

**Advanced Materials****Araldite® 2053-15****Structural Adhesives****TECHNICAL DATASHEET****Araldite® 2053-15****Two component toughened methacrylate adhesive system****Key properties**

- Excellent ageing and weathering resistance
- 15 minutes open time
- 60% Elongation at break
- Resistant to temperatures up to 100°C
- Resistant to e-coat post-cure up to 200°C
- Minimum pre-treatment needed

**Description**

Araldite® 2053-15 is a two-part toughened methacrylate adhesive designed for structural bonding. This adhesive has an open time of 15 minutes and combines a high elongation at break with an excellent resistance to ageing and weathering. It is the right choice for the transportation industry to bond metals, composites and plastics.

**Product data**

Properties	Araldite® 2053-15 A	Hardener 2053 B	Mixed adhesive
Colour	Off-white	Black	Dark grey
Specific gravity	1.04	1.2	ca. 1.1
Viscosity at 25°C (Pa.s)	ca. 100	ca. 100	non-sagging
Pot life (20 gr. at 25°C)	-	-	15 - 20 minutes
Open time	-	-	15 minutes
Lap shear strength at 25°C (A501)*	-	-	> 15 MPa
Time to peak exotherm (20gr) (A159)*	-	-	17 – 30 minutes

\* Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

**Processing****Pretreatment**

The strength and durability of a bonded joint are dependent on proper pretreatment of the surfaces to be bonded, however the methacrylate adhesives can be used effectively with little surface preparation. Ideally 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 (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.

Mix ratio	Parts by weight	Parts by volume
Araldite® 2053-15 A	100	100
Hardener 2053 B	13	10

**Application of adhesive**

This system is available in cartridges incorporating mixers and can be applied as ready to use adhesive with the aid of the tool recommended by Huntsman Advanced Materials.

The resin/hardener mix may be applied manually or robotically to the pretreated and dry joint surfaces. Huntsman's technical support group can assist the user in the selection of a suitable application method as well as suggest a variety of reputable companies that manufacture and service adhesive dispensing equipment.

A layer of adhesive 0.25 mm thick will normally impart the greatest lap shear strength to the joint. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied.

**Temperature of application:** the recommended temperature application range is 10°C to 40°C.

**Warning:** the cure reaction can generate a high amount of heat, it is not recommended to mix large amounts of material at room temperature.

For more detailed explanations regarding surface preparation and pretreatment, adhesive joint design, and the dual cartridge dispensing system, visit [www.aralditeadhesives.com](http://www.aralditeadhesives.com).

**Equipment maintenance**

All tools should be cleaned with hot water and soap before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation.

If solvents such as MEK are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

Temperature	°C	10°C	23°C	30°C	40°C
Cure time to reach	hours				
LSS > 1MPa	minutes	90	40	15	8
Cure time to reach	hours				
LSS > 10MPa	minutes	120	50	20	10

