Araldite®
Reliable and comprehensive bonding solutions

Raising performance in railway industry
Our mission: provide unique bonding technologies that create value for our customers

Driven by increasing demand for mobility, energy consumption efficiency, and concerns over climate change, a high priority is placed in Europe on developing rail as a key transport mode by promoting step-change innovations for passenger rolling stock, freight transport, and rail infrastructure.

Whilst the level of global business competition is high, manufacturers need solutions to help sustain their competitive edge and secure long-term growth. Production process improvement, innovation in design, weight savings, compliance to stringent safety and environmental standards, and low maintenance costs have become vital to success.

In this context, adhesives can play an even greater role, providing well established solutions as well as more advanced and innovative developments for all kinds of bonding applications.

Adhesives deliver long term performance and durability

Adhesive bonding enables the most efficient use of materials, maximising their long-term potential while optimising manufacturing methods with easy handling and processing.

Compared to mechanical joining, adhesive bonding allows the assembly of dissimilar materials and higher weight loads to be carried while offering more uniform stress distribution across the entire bonded joint and superior fatigue resistance.

Adhesives facilitate the integrity and strength of materials as there are no holes, rivets or fastening elements to weaken the structure. Without any visible joining elements, nothing detracts from the aesthetics of the finished parts and greater lightweight design flexibility can be achieved.

Additionally, adhesives offer the potential to reduce costs in parts production through streamlined assembly processes and hence faster cycle times.

Therefore adhesive bonding has become standard in manufacturing exterior and interior parts in order to deliver superior performance and durability for rolling stocks and infrastructure applications.

We deliver more than just products

Huntsman offers a unique wide range of adhesive solutions for all segments of the rail market, from high speed trains, mainline and regional trains to metro, suburban, freight trains and the infrastructure around them.

As a strategic partner, we tailor our products and services to the evolving needs of this market. Based on epoxy, polyurethane, methyl methacrylate and phenolic technologies, our adhesives have specific characteristics that help end-users improve their manufacturing processes, secure long-term performance and safety of assemblies. This results in reduced maintenance costs, increased design freedoms and the development of lightweight structures for better energy efficiency and aesthetics. As a result of our extensive experience working in the aerospace industry, Huntsman’s innovations go beyond improving mechanical properties with the addition of new features such as flame retardancy, low smoke density and low toxic emissions.

Huntsman Advanced Materials’ testing laboratories in Basel are accredited according to ISO/IEC 17025 for synthetic materials testing and quantity temperature calibration. This accreditation also ensures that in-house testing methods conform to the DIN 6702-1 standard requirements for the rail industry. Moreover Huntsman’s global manufacturing footprint, local technical support and commercial teams ensure close proximity with our customers.
Strength in bonding

The Araldite® adhesives range for railway contains a selection of adhesives from the latest epoxy, polyurethane, methacrylate and phenolic technologies to meet the great majority of high-performance bonding applications.

Araldite® adhesives range for railway

From adhesives with long open times for large area applications to fast-curing adhesives for early removal from fixtures and rapid through-out, this range includes adhesives which are resistant to high temperature, water and chemicals. Liquid adhesives as well as thixotropic adhesives for gap-filling or vertical applications can be found in this range. Adhesives with highest strength can be selected from this range as well as tough and impact-resistant adhesives with a well-balanced combination of strength and flexibility and also elastic adhesives to cope with different thermal expansions when bonding larger structures of dissimilar materials.

Products from the Araldite® adhesives range for railway are available in a variety of packaging including easy-to-use cartridges with static mixers and working packs for manual applications as well as hobbicks and drums for higher volume applications. The Araldite® adhesives range for railway will continuously be updated to meet the newest demands of innovative design using the bonding technology.

Epoxies

1-C epoxy adhesives
- excellent adhesion to metals, thermoset and thermoplastic composites
- outstanding lap shear strength and peel strength
- high fatigue resistance
- very high impact resistance
- excellent chemical resistance
- easy processing

2-C epoxy adhesives
- excellent adhesion to metals and thermoset composites
- high strength and high stiffness
- high creep resistance
- high fatigue resistance
- high temperature resistance
- (adhesive specific up to 210°C)
- excellent chemical resistance
- low shrinkage

Methacrylates

2-C methyl methacrylate adhesives
- excellent adhesion to metals, thermoset composites and most thermoplastics
- good adhesion with minimum surface preparation
- tolerant to mix-ratio variations
- optimum ratio open-time / cure time
- mechanical properties from rigid to flexible
- good long-term durability

