

Advanced Materials**Araldite® LY 5052 / Aradur® 5052*****COLD CURING EPOXY SYSTEMS**

Araldite® LY 5052 is a low viscosity epoxy resin

Aradur® 5052 is a mixture of polyamines

| | | | |
|---------------------|---|--------------|----------------------|
| APPLICATIONS | Aerospace and industrial composites, tooling, aircraft repair. | | |
| PROPERTIES | <ul style="list-style-type: none"> • Low viscosity, easy impregnation of reinforcement materials. • Long potlife (2 hours for 100 ml at ambient), ample processing time allows production of big objects. • High temperature resistance (glass transition temperature) after ambient cure: 60 °C, after post-cure at 100:120 °C. • Excellent mechanical and dynamic properties after ambient cure with potential for even higher properties after post-cure at elevated temperatures. • Also laminates show outstanding mechanical and dynamic properties. This system is qualified by the Luftfahrtbundesamt (German Aircraft Authority) for the production of gliders. <p>Adequate skin protection is indispensable.</p> | | |
| PROCESSING | <ul style="list-style-type: none"> • Wet lay-up • Resin Transfer Moulding (RTM) • Pressure Moulding • Filament Winding | | |
| KEY DATA | Araldite® LY 5052 | | |
| | Aspect (visual) | clear liquid | |
| | Colour (Gardner, ISO 4630) | ≤ 2 | |
| | Viscosity at 25 °C (ISO 12058-1) | 1000 - 1500 | [mPa s] |
| | Density at 25 °C (ISO 1675) | 1.17 | [g/cm ³] |
| | Flash point (ISO 2719) | ≥ 140 | [°C] |
| | Storage temperature (see expiry date on original container) | 2 - 40 | [°C] |
| | Aradur® 5052 | | |
| | Aspect (visual) | clear liquid | |
| | Colour (Gardner, ISO 4630) | ≤ 4 | |
| | Viscosity at 25 °C (ISO 12058-1) | 40 - 60 | [mPa s] |
| | Density at 25 °C (ISO 1675) | 0.94 | [g/cm ³] |
| | Flash point (ISO 2719) | ≥ 110 | [°C] |
| | Storage temperature (see expiry date on original container) | 2 - 40 | [°C] |
| STORAGE | <p>Provided that the products described above are stored in a dry place in their original, properly closed containers at the above mentioned storage temperatures they will have the shelf lives indicated on the labels.</p> <p>Partly emptied containers should be closed immediately after use.</p> | | |

* In addition to the brand name product denomination may show different appendices, which allows us to differentiate between our production sites: e.g., BD = Germany, US = United States, IN = India, CI = China, etc.. These appendices are in use on packaging, transport and invoicing documents. Generally the same specifications apply for all versions. Please address any additional need for clarification to the appropriate Huntsman contact.

PROCESSING DATA

| MIX RATIO | Components | Parts by weight | Parts by volume |
|-----------|-------------------|-----------------|-----------------|
| | Araldite® LY 5052 | 100 | 100 |
| | Aradur® 5052 | 38 | 47 |

The components must be weighed accurately and mixed thoroughly to obtain optimal properties. The sides and bottom of mixing vessels must be included in the mixing process. Large mix quantities will show considerable exotherm, leading to short potlives. Preferably mix smaller quantities or divide large mixes into smaller containers.

| INITIAL MIX VISCOSITY (ISO 12058-1) | [°C] | [mPa s] |
|--|-------|-------------|
| | at 18 | 1150 - 1350 |
| | at 25 | 500 - 700 |
| | at 40 | 200 - 250 |

| VISCOSITY BUILD-UP (ISO 12058-1) | [°C] | [mPa s] | [min] |
|-------------------------------------|-------|---------|----------|
| | at 25 | to 1500 | 50 - 60 |
| | at 25 | to 3000 | 90 - 110 |
| | at 40 | to 1500 | 40 - 45 |
| | at 40 | to 3000 | 50 - 60 |
| | at 60 | to 1500 | 15 - 18 |
| | at 60 | to 3000 | 18 - 22 |

| POT LIFE (TECAM, 100 ML, 65 % RH) LONG POTLIFE MEANS AMPLE TIME TO PRODUCE EVEN BIG OBJECTS. | [°C] | [min] |
|--|-------|-----------|
| | at 18 | 280 - 320 |
| | at 25 | 110 - 160 |
| | at 40 | 45 - 55 |

| GEL TIME (HOT PLATE) | [°C] | [min] |
|-------------------------|--------|-----------|
| | at 25 | 420 - 500 |
| | at 40 | 150 - 170 |
| | at 60 | 40 - 55 |
| | at 80 | 14 - 17 |
| | at 100 | 4 - 6 |
| | at 120 | 2 - 3 |