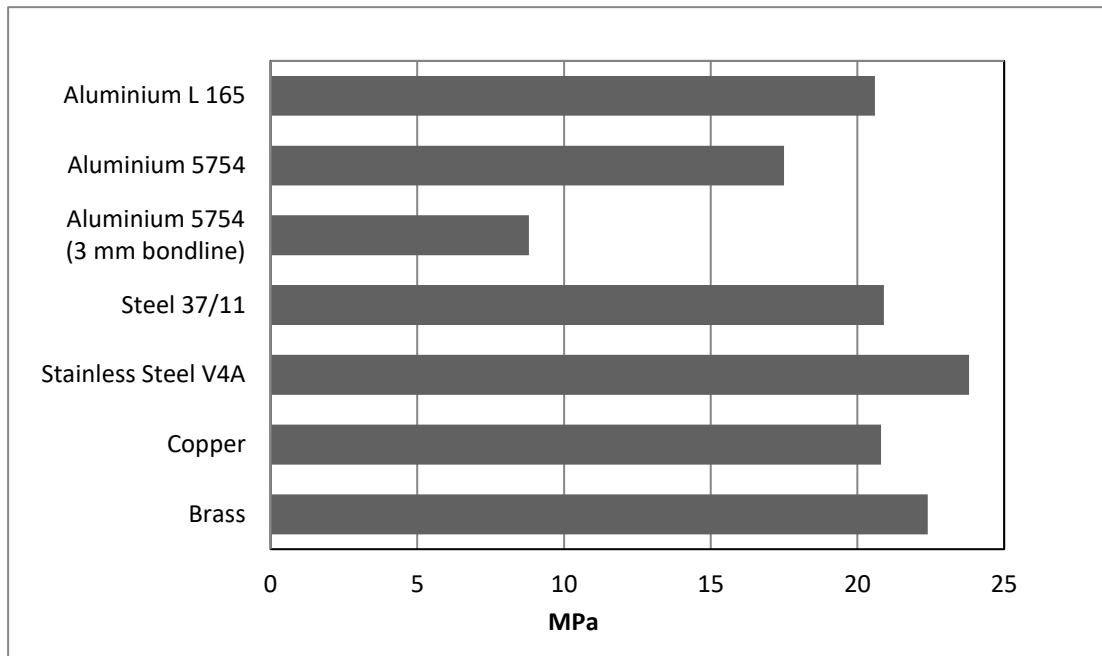
**Typical cured properties**

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.6 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

### Average lap shear strengths of typical metal-to-metal joints (ISO 4587) (typical average values)

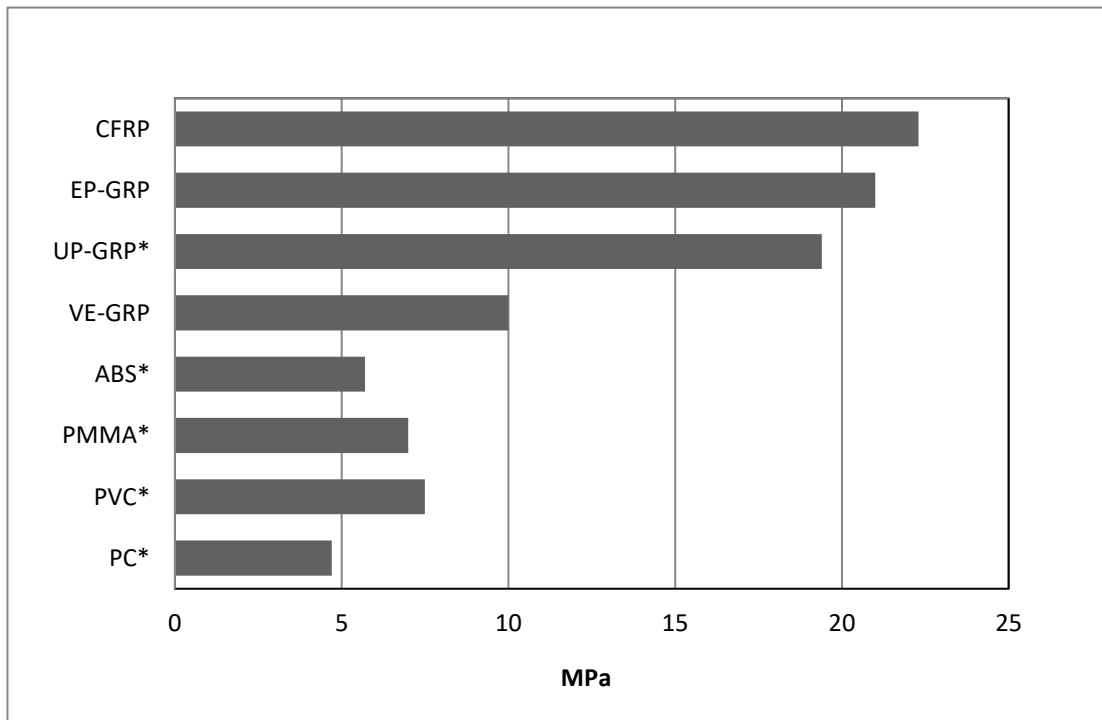
Cured for 7 days at RT and tested at 23°C. Substrates sandblasted and degreased with acetone.



Note: Araldite® 2053 is not suitable to bond galvanized steel, for this type of substrate the Araldite® 2047-1 or the Araldite® 2051 may be used.

### Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587) (typical average values)

Cured for 7 days at RT and tested at 23°C. Substrates abraded and degreased with isopropanol.



(\*): UP-GRP, ABS, PMMA, PVC, PC, substrate's failure or substrate's delamination failure observed.