No-mix methyl methacrylate adhesives
- long open-time and rapid cure
- good adhesion with minimum surface preparation
- high process flexibility
- suitable for high production speed
- high toughness
- good long-term durability

Polyurethanes

2-C polyurethane adhesive
- excellent adhesion to most thermoplastics and composite materials
- good adhesion to metals
- mechanical properties from rigid to flexible
- good long-term durability
- good combination of strength and flexibility

Phenolics

- excellent adhesion to metals and friction materials
- outstanding temperature resistance
- excellent chemical resistance
- easy to apply
- virtually «infinite» open time once applied
### Bonding solutions for railway industry

**Product designation** | **Light and traffic boxes** | **Carriage structure** | **Roof, floor covering, doors** | **Semi-structural bonding** | **Insulated rail joints and repair** | **Interior furnishings** | **Brake bonding** | **Sandwich panel laminating** | **Sandwich panel assembly** | **Electrical components**
--- | --- | --- | --- | --- | --- | --- | --- | --- | --- | ---
Araldite® 2013-1 | | | | | | | | | | |
Araldite® 2014-2 | | | | | | | | | | |
Araldite® 2015 | | | | | | | | | | |
Araldite® 2031 | | | | | | | | | | |
Araldite® 2033 | | | | | | | | | | |
Araldite® 420 | | | | | | | | | | |
Araldite® AV 170 | | | | | | | | | | |
Araldite® AV 4600 | | | | | | | | | | |
Araldite® AW 146 / Hardener HW 202 | | | | | | | | | | |
Araldite® AW 2101 / HW 2951 | | | | | | | | | | |
Araldite® AW 4858 / HW 4858 | | | | | | | | | | |
Araldite® AW 4859 / HW 4859 | | | | | | | | | | |
Araldite® 2026-1 | | | | | | | | | | |
Araldite® 2028-1 | | | | | | | | | | |
Araldite® 2029-1 | | | | | | | | | | |
Araldite® 2047-1 | | | | | | | | | | |
Araldite® 2052-1 | | | | | | | | | | |
Agomet® F 305 A/B hardener powder | | | | | | | | | | |
Agomet® F 330 hardener lacquer | | | | | | | | | | |
Araldite® 64-1 | | | | | | | | | | |
Araldite® 71 | | | | | | | | | | |

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**Recommended**, **Suitable**, **Non-exclusive selection - Ask our experts for other solutions.**
Araldite®
Reliable and comprehensive bonding solutions for railway industry

1. Lights and control boxes
   Body assembly, lens assembly
   Your needs
   > Very good weathering resistance
   > Electrical insulation
   > Good thermal resistance
   > Flame retardancy
   Our solutions
   Araldite® 2013-1
   Araldite® 2015
   Araldite® 2021-1
   Araldite® 2022-1
   Araldite® 2033
   Araldite® 2052-1

2. Carriage structure
   Frame and ceiling reinforcement
   Your needs
   > Improve the fatigue resistance of the metal assemblies
   > Reduce overall weight of structure
   > Prevent and reduce corrosion
   > Improve stiffness and shock resistance of the assemblies
   Our solutions
   Araldite® 2014-2
   Araldite® 2015
   Araldite® AV 170
   Araldite® AV 4600
   Araldite® AW 4858 / HW 4858
   Araldite® AW 4859 / HW 4859

3. Roofs, doors, floors and semi-structural bonding
   Floor coverings, seats attachment to floor, doors frames, hinges, HVAC
   Your needs
   > Multimaterial assemblies
   > Ease of application
   > Toughness, shock resistance
   > Aesthetical design
   Our solutions
   Araldite® 2013-1
   Araldite® 2015
   Araldite® 2029-1
   Araldite® AW 4858 / HW 4858
   Araldite® AW 4859 / HW 4859

4. Insulated rail joints
   Your needs
   > Very good weathering resistance
   > Fast curing
   > High fatigue and vibration resistance
   > Electrical insulation
   Our solutions
   Araldite® 2013-1
   Araldite® 2014-2
   Araldite® 2015
   Araldite® 2021
   Araldite® 2022-1
   Araldite® AW 2101 / HW 2001

5. Interior furnishings
   Fold tables, equipment boxes on carriages, handles, mirrors, luggage racks, ceiling liners
   Your needs
   > Multimaterial assemblies
   > Reduce overall weight
   > Ease of application
   > Flame retardancy
   > Aesthetical design
   Our solutions
   Araldite® 2015
   Araldite® 2022-1
   Araldite® 2028-1
   Araldite® 2029-1
   Araldite® 2047-1
   Araldite® 2048-1

