ARALDITE® 2022-1 A	ARALDITE® 2022-1 B	Mixed System
Appearance	Off white	Beige / yellow	Pale yellow
Density, g/cm ³	0.99	0.94	~0.98
Viscosity at 25°C (Brookfield, spindle # 7 and at 10 rpm), cPs	228,600	45,200	--
Working time at 25°C, 10 g, min	--	--	10.00-12.00
Flash point (°F)	10	10	--

*Properties are based on Huntsman test methods. Copies are available upon request

Processing

Mix Ratio

Product	Parts by weight	Parts by volume
ARALDITE® 2022-1 A	100	100
ARALDITE® 2022-1 B	95	100

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, iso-propanol (for plastics) or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt. Low-grade alcohol, gasoline, 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.

ARALDITE® 2022-1 structural adhesive is available in cartridges designed for use with disposable 18-21 elements mixing nozzles and can be applied as a ready-to-use adhesive.

Application of adhesive

The resin/hardener mix may be applied manually or with an automated dispensing equipment to the pretreated and dry joint surfaces. A 0.002 to 0.004 in (0.05 to 0.10 mm) thick adhesive layer will normally impart the greatest lap shear strength to the joint. A proper adhesive joint design is also critical for a durable bond. The joint components should be assembled and maintained in a secure position as soon as the adhesive has been applied. For more detailed explanations regarding surface preparation and pretreatment, adhesive joint design, and the dual syringe dispensing system, visit www.araldite2000plus.com.

Equipment Maintenance

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

Cure times to reach minimum shear strength

Tested at 23°C (73°F) and 55% R. H.	
Cure time to reach lap shear strength > 145 psi (1 MPa), minutes	28
Cure time to reach lap shear strength > 1450 psi (10 MPa), minutes	30

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification.

The figures below were all determined by testing standard specimens made by lap-jointing 4.5 x 1.0 x 0.063 in (114 x 25 x 1.6 mm) strips. The bond area was 0.5 x 1.0 in (12.5 x 25 mm) in each case.

Average of 3 test specimens lap shear strength, metal-metal joints. Substrates were degreased with IPA.

Substrate	Substrates were cured at 25°C (77°F) for 24 hours and tested at 23°C (73°F),	Substrates were cured at 40°C (104°F) for 16 hours and tested at 23°C (73°F),	Test Method
	psi	psi	
Primed aluminum, 2024T3 Clad	4,440	3,680	ASTM D1002
Treated steel, RC #14	3,530	2,560	ASTM D1002
Stainless steel, V4A	3,200	3,080	ASTM D1002

Average of 3 test specimens lap shear strength, plastic-plastic joints. Substrates were lightly abraded and degreased with IPA.

Substrate	Substrates were cured at 25°C (77°F) for 24 hours and tested at 23°C (73°F),	Substrates were cured at 40°C (104°F) for 16 hours and tested at 23°C (73°F),	Test Method
	psi	psi	
ABS	480 (substrate failure)	500 (substrate failure)	ASTM D1002
PVC	820 (substrate failure)	790 (substrate failure)	ASTM D1002
PC	750 (substrate failure)	990 (substrate failure)	ASTM D1002
PMMA	570 (substrate failure)	560 (substrate failure)	ASTM D1002

Average of 3 test specimens lap shear strength on primed aluminum substrates. Substrates were degreased with IPA, cured at 40°C for 16 hours and tested at 23°C, after immersion in 23°C media.

Media	Initial, psi	30 days, psi	60 days, psi	90 days, psi	Test Method
Gasoline	3,680	3,020	3,190	2,950	ASTM D1002
10% Acetic acid	3,680	3,750	3,600	3,500	ASTM D1002
Xylene	3,680	3,360	3,420	3,190	ASTM D1002
Water	3,680	3,640	3,740	3,680	ASTM D1002

Average of 3 test specimens lap shear strength on primed aluminum substrate versus tropical weathering, 92% RH at 40°C. Substrates were degreased with IPA, cured at 40°C for 16 hours and tested at 23°C.

Initial, psi	30 days, psi	60 days, psi	90 days, psi	Test Method
3,680	3,310	3,610	3,260	ASTM D1002

Average of 3 test specimens lap shear strength on primed aluminum substrate versus temperature. Substrates were degreased with IPA and tested at different temperature.

Substrate	Substrates were cured at 25°C (77°F) for 24 hours and tested at 23°C (73°F), psi	Substrates were cured at 40°C (104°F) for 16 hours and tested at 23°C (73°F), psi	Test Method
-40°C (40°F)	3,260	3,030	ASTM D1002
23°C (73°F)	4,440	3,680	ASTM D1002
100°C (212°F)	1,500	1,070	ASTM D1002

Additional properties.

Property	Value	Test Method
T-peel, primed aluminum substrate, cured at 40°C for 16 hours, tested at 23°C, pli.	42	ASTM D1876 Rev A
Shore D hardness, sample cured at 40°C for 16 hours, tested at 23°C	81	ASTM D2240

Storage

ARALDITE® 2022-1 may be stored for 24 months at 2°C to 8°C provided the components are stored in the original sealed containers. The expiration date is indicated on the packaging.

The product may be placed at room temperature before use, the total time at room temperature should not exceed 6 months. Long term exposure above 25°C will reduce the shelf life of the product.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) 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.

First Aid!

Refer to SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

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Advanced Materials

US Technical Datasheet

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Main Offices:

Huntsman Corporation

10003 Woodloch Forest Dr
The Woodlands, TX 77380
888-564-9318

Huntsman Advanced Technology Center

8600 Gosling Rd.
The Woodlands, TX 77381
281-719-7400