### Tensile Properties (ISO 527) (Typical average values) Cure 7 days at RT and test at 23°C

Tensile Strength	19 MPa
Tensile Modulus	1000 MPa
Elongation at break	Ca. 60%

### Glass Transition Temperature (DMA) (Typical average values) Cure 7 days at RT

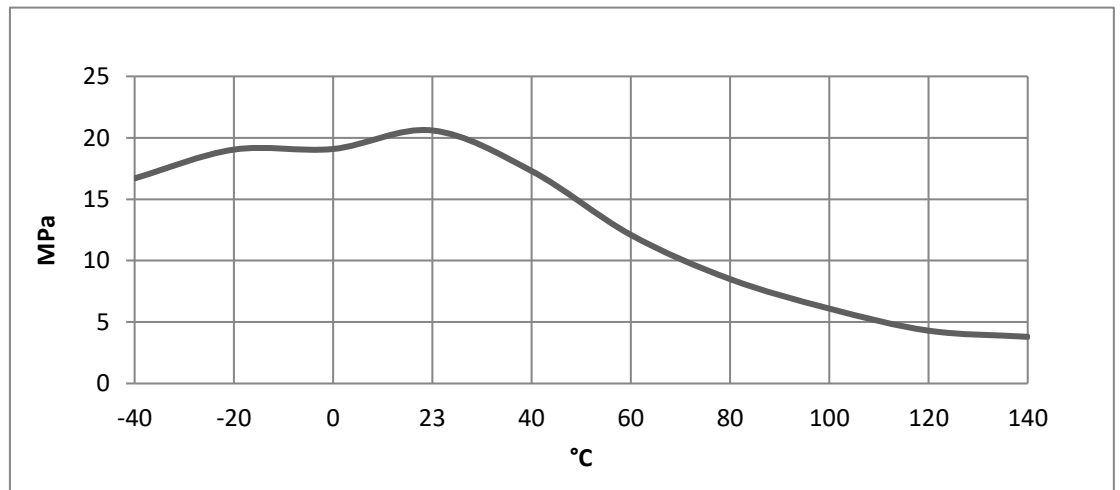
Midpoint	113°C
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### Roller Peel Strength (Typical average values) Cure 7 days at RT

Sandblasted Aluminium L165	6.5 N/mm
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### Lap shear strength versus temperature (ISO 4587) (typical average values)

Substrates sandblasted and degreased with acetone. Cure: 7 days at RT.

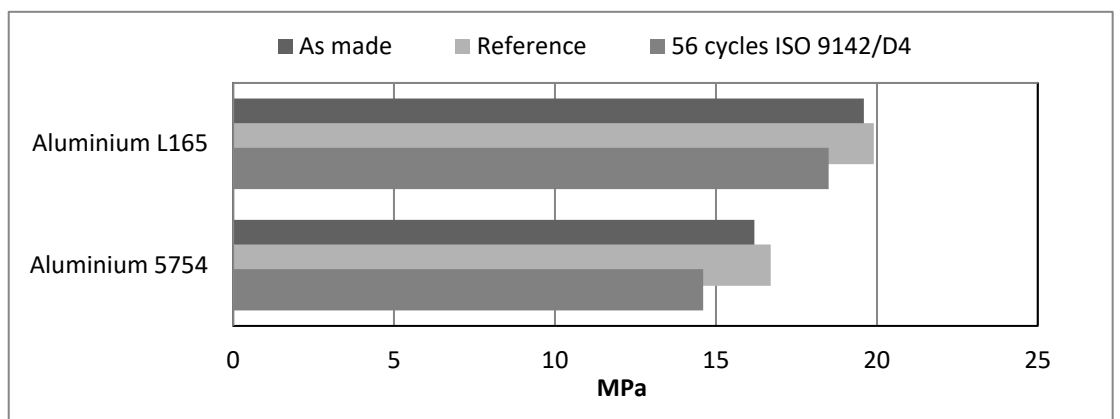


### Lap shear after cycling ageing (typical average values)

Cure: 7 days at RT. Test at 23°C. Substrates sandblasted and degreased with acetone.

Reference sample: 28 days at 23°C / 50% relative humidity.