6. Brake bonding
   Brake shoes, brake pads, dip-coating
   Your needs
   > Very high temperature resistance
   > Very good adhesion to friction material
   > Very good adhesion to steel and aluminum
   Our solutions
   Araldite® 64-1
   Araldite® 71

7. Sandwich panels laminating and assembly
   Wall cabinets, partition walls, panelling
   Your needs
   > Multimaterial assemblies
   > Long open time for large parts laminating
   > Controlled rheology
   > Fast curing for panels assembly
   > Design freedom
   Our solutions for lamination
   Araldite® AW 146 / HV 957
   XB 5390-1 / Arathane® HY 5611-1
   XD 4465 / Arathane® HY 5611-1
   Our solutions for assembly
   Araldite® 420
   Araldite® 2013-1
   Araldite® 2015
   Araldite® 2029-1
   Araldite® 2033
   Araldite® AW 4858 / HW 4858

8. Electrical components assembly
   Transformers, drivers control panel, cables
   Your needs
   > Multimaterial assemblies
   > Good thermal resistance
   > Weathering resistance
   > Electrical insulation
   Our solutions
   Araldite® 2013-1
   Araldite® 2014-2
   Araldite® 2033
   Agomet® F 305 A/B
   Agomet® F 330

Non exclusive selection - Ask our experts for other solutions.
<table>
<thead>
<tr>
<th>Product designation</th>
<th>Technology</th>
<th>Mix ratio</th>
<th>Color</th>
<th>Pot life</th>
<th>Fixture time</th>
<th>Gap filling</th>
<th>Lap shear strength on aluminum*</th>
<th>Tensile modulus**</th>
<th>Elongation at break**</th>
<th>Key benefits</th>
</tr>
</thead>
<tbody>
<tr>
<td>Araldite® 2013-1</td>
<td>Araldite® AV 144-2 / Hardener HV 997-1</td>
<td>EP 100 : 100</td>
<td>grey</td>
<td>80</td>
<td>300</td>
<td>5</td>
<td>20</td>
<td>1 400</td>
<td>2</td>
<td>Grey metal colored, non-sagging paste, high toughness. Approved by the French Railways.</td>
</tr>
<tr>
<td>Araldite® 2014-2</td>
<td>Araldite® AV 130-1 / Hardener HV 5300-1</td>
<td>EP 100 : 50</td>
<td>dark grey</td>
<td>110</td>
<td>300</td>
<td>5</td>
<td>17</td>
<td>3 000</td>
<td>1</td>
<td>Resistance to high temperature, excellent chemical resistance, room temperature cure.</td>
</tr>
<tr>
<td>Araldite® 2015</td>
<td>Araldite® AV 5300 / Hardener HV 5300-1</td>
<td>EP 100 : 100</td>
<td>beige</td>
<td>40</td>
<td>240</td>
<td>10</td>
<td>17</td>
<td>2 000</td>
<td>5</td>
<td>High toughness, excellent weathering resistance, good temperature resistance on British rail’s register of approved adhesives for fishplate and rail bonding. Approved by the French Railways.</td>
</tr>
<tr>
<td>Araldite® 2031</td>
<td>Araldite® AV 4706.1 BK / Hardener HV 5300-1 BK</td>
<td>EP 100 : 100</td>
<td>black</td>
<td>60</td>
<td>240</td>
<td>10</td>
<td>18</td>
<td>1 000</td>
<td>5</td>
<td>High toughness, excellent weathering resistance, non sagging paste.</td>
</tr>
<tr>
<td>Araldite® 2033</td>
<td>Araldite® AW 4833 / Hardener HW 4833</td>
<td>EP 100 : 100</td>
<td>black</td>
<td>120</td>
<td>240</td>
<td>5</td>
<td>16</td>
<td>2 500</td>
<td>1</td>
<td>Self extinguishing, EN 4545-2 H3.3, UL 94 V-0 (4.5 mm), gap filling, long open time.</td>
</tr>
<tr>
<td>Araldite® 420</td>
<td>Araldite® AV 460 / Araldite® 420 A</td>
<td>EP 100 : 50</td>
<td>green</td>
<td>150</td>
<td>360</td>
<td>&lt; 1</td>
<td>40</td>
<td>1 500</td>
<td>10</td>
<td>High lap shear strength, high peel strength, high toughness.</td>
</tr>
<tr>
<td>Araldite® AV 170</td>
<td>n.a.</td>
<td>pale yellow</td>
<td>n.a.</td>
<td>1 component epoxy</td>
<td>0.5</td>
<td>28</td>
<td>1 800</td>
<td>1</td>
<td>High peel strength, high toughness, non sagging paste. Approved by the French Railways.</td>
<td></td>
</tr>
<tr>
<td>Araldite® 2038-1</td>
<td>Araldite® AV 170 / Araldite® 420-1</td>
<td>EP 100 : 100</td>
<td>pale yellow</td>
<td>100</td>
<td>420</td>
<td>&lt; 1</td>
<td>26</td>
<td>1 900</td>
<td>10</td>
<td>Easy to spread, long pot-life, good temperature resistance.</td>
</tr>
<tr>
<td>Araldite® AW 2015 / HW 2051</td>