The values shown are for small amounts of pure resin/hardener mix. In practice, fibre content and laminate thickness may modify the gel time to a very significant extent. In composite structures the gel time can differ significantly from the given values depending on the fibre content and the laminate thickness.

| GELATION AT 23 °C (IN THIN LAYERS: 0.4 - 0.7 MM) | Start | [h] |
|--|-------|---------|
| | End | 5 - 6.5 |
| | | 7 - 8 |

| TYPICAL CURE CYCLES | 1 day 23 °C + 15 h 50 °C or 1 day 23 °C + 4 h 100 °C |
|---------------------|---|
|---------------------|---|

The optimum cure cycle has to be determined case by case, depending on the processing and the economic requirements.

PROPERTIES OF THE CURED, NEAT FORMULATION

| GLASS TRANSITION TEMPERATURE (IEC 1006, DSC, 10 K/MIN) | Cure: | T_G onset [°C] | T_G [°C] |
|---|-----------|------------------|------------|
| | | 2 days 25 °C | 50 - 52 |
| 8 days 25 °C | 60 - 64 | 62 - 66 | |
| 4 month 23 °C | 64 - 68 | 67 - 71 | |
| 1 day 23 °C + 10 h 40 °C | 68 - 72 | 70 - 76 | |
| 1 day 23 °C + 20 h 40 °C | 72 - 76 | 74 - 80 | |
| 1 day 23 °C + 10 h 50 °C | 78 - 82 | 80 - 85 | |
| 1 day 23 °C + 15 h 50 °C | 81 - 85 | 82 - 88 | |
| 1 day 23 °C + 10 h 60 °C | 92 - 96 | 94 - 104 | |
| 1 day 23 °C + 15 h 60 °C | 94 - 98 | 96 - 106 | |
| 1 day 23 °C + 2 h 80 °C | 106 - 110 | 108 - 114 | |
| 1 day 23 °C + 8 h 80 °C | 112 - 116 | 114 - 122 | |
| 1 day 23 °C + 1 h 90 °C | 104 - 108 | 108 - 118 | |
| 1 day 23 °C + 4 h 90 °C | 112 - 116 | 116 - 126 | |
| 1 day 23 °C + 1 h 100 °C | 116 - 120 | 118 - 130 | |
| 1 day 23 °C + 4 h 100 °C | 118 - 124 | 120 - 134 | |

Even if post-cured at elevated temperature after a prolonged cure at ambient, a good increase of the glass transition temperature is obtained as follows :

| | | |
|-----------------------------|-----------|-----------|
| 4 months 23 °C + 4 h 130 °C | 106 - 112 | 120 - 132 |
|-----------------------------|-----------|-----------|

The maximum attainable glass – transition temperature for this system is in the range of 130 °C

| TENSILE TEST (ISO 527) | Cure: | 7 days RT | 15 h 50 °C | 8 h 80 °C |
|------------------------------------|-------|------------------------|-------------|-------------|
| | | Tensile strength [MPa] | 49 - 71 | 82 - 86 |
| Elongation at tensile strength [%] | | 1.5 - 2.5 | 3.1 - 3.7 | 5.7 - 5.9 |
| Ultimate strength [MPa] | | 49 - 71 | 80 - 83 | 80 - 84 |
| Ultimate elongation [%] | | 1.5 - 2.5 | 3.5 - 5.5 | 7.0 - 8.5 |
| Tensile modulus [MPa] | | 3350 - 3550 | 3450 - 3650 | 3000 - 3200 |

| FLEXURAL TEST (ISO 178) | Cure: | 15 h 50 °C | 8 h 80 °C |
|-------------------------------------|-------|-------------------------|-------------|
| | | Flexural strength [MPa] | 130 - 140 |
| Elongation at flexural strength [%] | | 5.8 - 6.3 | 6.5 - 7.2 |
| Ultimate strength [MPa] | | 90 - 115 | 87 - 113 |
| Ultimate elongation [%] | | 8.0 - 9.5 | 8.5 - 13.4 |
| Flexural modulus [MPa] | | 3000 - 3300 | 2700 - 3000 |