Humid-heat and cold cycle (-40°C / 70°C 90% RH) 56 cycles (28 days) according to ISO 9142/D4

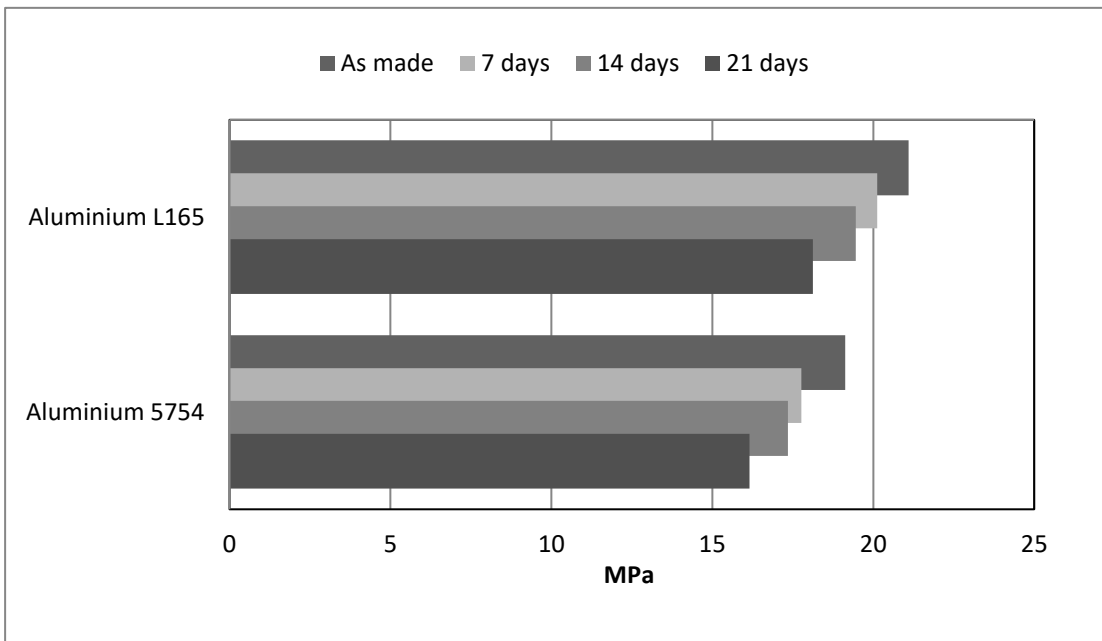


### Lap shear strength versus cataplasma ageing (typical average values)

Cure: 7 days at RT. Test at 23°C. Substrates sandblasted and degreased with acetone.

Cataplasma ageing according to ISO 9142/E2 (x days 70°C in soaked cotton / 15 hours -20°C / 24 hours recovery).

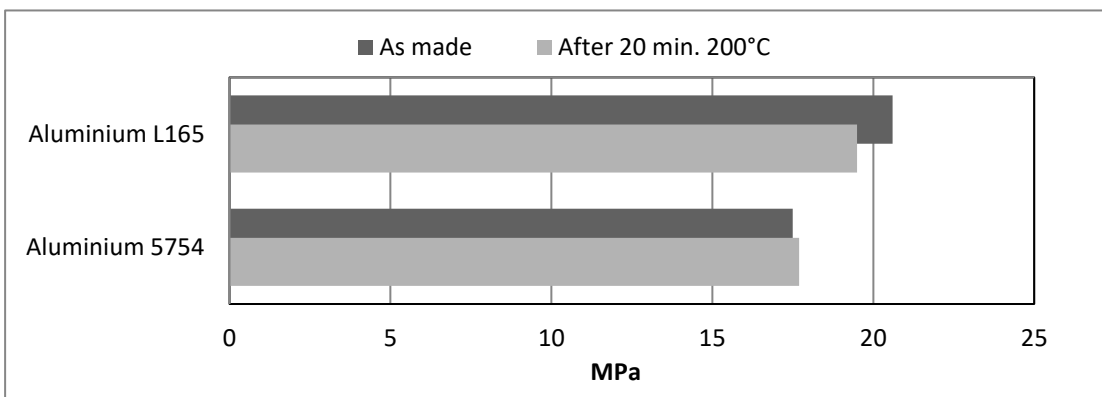
Test: at 23°C.