<td>Araldite® AW 2015 / Hardener HW 2051</td>
<td>EP 100 : 100</td>
<td>grey</td>
<td>6</td>
<td>60</td>
<td>5</td>
<td>20</td>
<td>5 500</td>
<td>1</td>
<td>Fast cure, non-sagging paste, high strength, sandable.</td>
</tr>
<tr>
<td>Araldite® AW 4805 / HW 4805</td>
<td>Araldite® AV 5505 / Hardener HW 4805</td>
<td>EP 100 : 50</td>
<td>black</td>
<td>150</td>
<td>360</td>
<td>10</td>
<td>38</td>
<td>1 800</td>
<td>10</td>
<td>High lap shear strength, high peel strength, high toughness.</td>
</tr>
<tr>
<td>Araldite® AW 4805 / HW 4805</td>
<td>Araldite® AW 4805 / Hardener HW 4805</td>
<td>EP 100 : 50</td>
<td>black</td>
<td>100</td>
<td>270</td>
<td>10</td>
<td>33</td>
<td>1 500</td>
<td>5</td>
<td>High temperature resistance, high peel strength, gap filling.</td>
</tr>
<tr>
<td>Araldite® 2028-1</td>
<td>Araldite® AV 4833-1 polyol / Araldite® AV 5300-1 isocyanate</td>
<td>PU 100 : 100</td>
<td>crystal clear</td>
<td>6</td>
<td>30</td>
<td>&lt; 1</td>
<td>15</td>
<td>60</td>
<td>Transparent clear, 3V stable, fast curing.</td>
<td></td>
</tr>
<tr>
<td>Araldite® AW 4804-1 / Hardener HW 4841</td>
<td>XB 5080-1 polyol / Araldine® HY 5611-1</td>
<td>PU 100 : 100</td>
<td>beige</td>
<td>100</td>
<td>360</td>
<td>&lt; 1</td>
<td>20</td>
<td>27</td>
<td>40</td>
<td>Easy to spread, long pot-life, good environmental and chemical resistance.</td>
</tr>
<tr>
<td>Araldite® 2011-1</td>
<td>Araldite® F 350-1 / Hardener F 350-1</td>
<td>MMA 100 : 100</td>
<td>pale yellow</td>
<td>3</td>
<td>9</td>
<td>3</td>
<td>25</td>
<td>2 000</td>
<td>10</td>
<td>Very fast cure, high strength, high toughness.</td>
</tr>
<tr>
<td>Araldite® 2023-1</td>
<td>Araldite® F 360-1 / Hardener F 360-1</td>
<td>MMA 100 : 100</td>
<td>pale yellow</td>
<td>10</td>
<td>12</td>
<td>3</td>
<td>25</td>
<td>2 000</td>
<td>5</td>
<td>Fast cure, high strength, high toughness.</td>
</tr>
<tr>
<td>Araldite® 2047-1</td>
<td>Araldite® F 347 / Hardener K 100-1 red</td>
<td>MMA 100 : 100</td>
<td>brown</td>
<td>10</td>
<td>15</td>
<td>3</td>
<td>18</td>
<td>850</td>
<td>30</td>
<td>Good adhesion on difficult to bond metals, fast cure, good flexibility. Approved by the French Railways.</td>
</tr>
<tr>
<td>Araldite® 2048-1</td>
<td>Araldite® F 348 / Hardener F 348-1</td>
<td>MMA 100 : 100</td>
<td>black</td>
<td>10</td>
<td>35</td>
<td>8</td>
<td>24</td>
<td>350</td>
<td>90</td>
<td>High flexibility, gap filling, fast cure, low chlorine content.</td>
</tr>
<tr>
<td>Araldite® 2052-1</td>
<td>Agomet® F 332 / Hardener K 100-1 red</td>
<td>MMA 100 : 100</td>
<td>red</td>
<td>15</td>
<td>20</td>
<td>3</td>
<td>24</td>
<td>1 700</td>
<td>10</td>
<td>High temperature resistance, high strength, fast cure, toughness.</td>
</tr>
<tr>
<td>Agomet® F 305 A/B</td>
<td>MMA 6% hardener brown powder</td>
<td>MMA 100 : 100</td>
<td>brown</td>
<td>2</td>
<td>5</td>
<td>&lt; 1</td>
<td>23</td>
<td>500</td>
<td>20</td>
<td>«No mix» system, 2 minutes work-life, 5 minute handling strength, low viscosity, ideal for ferrite bonding.</td>
</tr>
<tr>
<td>Agomet® F 330 hardener lacquer</td>
<td>MMA hardener lacquer</td>
<td>MMA 100 : 100</td>
<td>beige</td>
<td>10</td>
<td>20</td>
<td>&lt; 0.5</td>
<td>35</td>
<td>1 500</td>
<td>5</td>
<td>«No mix» system, 10 minutes work-life, 20 minutes handling strength, resistance to high temperature.</td>
</tr>
<tr>
<td>Araldite® 64-1</td>
<td>Phenolic</td>
<td>n.a.</td>
<td>black</td>
<td>n.a.</td>
<td>n.a.</td>
<td>&lt; 0.5</td>
<td>8</td>
<td>n.a.</td>
<td>n.a.</td>
<td>Very high temperature resistance, «infinite» open time, suitable for use as an adhesive or dilution to primer viscosity.</td>
</tr>
<tr>
<td>Araldite® 71</td>
<td>Phenolic</td>
<td>n.a.</td>
<td>black</td>
<td>n.a.</td>
<td>n.a.</td>
<td>&lt; 0.5</td>
<td>8</td>
<td>n.a.</td>
<td>n.a.</td>
<td>Very high temperature resistance, «infinite» open time, extrudable.</td>
</tr>
</tbody>
</table>

