

Advanced Materials

Araldite® 403 A/B

Aerospace Adhesives

TECHNICAL DATA SHEET

Key properties

- Two component epoxy adhesive
- Cold cured system
- Can be used in conjunction with riveting
- Good strength retention up to 120°C

Description

Araldite® 403 A/B is a two pack cold curing structural adhesive system developed primarily for use in riveted joints to give improved fatigue resistance. It also gives other benefits of bonded assembly to structural joints which cannot be bonded with hot cured adhesives because of their size or other physical limitations. It is also suitable for honeycomb-to-skin bonding.

Product data

Property	Araldite® 403 A	Araldite® 403 B	Mixed adhesive
Colour (visual) (A112)*	grey	blue	grey
Specific gravity	1.3 - 1.4	0.8 - 0.9	1.5 - 1.6
Viscosity at 25 °C (Pas) (A093)*	1200 - 2700	0.01 - 0.02	ca. 150
Lapshear strength (MPa) at 23°C (A501)*			>17.9
Pot life / 100g at 25°C (min)	-	-	60 – 90

* Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

Processing

Pretreatment

The strength and durability of a bonded joint are dependent on proper treatment of the surfaces to be bonded.

At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt. Alcohol, gasoline (petrol) or paint thinners should never be used.

The strongest and most durable joints are obtained by either mechanically abrading or chemically etching ("pickling") the degreased surfaces.

Abrading should be followed by a second degreasing treatment.

Mix ratio	Parts by weight	Parts by volume
Araldite® 403 A	100	-
Araldite® 403 B	7.5	-

The resin and hardener should be blended until they form a homogeneous mix

Pot life

To obtain the maximum workable life after mixing, pour the adhesive into a shallow tray to a maximum depth of about 6mm. This will assist rapid dissipation of heat generation by exothermic reaction.

The workable life will then be approximately 1½ hours at 25°C. This will be reduced at higher temperatures, or may be increased by maintaining a lower temperature.

Application of adhesive

Araldite® 403 may be applied by extrusion or by spreading with a roller or serrated comb spreader.

Apply a thin coating of the adhesive to each surface of the joint; for honeycomb-to-skin bonds apply the adhesive to the honeycomb surface and to the skins.

Assembly

The joint assembly must be completed and securely clamped or tack riveted within 2 hours of mixing the adhesive.

Araldite® 403 has excellent gap-filling properties and is tolerant of glue-line thickness variations over the range 0.08 - 0.80mm.

Riveting

Araldite® 403 does not appear to be sensitive to riveting operations, but there is a risk that the joint may be disturbed if the assembly is moved during the most critical part of the adhesive curing period. All riveting should be done before the adhesive has set or after it has hardened sufficiently to withstand normal handling.

Unless the assembly is rigidly clamped in a jig to prevent movement, riveting should not be done during the 6 hours immediately following adhesive application; alternatively, the assembly should be left undisturbed for at least 24 hours after clamping or tack riveting before further work is carried out on it.

Equipment maintenance

All tools should be cleaned before adhesives residues have had time to cure.

The removal of cured residues is a difficult and time-consuming operation.

If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

Curing

At 22°C Araldite® 403 will attain 50% of its ultimate strength approximately 2 days after mixing, 80-90% of its full strength after 1 week, and full strength after about 8 weeks.

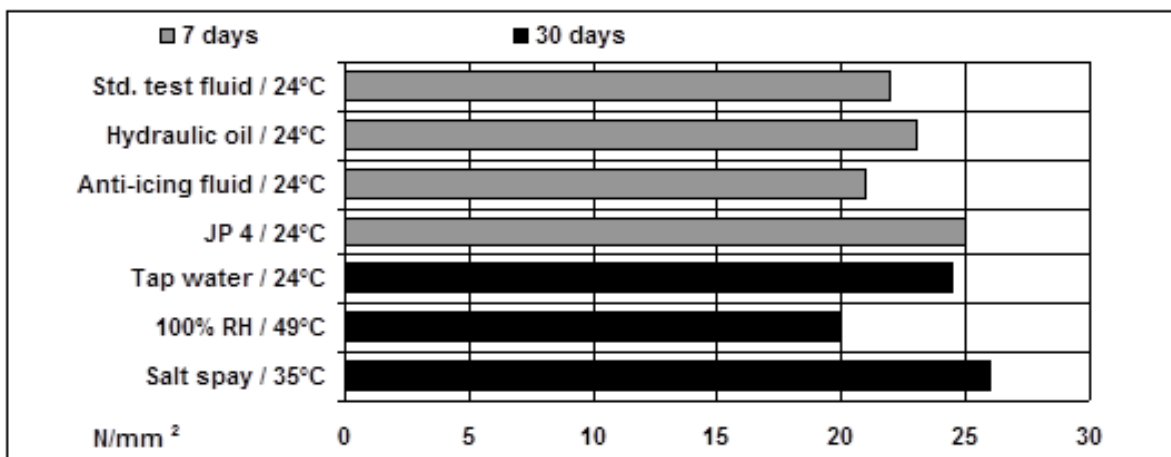
Where circumstances permit, curing time can be reduced to 16 hours by warming the assembly to 45 ± 5°C.