| FRACTURE PROPERTIES BEND NOTCH TEST (PM 258-0/90) | Cure: | 8 h 80 °C |
|--|-----------|-------------------------------------|
| | | Fracture toughness K_{1C} [MPa√m] |
| Fracture energy G_{1C} [J/m ²] | 192 - 212 | |

| WATER ABSORPTION (ISO 62) | Immersion: | Cure: | 7 days RT | 8 h 80 °C |
|------------------------------------|------------|-------------|-----------------------------------|-------------|
| | | | 4 days H ₂ O 23 °C [%] | 0.45 - 0.50 |
| 10 days H ₂ O 23 °C [%] | | 0.70 - 0.80 | 0.65 - 0.70 | |
| 30 min H ₂ O 100 °C [%] | | 0.55 - 0.60 | 0.45 - 0.50 | |
| 60 min H ₂ O 100 °C [%] | | 0.70 - 0.80 | 0.60 - 0.70 | |

| COEFFICIENT OF LINEAR THERMAL EXPANSION (DIN 53 752) | Mean value: | Cure: | 7 d RT | 15 h 50 °C | 8 h 80 °C |
|---|-------------|-------|--|------------|-----------|
| | | | α from 20 - 50 °C [10 ⁻⁶ /K] | 97 | - |
| α from 20 - 90 °C [10 ⁻⁶ /K] | | - | 71 | - | |
| α from 20 - 120 °C [10 ⁻⁶ /K] | | - | - | 71 | |

POISONS'S RATIO [] 0.35

PROPERTIES OF THE CURED, REINFORCED FORMULATION

FLEXURAL TEST Samples:
(ISO 178) 16 layers (4 mm) E-glass fabric 1:1, 280-300 g/m²
Fibre volume content: 45 - 46 %
Cure: 10 h 80 °C

| | | | <i>Unconditioned</i> |
|---------------------------------|-------|--|----------------------|
| Flexural strength | [MPa] | | 440 - 490 |
| Elongation at flexural strength | [%] | | 2.7 - 3.0 |
| Ultimate strength | [MPa] | | 420 - 460 |
| Ultimate elongation | [%] | | 2.9 - 3.2 |
| Flexural modulus | [MPa] | | 20000 - 22000 |

After 30 days in H₂O 23 °C

| | | | |
|---------------------------------|-------|--|---------------|
| Flexural strength | [MPa] | | 380 - 400 |
| Elongation at flexural strength | [%] | | 2.7 - 3.0 |
| Ultimate strength | [MPa] | | 340 - 370 |
| Ultimate elongation | [%] | | 1.9 - 3.4 |
| Flexural modulus | [MPa] | | 19000 - 21000 |

TENSILE TEST Samples:
(ISO 527) 16 layers (4 mm) E-glass fabric 1:1, 280-300 g/m²
Fibre volume content : 45 - 46 %
Cure: 10 h 80 °C

| | | | |
|---------------------|-------|--|---------------|
| Tensile strength | [MPa] | | 360 - 390 |
| Ultimate elongation | [%] | | 1.6 - 1.9 |
| Tensile modulus | [MPa] | | 33100 - 39100 |

INTERLAMINAR SHEAR STRENGTH Short beam: E-glass unidirectional specimen, thickness t = 3.2 mm
(ASTM D 2344) Fibre volume content: 60 %

| | <i>Cure:</i> | <i>7 days RT</i> | <i>8 h 80 °C</i> |
|--------------------------------------|--------------|------------------|------------------|
| Unconditioned | [MPa] | 57 - 61 | 60 - 65 |
| After 1 h in H ₂ O 100 °C | [MPa] | 55 - 60 | 58 - 62 |

HANDLING PRECAUTIONS

Personal hygiene

Safety precautions at workplace

| | |
|------------------------|--------------------------------------|
| protective clothing | yes |
| gloves | essential |
| arm protectors | recommended when skin contact likely |
| goggles/safety glasses | yes |

Skin protection

| | |
|----------------------|-------------------------------------|
| before starting work | Apply barrier cream to exposed skin |
| after washing | Apply barrier or nourishing cream |

Cleansing 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

Disposal of spillage

Soak up with sawdust or cotton waste and deposit in plastic-lined bin

Ventilation

of workshop

Renew air 3 to 5 times an hour

of workplaces

Exhaust fans. Operatives should avoid inhaling vapours

FIRST AID

Contamination of the eyes by resin, hardener or 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.

Anyone taken ill after *inhaling* vapours should be moved out of doors immediately.

In all cases of doubt call for medical assistance.

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