A total solution to high performance adhesive bonding

One stop shop technology for structural bonding of plastics

- Fully comprehensive range of structural adhesives
  - The Araldite® 2000 PLUS range is available under a broad spectrum of processing and curing conditions and can meet the most demanding performance requirements.
  - The range includes leading-edge epoxy, polyurethanes and toughened acrylic technologies providing a complete solution to structural bonding.
- Broad range of easy to use packing sizes
  - Araldite® 2000 PLUS adhesives are available in a wide range of cartridge systems and small packs for convenient handling. These options allow the user to accurately deliver a measured quantity of adhesive with minimum wastage.
- Local availability
  - No matter where you are in the world, Huntsman’s strong global network means Araldite® 2000 PLUS adhesives can be supplied locally. Our operations span 30 countries and are supported by an established worldwide distribution framework.

Setting the industry standard for technical support

- Comprehensive telephone technical support
  - Huntsman sets the standard for technical support. Its industry experts can provide advice at a local level and can rapidly respond to customer challenges.
- On site technical assistance
  - Our network of technical support staff can give on site demonstrations and provide expert advice to find the best solution for a range of technical challenges.
- Access to significant case history database
  - Sample case studies from our extensive library available on our website www.araldite2000plus.com.
- Additional reference guides available
  - Araldite® has a leading adhesive brand for 80 years and our experience is reflected in our comprehensive technical support packages which can be accessed through our website and provide a complete solution to all adhesive processing and performance needs.

All trademarks are either property of, or licensed to Huntsman Corporation or an affiliate thereof.

The Araldite® 2000 PLUS range can be used across a vast range of structural engineering applications. The Araldite® 2000 PLUS range adhesives for plastics can be used under a broad spectrum of processing and curing conditions and can meet the most demanding performance requirements. The range includes leading-edge epoxy, polyurethanes and toughened acrylic technologies providing a complete solution to structural bonding. In addition, Huntsman sets the industry standard for technical support. Its industry experts can provide advice at a local level and can rapidly respond to customer challenges. Our network of technical support staff can give on site demonstrations and provide expert advice to find the best solution for a range of technical challenges. Sample case studies from our extensive library available on our website www.araldite2000plus.com. In addition, a complete range of reference guides is available, which can be accessed through our website and provide a complete solution to all adhesive processing and performance needs.

For further information, please contact your Huntsman representative.

Ref. No. CCA Araldite2000plus_04.07_EN

Huntsman Advanced Materials

www.araldite2000plus.com
The appropriate solution for Bonding plastics to any substrates

Huntsman’s recognised expertise in research and development allows us to offer a uniquely wide range of innovative solutions, all of which are backed by strong technical support and excellent levels of customer service. Araldite® 2000 PLUS adhesives are designed to satisfy all your plastic bonding requirements.

### Processing, performance and packaging data

Araldite® 2900 PLUS is a trusted brand – with more than 60 years experience in developing engineering adhesives.

#### Processing data

<table>
<thead>
<tr>
<th>Viscosity (at 23°C)</th>
<th>30-45 Pa.s</th>
<th>Appr. 80 Pa.s</th>
<th>25-35 Pa.s</th>
<th>Thixotropic</th>
<th>Thixotropic</th>
</tr>
</thead>
<tbody>
<tr>
<td>Useable life of adhesive (at 23°C)</td>
<td>7 hr 30 min</td>
<td>20 min</td>
<td>4 hr</td>
<td>1 hr</td>
<td>1 hr</td>
</tr>
<tr>
<td>Time required to reach (at 23°C)</td>
<td>1 hr</td>
<td>4 hr 30 min</td>
<td>5 min</td>
<td>8 hr</td>
<td>6 hr</td>
</tr>
<tr>
<td>50% of final shear strength</td>
<td>8 hr</td>
<td>6 hr 30 min</td>
<td>5 min</td>
<td>8 hr</td>
<td>6 hr</td>
</tr>
<tr>
<td>50% of final shear strength (at 60°C)</td>
<td>30 min</td>
<td>1.5 hr</td>
<td>60 min</td>
<td>60 min</td>
<td>60 min</td>
</tr>
</tbody>
</table>

#### Performance data

| Lap shear strength on GRP substrate | 11 MPa | 5 MPa | 9 MPa | 8 MPa | 9 MPa | 9 MPa | 8 MPa | 8 MPa | 6 MPa | 8 MPa | 7 MPa | 8 MPa |
| Peel strength on Al substrate | 5 N/mm | 6 N/mm | 5.5 N/mm | 4 N/mm | 3 N/mm | 4 N/mm | 11 N/mm | 4 N/mm | 3 N/mm | 4 N/mm | 4 N/mm | 6 N/mm |
| Typical Tg (°C) for bonding thermoplastics | 60°C | 45°C | 80°C | 50°C | 80°C | 30°C | 60°C | 30°C | 80°C | 30°C | 80°C | 30°C |
| Resistance properties | | | | | | | | | | | | |
| Chemical | | | | | | | | | | | | |
| Heat | | | | | | | | | | | | |
| Water | | | | | | | | | | | | |
| Alcohols | | | | | | | | | | | | |
| Salts | | | | | | | | | | | | |
| Acids | | | | | | | | | | | | |

#### Packaging

- **Cartridges**
  - 50 ml
  - 200 ml
  - 400 ml
  - 500 ml

- **Working packs (2 kg kits)**
  - 2014-1
  - 2015
  - 2021
  - 2022
  - 2047*

  * Araldite® 2014-1 is only registered for use in Europe. Araldite 2014® is directly equivalent in performance to 2014-1 and is available for regions outside of Europe.

  ** Araldite® 2047 is currently only registered for use in Europe.