### Lap shear strength after coating post-cure cycle at 200°C (typical average values)

Cure: 7 days at RT. Test at 23°C. Substrates sandblasted and degreased with acetone.

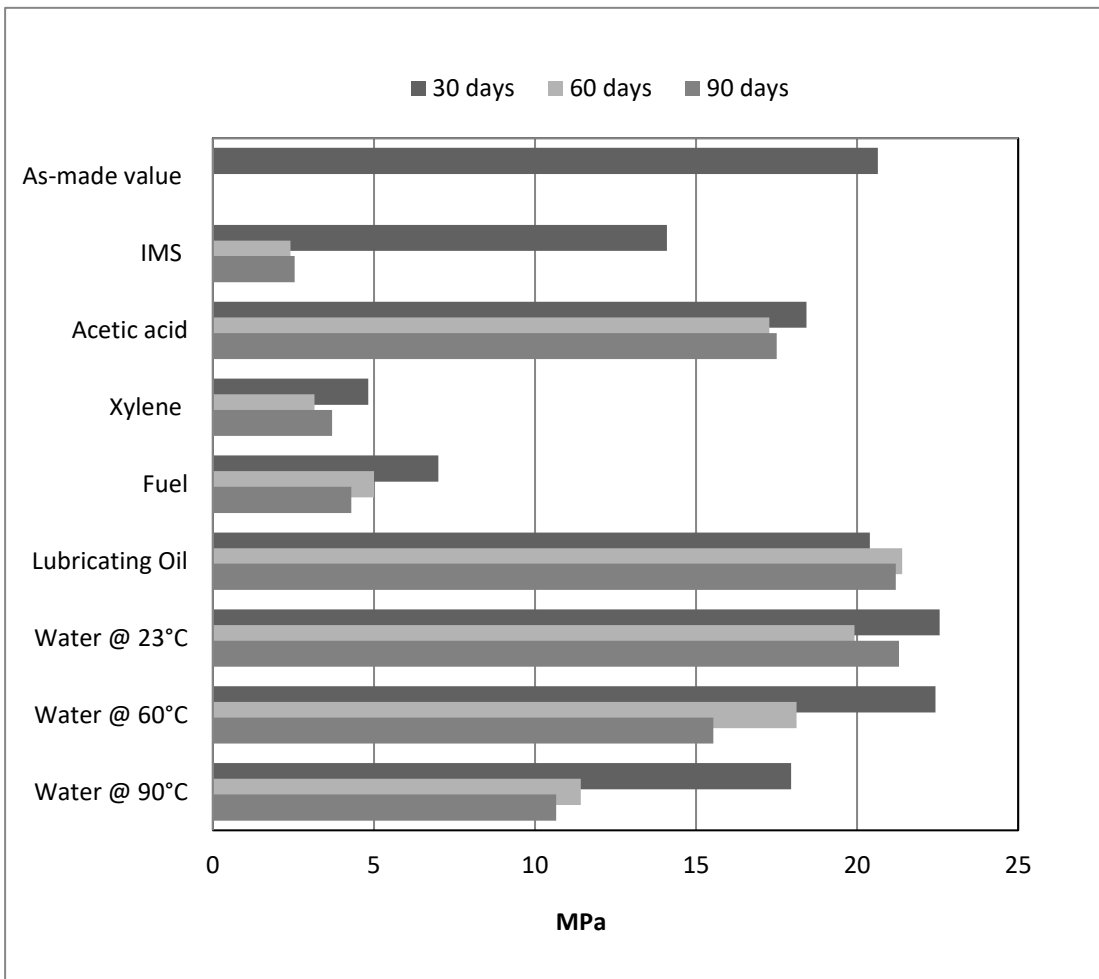
Ageing with a simulated coating post-cure cycle of 20 minutes at 200°C in an oven. Test performed at 23°C.



### Lap shear strength versus immersion in various media (ISO4587) (typical average values)

On aluminium, pretreatment: sandblasting. Cure: 7 days at RT. Tested at 23°C.

LSS was determined after immersion for 30, 60 days at 90 days at 23°C.



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**Storage**

Araldite® 2053-15 may be stored during 18 months at 2 – 8°C provided the components are stored in the original sealed containers. The expiry 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.

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**Handling precautions****Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. 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 in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents 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 the Material Safety Data sheets for the individual products and should be referred to for fuller information.



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