

**Advanced Materials****Araldite<sup>®</sup> 8595 A/B Adhesive****TWO-COMPONENT EPOXY ADHESIVE****DESCRIPTION :**

Araldite<sup>®</sup> 8595 A/B epoxy adhesive is a two-component system designed for bonding metals, including oily metals, as well as other substrates. The adhesive has 1 to 1 mix ratio for ease of use.

**APPLICATIONS :**

- Metal to metal bonding

**ADVANTAGES :**

- Bonds to oily metals
- Room temperature curing
- 1 to 1 mix ratio by volume
- Excellent flexibility

**TYPICAL PROPERTIES :**

<b>Property</b>	<b>Test Method</b>	<b>Test Values<sup>(1)</sup></b>	
		<b>Resin</b>	<b>Hardener</b>
Color/Appearance	Visual	Cream	Amber
Specific Gravity	ASTM D-792	1.23	0.94
Viscosity (cP) @ 77 °F (25 °C)	ASTM D-2393	33,000	25,000

**TYPICAL MIXED PROPERTIES :**

<b>Property</b>	<b>Test Method</b>	<b>Test Values<sup>(1)</sup></b>
Resin/Hardener Ratio (by weight)	ASTM D-2471	100/77
Resin/Hardener Ratio (by volume)		100/100
Color	Visual	Cream
Pot Life, minutes @ 77 °F (25 °C) (100 gram mass)	ASTM D-2471	60
Mixed viscosity (cP) at 77 °F (25 °C)	ASTM D-2393	21,000

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**CURE SCHEDULES :**

<u>Temperature</u>	<u>Handling Time</u>	<u>Cure Time</u>
77 °F (25 °C)	4 hours	16 hours
140 °F (60 °C)	20 minutes	1 hour
212 °F (100 °C)	5 minutes	10 minutes

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**TYPICAL CURED PROPERTIES :****Properties of Araldite® 8595 A/B**

Cured 7 days @ 77 °F (25 °C)

<u>Property</u>	<u>Test Method</u>	<u>Test Values<sup>(1)</sup></u>
Lap Shear Strength, psi (Mpa) Tested @ 77 °F (25 °C)	ASTM D-1002	2600 (17.9)
Hardness, Shore D	ASTM D-2240	70
Ultimate Tensile Properties, psi (Mpa)	ASTM D-638	2200 (15.1)
Ultimate Elongation, %	ASTM D-638	30
Tg per DMA, °F (°C)	ASTM D-4065	141 (61)
Coefficient of Thermal Expansion, in/in/°C		1.176 x 10 <sup>-4</sup>

Tested 7 days @ 77 °F (25 °C), unless otherwise noted.

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**NOTE ON TYPICAL PROPERTIES :**

These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed in establishing product specifications, please consult with our Quality Control Department.

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**STORAGE:**

Araldite® 8595 A/B epoxy adhesive should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+36°F and 104°F). Under these storage conditions, the shelf life is 3 years. The product should not be exposed to direct sunlight.

If stored below 60°F, the adhesive should be brought to 60°F – 77°F and conditioned at this temperature for some time prior to use.

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**PRECAUTIONARY STATEMENT**

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) 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 MSDS as mentioned above.

**KEEP OUT OF REACH OF CHILDREN****FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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