

Araldite[®] KIT K 267

Araldite [®] KIT K 267	Part A	100	pbv	100	pbw
Araldite [®] KIT K 267	Part B	100	pbv	100	pbw

Araldite[®] KIT K 267 is a two-part, specially formulated paste based on an Araldite[®] epoxy resin and hardener.

Application

It is particularly recommended for applications requiring a tough, abrasion resistant surface with excellent impact strength and adhesion

Processing methods

Manual mixing.

Key Properties

Easy to mix and apply
Gap filling and sag resistant
Pre-filled, solvent free
Excellent adhesion to properly prepared surfaces
Cures to a tough, abrasion resistant surface
Excellent impact strength

Product Data (Guideline Values)

Araldite® Kit K 267

		Resin	Hardener
Form		Paste	Paste
Colour		Grey	Grey Black
Flash Point	DIN 51758	235 °C	100 °C
Density At 25°C	g/cm ³	1.37 – 1.47	1.46 – 1.56

Processing Data (Guideline Values)

Mix Ratio

		Parts by weight	Parts by volume
Araldite® Kit K 267	Part A	100	100
Araldite® Kit K 267	Part B	100	100

Gel Time, Viscosity and Curing

Usable Life (1 litre)	at 15°C		70 - 90 minutes
	at 25°C		35 - 40 minutes
	at 35°C		15 - 25 minutes
Minimum Cure Temperature	15°C		
Minimum Cure Time	at 15°C	ISO 291	36 - 48 hours
	at 25°C	ISO 291	18 - 24 hours
	at 35°C	ISO 291	9 - 12 hours

Processing and Storage (Guideline Values)

Surface Preparation

Complete durable adhesion can only be achieved if the surfaces to be bonded are properly pretreated. In all cases, except for concrete, the following pretreatment procedure should be followed:

Degrease, abrade and degrease again.

DEGREASING: The removal of all traces of dirt, oil and grease can be achieved by using a solvent such as EPOSOLVE 70 (Huntsman Advanced Materials). Concrete should be degreased by washing with a strong detergent solution.

ABRASING: Grit blasting is the ideal pretreatment for metallic and non-metallic surfaces. If grit blasting is impractical or cannot be carried out, alternative pretreatments include abrading thoroughly with a grinder, needle gun, scabblor, emery cloth or similar.

CAUTION: Eposolve 70 contains Toluene and should only be used in well ventilated areas. Avoid direct skin contact. For further information, refer to the specific instruction sheet and Material Safety Data Sheet.

Mixing

Blend by trowel on a flat board until the mix is a streakless, uniform grey colour. Mechanical mixers may be used, but the sides and bottom of the mixing container must be checked for unmixed material before use. Avoid excessive aeration of the mix.

Mixing should be completed within five minutes, and the mix then applied to the job as quickly as possible.

Curing

To determine whether crosslinking has been carried to completion and the final properties are optimal, it is necessary to carry out relevant measurements on the actual object or to measure the glass transition temperature. Different gel and cure cycles in the customer's manufacturing process could lead to a different degree of crosslinking and thus a different glass transition temperature.

Storage Conditions

Store the components in a dry place at RT, in tightly sealed original containers. Under these conditions, the shelf life will correspond to the expiry date stated on the label. After this date, the product may be processed only after reanalysis. Partly emptied containers should be tightly closed immediately after use.

For information on waste disposal and hazardous products of decomposition in the event of a fire, refer to the Material Safety Data Sheets (MSDS) for these particular products.

Mechanical and Physical Properties (Guideline Values)

Determined on standard test specimen at 23°C. Cured for 24h/RT + 6h/80°C

Maximum Operating Temperature		DSC 7	65°C
Density	g/cm ³		1.5 - 1.6
Tensile Strength	N/mm ²	ISO 527	30 - 40
Tensile Shear Strength	N/mm ²	ISO 4587	9 - 13
Compressive Strength	N/mm ²	ISO 604	100 - 122
Flexural Strength	N/mm ²	ISO 178	17 - 18
Modulus of Elasticity	N/mm ²	ISO 178	(2.0- 2.2) x 10 ³
Coefficient of Linear Thermal Expansion	mm/°C	ASTM D 3386	(40 - 60) x 10 ⁻⁶
Water Absorption	10 days at 25°C	ISO 62	0.5-0.8% by weight

(1N/mm² = 1 MPa = 145 psi)

Industrial hygiene

Mandatory and recommended industrial hygiene procedures should be followed whenever our products are being handled and processed. For additional information please consult the corresponding Safety Data Sheets and the brochure "Hygienic precautions for handling plastics products".

Handling Precautions

Safety precautions at workplace:

protective clothing

Yes.

gloves

Essential.

arm protectors

Recommended when skin contact likely.

goggles/safety glasses

Yes.

respirator/dust mask

Recommended.

Skin protection:

before starting work

Apply barrier cream to exposed skin.

after washing

Apply barrier or nourishing cream.

Cleaning of contaminated skin

Dab off with absorbent paper, wash with warm water and alkali-free soap, then dry with disposable towels. Do not use solvents.

Clean shop requirements

Cover workbenches, etc. with light coloured paper. Use disposable beakers, etc.

Disposal of spillage

Soak up with sawdust or cotton waste and

Ventilation:

deposit in plastic-lined bin.

of workshop

Renew air 3 to 5 times an hour.

of workplace

Exhaust fans. Operatives should avoid inhaling vapors.

First Aid

Contamination of the **eyes** by resin, hardener or casting mix should be treated immediately by flushing with clean, running water for 10 to 15 minutes. A doctor should then be consulted.

Material smeared or splashed on the **skin** should be dabbed off, and the contaminated area then washed and treated with a cleansing cream (see above). A doctor should be consulted in the event of severe irritation or burns. Contaminated clothing should be changed immediately.

For more detailed information please read Huntsman Advanced Material safety data sheets for the individual products.

Note

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