

Technical Data Sheet: AEROK 8040

Product Description

Aerok 8040 is a slow-curing structural epoxy adhesive. It has high lap shear strength and a long working life. Aerok 8040 is ideal for applications that require a durable and high-strength bond, particularly in harsh environments.

Key Features

- Non-sag formulation
- High Lap Shear Strength
- Toughened
- Excellent adhesion profile
- Good Peel Strength
- Long open time



Applications

All structural applications that require: impact resistance, high static load-bearing, chemical resistance, and resistance to extreme environmental conditions.

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Typical Physical Properties

Uncured

Properties	Part A	Part B
Chemistry	Epoxy	Hardener
Colour	White	Black
Viscosity @ 5 s ⁻¹	79,000	51,000
Density [g/ml]	1.26	1.01
Mix ratio by volume	2	1

Mixed

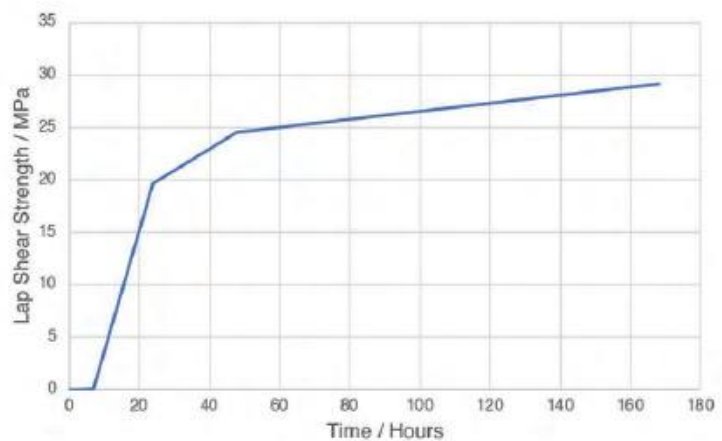
Properties	Aerok 8040
Colour	Grey
Working Time	90-120 mins
Handling Time (Minimum time to achieve >0.3 MPa overlap shear strength)	>9 Hours
Time to reach Full Strength	7 Days

Mixed Viscosity

Shear Rate / s ⁻¹	Mixed Viscosity
0.6	290,000
10	59,000
25	46,000

Rate of Strength Build Up

Overlap shear specimens of grit blasted aluminium were bonded with overlap dimensions of 12.5 x 25 x 0.5 mm (Length x width x thickness). Test specimens were pulled apart at different times after the adhesive was mixed to determine the rate of strength build up as the product cured.





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Tensile Properties

In accordance with
ASTM D638

Properties	Value
Tensile Strength at Break [MPa]	20
Percentage Elongation at Break [%]	11
E-Modulus [MPa]	400

Tensile properties measured on 3mm thick dumbbell specimens at a rate of 5mm/min. Tensile specimens were allowed to cure for 7 days under ambient conditions before being tested

Hardness

Tested in accordance
with ASTM D2240

Properties	Value
Shore D Hardness	75

Shore D hardness measured on a 7mm thick sample of cured adhesive

Typical Performance Characteristics

Overlap Shear Strength

In accordance with
ISO4587

Overlap shear specimens were bonded with overlap dimensions of 12.5 x 25 x 0.5 mm (length x width x thickness). Each specimen was allowed to cure for 3 days @ 20°C 50% RH before being pulled apart at a rate of 6mm/min -for metals and 50mm/min for plastics and composites.

Substrate	Surface Prep	Overlap Shear Strength	Failure Mode
Aluminium	IPA wiped Abraded (120g) * Grit Blasted*	26	AF
		27	CF
		29	CF
Anodised Aluminium	IPA wiped Grit Blasted*	18 19	AF CF
Stainless Steel	IPA wiped Grit Blasted*	26	CF
		27	CF
Mild Steel	IPA wiped Grit Blasted*	23	AF
		25	CF
E-Galvanised Steel	IPA wiped Grit Blasted*	17	AF
		24	CF
GRP - Epoxy	IPA wiped Abraded (120g) *	18	SF
		18	SF
GRP - Polyester	IPA wiped Abraded (120g) *	9	SF
		9	SF
PMMA	IPA wiped Abraded (120g) *	1	AF
		4	SF
Polycarbonate	IPA wiped Abraded (120g) *	3	AF
		5	SF
ABS	IPA wiped Abraded (120g) *	2	AF
		4	AF

IPA: isopropyl alcohol, * = IPA wipe, abrade with 120 grit pad or Grit blast, IPA wipe.

AF - Adhesive Failure

CF - Cohesive Failure

SF - Substrate Failure

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Temperature Performance

Overlap Shear Strength

In accordance with ISO4587

Overlap shear specimens were bonded with overlap dimensions of 12.5 x 25 x 0.5 mm (length x width x thickness). Each specimen was allowed to cure for 7 days @ 20°C 50%RH before being subjected to various temperature exposures.

Short Term Exposure at Temperature

Test specimens exposed to the test temperature for 5 minutes and pulled apart at the test temperature. Pull rate 6mm/min.

Substrates	Surface Prep	Test Temp [°C]	Shear Strength	% Strength Retention (% against 25°C strength)
Aluminium	Grit Blasted	25	29	100
Aluminium	Grit Blasted	50	21	72
Aluminium	Grit Blasted	75	12	41
Aluminium	Grit Blasted	100	6	21
Aluminium	Grit Blasted	120	5	17
Aluminium	Grit Blasted	150	3	10
Aluminium	Grit Blasted	200	0	0

All substrates used to create a lap shear specimen were 3mm in thickness

Volumes Available.

Cartridges

50ml
200ml
400ml



Bulk



Remarks, Disclaimer & Health and Safety

Disclaimer - The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate evaluations on the efficacy of the materials offered by Forgeway, of its products, services, recommendations and suggestions for the specific application need, and must accomplish sufficient testing to ascertain that the final product will be safe and sound for the final intent of the end user.

Health and safety - Refer to Safety Data Sheet (SDS) for further information. Apply the usual industrial hygiene.

Reviewed June 2023