



Araldite®

Brake & Clutch Bonding

HUNTSMAN

Araldite Brake Bonding - Core Range

Typical Properties

Product	Solid content (weight)	Colour	Application method	Solvent
Brake bonding dip coats				
Araldite 70	38-44%	Clear brown	D,Sp	Ethanol
XD 5005	9-11%	Clear brown	D,Sp	Ethanol
XD 5006	16.5-19%	Translucent brown	D,Sp	Xylene and Butyl alcohol
XD 5009	13-16%	Black	D	Isopropanol/Ethyl Acetate
Brake bonding shoe adhesives				
Araldite 71	47-51%	Dark brown	Ex, Rc	Ethanol
XD 5001	39-43%	Clear brown	Rc, Br, Sp	Ethanol/Acetone
Brake bonding pad adhesives				
Araldite 64 - 1	39-44%	Clear brown	Sp, Br, Rc	Ethanol/Toluene
Araldite water based brake bonding adhesives (brake shoes & brake pads)				
XD 5004 - 1	39-43%	Black	Rc	Water

Processing Characteristics

Product	Drying time		*Curing schedule		Curing time
	(at 23°C)	(at 70°C)	Pressure (MPa)	Temp (°C)	
Brake bonding dip coats					
Araldite 70	20 mins	5 mins	N/A	200	5 min
XD 5005	15 mins	5 mins	N/A	200	5 min
XD 5006	60 mins	10 mins	N/A	200	5 min
XD 5009	30 mins	10 mins	N/A	200	5 min
Brake bonding shoe adhesives					
Araldite 71	8 - 10 hrs	25 mins	0.35 - 1	200	5 min
XD 5001	2 - 4 hrs	5 mins	0.35 - 1	200	5 min
Brake bonding pad adhesives					
Araldite 64 - 1	6 hrs	25 mins	0.35 - 1	200	5 min
Araldite water based brake bonding adhesives (brake shoes & brake pads)					
XD 5004 - 1	4 - 8 hrs	15 mins	0.35 - 1	180	10 min

Key

D - Dip
Rc - Roller coat
Sp - Spray
Ex - Extruder
Br - Brush
N/A - Not applicable

*Note:
Range of cure times and temperatures possible.
Refer to relevant product data sheets.

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Handling Precautions**Caution**

Huntsman Advanced Materials are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils, and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary, likewise the use of eye protection. The skin should be thoroughly cleansed the end of each working period by washing with soap and warm water. The use of solvents should be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. The work area should be well ventilated. The precautions are described in greater detail in Manual No 24264/e *Hygienic Precautions for Handling Plastic Products* and in the Material Safety Data Sheets for the Individual products. These publications are available on request and should be referred to for further information.

All recommendations for use of our products, whether given by us in writing, verbally, or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefore. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.

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.

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