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## Product Data

# ARALDITE<sup>®</sup> AW 8535 Resin Hardener HW 8535 TWO-COMPONENT EPOXY ADHESIVE

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**DESCRIPTION:** Araldite AW 8535 resin/Hardener HW 8535 epoxy adhesive is a two-component paste designed for bonding metal substrates including oily metals. The system has excellent sag resistance and a 1 to 1 mix ratio by volume for ease of use.

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**APPLICATIONS:** Metal-to-metal bonding.

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**ADVANTAGES:**

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

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<b>TYPICAL PROPERTIES:</b>	<b><u>Property</u></b>	<b><u>Test Method</u></b>	<b><u>Resin</u></b>	<b>Test Values<sup>(1)</sup></b>
	Color/Appearance	Visual	Off- white	<b><u>Hardener</u></b> Dark gray
	Specific Gravity	ASTM D-792	1.43	1.10
	Viscosity (cP) @ 77°F (25°C)	ASTM D-2393	Paste	Paste

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<b>TYPICAL MIXED PROPERTIES:</b>	<b><u>Property</u></b>	<b><u>Test Method</u></b>	<b>Test Values<sup>(1)</sup></b>
	Resin/Hardener Ratio (by weight)	ASTM D-2471	100/75
	Resin/Hardener Ratio (by volume)		100/100
	Color	Visual	Gray
	Pot Life, min. @ 77°F (25°C), 100 gram mass	ASTM D-2471	60
	Sag Resistance in (mm), (0.25 inch/6mm bead. Vertical. 30 min. @ 320°F/160°C)		<0.39 (10)
Mixed Viscosity (cP) @ 77°F (25°C)	ASTM D-2393	Paste	

Tested 7 days @ 77°F (25°C)

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<b>CURE SCHEDULES:</b>	<b><u>Temperature</u></b>	<b><u>Handling Time</u></b>	<b><u>Minimum Cure Time</u></b>
	77°F (25°C)	5.5 hrs.	16 hrs.
	140°F (60°C)	20 minutes	1 hr.
	212°F (100°C)	5 minutes	10 minutes

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**TYPICAL CURED PROPERTIES:** **Properties of AW-8535/ HW-8535 Epoxy Adhesive**

Cured 7 days @ 77°F (25°C)

<b><u>Property</u></b>	<b><u>Test Method</u></b>	<b><u>psi</u></b>	<b><u>MPa</u></b>
Lap Shear Strength, psi (MPa)	ASTM D-1002		
Tested @ 77°F (25°C)		2500	17
@ 179°F (82°C)		890	6
Hardness, Shore D	ASTM D-2240	75	
Ultimate Tensile Properties, psi (MPa)	ASTM D-638	2290	16
Ultimate Elongation, %	ASTM D-638	29	
Tg per DMA, °F (°C)	ASTM D-4065	190 (88)	
Coefficient of Thermal Expansion (in/in/°F)	ASTM D-3386	14.00 x 10 <sup>-5</sup>	

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

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**Note : 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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## CAUTION:

Huntsman Advanced Materials Americas Inc. 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. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to [adhesives\\_group@huntsman.com](mailto:adhesives_group@huntsman.com).

## FIRST AID!

Eyes and skin: Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.

Inhalation: Remove subject to fresh air.

Swallowing: Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

## KEEP OUT OF REACH OF CHILDREN

## FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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