



Cold-curing epoxy system based on Araldite[®] LY 5052* / Aradur[®] 5052*

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	<p>Araldite LY 5052</p> <table border="1"> <tr> <td>Aspect (visual)</td> <td>clear liquid</td> <td></td> </tr> <tr> <td>Colour (Gardner, ISO 4630)</td> <td>≤ 2</td> <td></td> </tr> <tr> <td>Viscosity at 25 °C (ISO 12058-1)</td> <td>1000 - 1500</td> <td>[mPa s]</td> </tr> <tr> <td>Density at 25 °C (ISO 1675)</td> <td>1.17</td> <td>[g/cm³]</td> </tr> <tr> <td>Flash point (ISO 2719)</td> <td>≥ 140</td> <td>[°C]</td> </tr> <tr> <td>Storage temperature (see expiry date on original container)</td> <td>2 - 40</td> <td>[°C]</td> </tr> </table> <p>Aradur 5052</p> <table border="1"> <tr> <td>Aspect (visual)</td> <td>clear liquid</td> <td></td> </tr> <tr> <td>Colour (Gardner, ISO 4630)</td> <td>≤ 4</td> <td></td> </tr> <tr> <td>Viscosity at 25 °C (ISO 12058-1)</td> <td>40 - 60</td> <td>[mPa s]</td> </tr> <tr> <td>Density at 25 °C (ISO 1675)</td> <td>0.94</td> <td>[g/cm³]</td> </tr> <tr> <td>Flash point (ISO 2719)</td> <td>≥ 110</td> <td>[°C]</td> </tr> <tr> <td>Storage temperature (see expiry date on original container)</td> <td>2 - 40</td> <td>[°C]</td> </tr> </table>			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]	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]
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]																																					
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	<i>Components</i>	<i>Parts by weight</i>	<i>Parts by volume</i>
	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)	<i>[°C]</i>	<i>[mPa s]</i>
	at 18	1150 - 1350
	at 25	500 - 700
	at 40	200 - 250

Viscosity build-up (ISO 12058-1)	<i>[°C]</i>	<i>[mPa s]</i>	<i>[min]</i>
	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.	<i>[°C]</i>	<i>[min]</i>
	at 18	280 - 320
	at 25	110 - 160
	at 40	45 - 55

Gel time (Hot plate)	<i>[°C]</i>	<i>[min]</i>
	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)		<i>[h]</i>
	Start	5 - 6.5
	End	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)	<i>Cure:</i>	T_G onset [°C]	T_G [°C]
	2 days 25 °C	50 - 52	52 - 55
	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 <u>after</u> 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)	<i>Cure:</i>	7 days RT	15 h 50 °C	8 h 80 °C	
Tensile strength [MPa]		49 - 71	82 - 86	84 - 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)	<i>Cure:</i>	15 h 50 °C	8 h 80 °C		
Flexural strength [MPa]		130 - 140	116 - 122		
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	<i>Cure:</i>		8 h 80 °C		
Bend notch test (PM 258-0/90)	Fracture toughness K_{1C} [MPa√m]			0.77-0.83	
	Fracture energy G_{1C} [J/m ²]			192 - 212	
Water absorption (ISO 62)	<i>Immersion:</i>	<i>Cure:</i>	7 days RT	8 h 80 °C	
	4 days H ₂ O 23 °C [%]		0.45 - 0.50	0.40 - 0.45	
	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)	<i>Mean value:</i>	<i>Cure:</i>	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
Poissons'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/m ² 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	
			<i>After 30 days in H₂O 23 °C</i>	
	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/m ² 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 Mandatory and recommended industrial hygiene procedures should be followed whenever our products are being handled and processed. For additional information please consult the corresponding product safety data sheets and the brochure "Hygienic precautions for handling plastics products".

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.

Note

Araldite® and Aradur® are registered trademarks of Huntsman LLC or an affiliate thereof in one or more countries, but not all countries.

Huntsman LLC
®Registered trademark



IMPORTANT: The following supersedes Buyer's documents. SELLER MAKES NO REPRESENTATION OR WARRANTY, EXPRESS OR IMPLIED, INCLUDING OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. No statements herein are to be construed as inducements to infringe any relevant patent. Under no circumstances shall Seller be liable for incidental, consequential or indirect damages for alleged negligence, breach of warranty, strict liability, tort or contract arising in connection with the product(s). Buyer's sole remedy and Seller's sole liability for any claims shall be Buyer's purchase price. Data and results are based on controlled or lab work and must be confirmed by Buyer by testing for its intended conditions of use. The product(s) has not been tested for, and is therefore not recommended for, uses for which prolonged contact with mucous membranes, abraded skin, or blood is intended; or for uses for which implantation within the human body is intended.