Typical cured properties

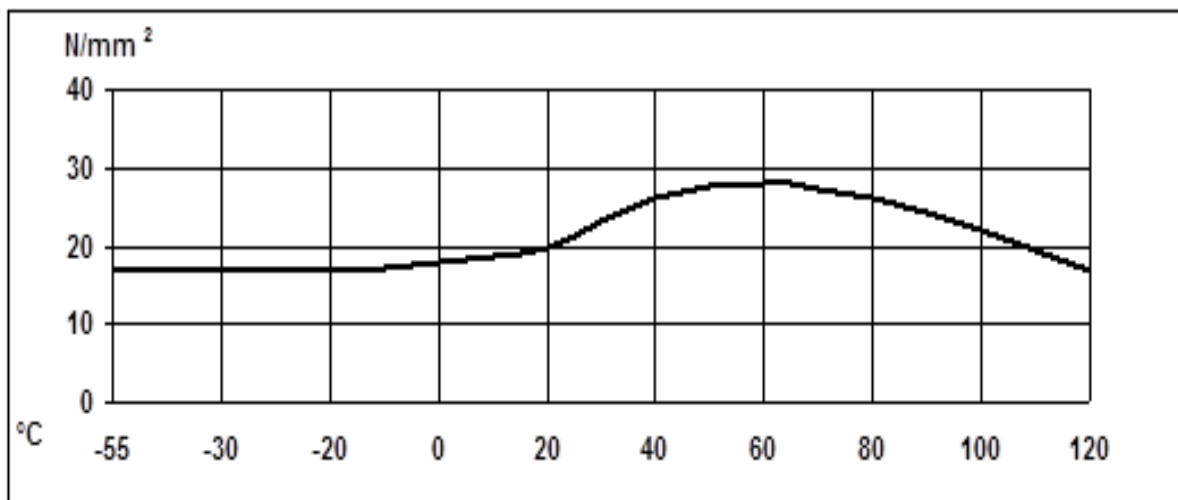
The following data has been obtained for Araldite® 403 on tensile lap shear standard specimens made by lap-jointing (102 x 25 x 1.6) mm strips of aluminium alloy. The joint area was (12.5 x 25) mm in each case.

The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

Tensile shear strength: effect on fluid immersions (Typical average values)
Cure: 42 days at 22°C



Lap shear strength versus temperature (ISO 4587) (typical average values)
Cure: 42 days at 22°C



Storage

Araldite® 403 A/B should be stored at room temperature in the original sealed containers, kept in a dry place protected from extremes of temperature and strong sunlight. The expiry date is indicated on the individual container labels.

Due to the chemical formulation of the Araldite® 403 A itself, it can happen from time to time that some small lumps appear in the product over time. These lumps are known to be recrystallized semi-solid epoxy resin particles. This recrystallization issue occurs randomly but can usually be minimized by avoiding cold storage conditions (below room temperature).

In case of recrystallization, the lumps can be melted again, without affecting the properties on the product, using the following method :

- Open the cans of Araldite® 403 A & heat them up at 60°C in an oven for at least 1 hour to allow the viscosity to go down.
- Using a disperser, stir the heated resin at 500 t/min for 2 to 3 hours (maintaining the heat during the stirring operation will help). Stirring under vacuum will also avoid bubbles.
- Check regularly the aspect of the product till it is lumps free.
- Let the product cool down, then close the lid & store the cans at room temperature.

**Handling
precautions****Caution**

Our products 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 into contact with foodstuffs or food utensils, and measures should 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 at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided.

Disposable paper - not cloth towels - should be used to dry the skin.

Adequate ventilation of the working area is recommended.

These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

**Huntsman Advanced Materials
(Switzerland) GmbH** Klybeckstrasse 200
CH - 4057 Basel
Switzerland

Tel: +41 (0)61 299 11 11
Fax: +41 (0)61 299 11 12

www.huntsman.com/advanced_materials

Huntsman Advanced Materials warrants only that its products meet the specifications agreed with the user. Specified data are analysed on a regular basis. Data which is described in this document as 'typical' or 'guideline' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

The manufacture of materials is the subject of granted patents and patent applications; freedom to operate patented processes is not implied by this publication.

While all the information and recommendations in this publication are, to the best of Huntsman Advanced Material's knowledge, information and belief, accurate at the date of publication, **nothing herein is to be construed as a warranty, whether express or implied, including but without limitation, as to merchantability or fitness for a particular purpose. In all cases, it is the responsibility of the user to determine the applicability of such information and recommendations and the suitability of any product for its own particular purpose.**

The behaviour of the products referred to in this publication in manufacturing processes and their suitability in any given end-use environment are dependent upon various conditions such as chemical compatibility, temperature, and other variables, which are not known to Huntsman Advanced Materials. It is the responsibility of the user to evaluate the manufacturing circumstances and the final product under actual end-use requirements and to adequately advise and warn purchasers and users thereof.

Products may be toxic and require special precautions in handling. The user should obtain Safety Data Sheets from Huntsman Advanced Materials containing detailed information on toxicity, together with proper shipping, handling and storage procedures, and should comply with all applicable safety and environmental standards.

Hazards, toxicity and behaviour of the products may differ when used with other materials and are dependent on manufacturing circumstances or other processes. Such hazards, toxicity and behaviour should be determined by the user and made known to handlers, processors and end users.

Except where explicitly agreed otherwise, the sale of products referred to in this publication is subject to the general terms and conditions of sale of Huntsman Advanced Materials LLC or of its affiliated companies including without limitation, Huntsman Advanced Materials (Europe) BVBA, Huntsman Advanced Materials Americas Inc., Huntsman Advanced Materials (UAE) FZE, Huntsman Advanced Materials (Guangdong) Company Limited, and Huntsman Advanced Materials (Hong Kong) Ltd.

Huntsman Advanced Materials is an international business unit of Huntsman Corporation. Huntsman Advanced Materials trades through Huntsman affiliated companies in different countries including but not limited to Huntsman Advanced Materials LLC in the USA and Huntsman Advanced Materials (Europe) BVBA in Europe.

All trademarks mentioned are either property of or licensed to Huntsman Corporation or an affiliate thereof in one or more, but not all, countries.

Copyright © 2025 Huntsman Corporation or an affiliate thereof. All rights reserved