EP = Epoxy  I  PU = Polyurethane  I  MMA = Methyl methacrylate  I  *measured following ISO 4587 (Curing 16h at 40°C)  I  **measured following ISO 527 (Curing 16h at 40°C)  I  Cure temperature at RT possible (full cure achieved after 7 days)  I  Non-exclusive selection - Ask our experts for other solutions.
We value your challenge

By providing unique, certified or patented technologies, combined with high quality and reliability, our chemists and experts bring enhanced value to our customers, ensuring their success.

With innovation

Every day, all over the world, our Technical Competence centers engage in intensive research and development focusing on one goal: to deliver innovative solutions by working hand-in-hand with our business partners. Together through a continual exchange of ideas, supported by an experienced team of sales and technical specialists, we strive to deliver innovative and regulatory compliant (e.g. REACH compliant) solutions.

We track both new market expectations and changing regulations. Protection of the environment, as well as health and safety are paramount concerns, playing an integral part in our development projects.

With customer intimacy

We market a unique product portfolio and a broad range of forward-looking solutions for our customers. Customers and partners benefit from an advanced level of service in:

> product selection and quality
> product trials in-house and with customers
> customer seminars and trainings
> technical service and solution-providing

Partnership with our customers is more than simply “putting them first”. It requires long-term commitment to forging close relationships that create synergies of knowledge, security and adaptability to create a successful, shared future.

With care

Sustainability is a fundamental part of our corporate and business strategy. We see a better world in which our innovations help reduce consumption of natural resources and improve the quality of life for people everywhere. We are identifying the long-term trends that affect our markets and looking to see how products and applications can play a part in supporting and providing solutions to the challenges those markets face.
Huntsman Advanced Materials

Our Advanced Materials division is a leading global chemical solutions provider with a long heritage of pioneering technologically advanced epoxy, acrylic, phenolic and polyurethane-based polymer products.

Our capabilities in high-performance adhesives and composites, delivered by more than 1,600 associates, serve over 2,000 global customers with innovative, tailor-made solutions and more than 1,500 products which address global engineering challenges.

We operate synthesis, formulating and production facilities around the world

Find the right adhesive to fulfill your needs

www.AralditeAdhesives.com

Enriching lives through innovation

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Data and results are based on controlled conditions and/or lab work. Buyer is responsible to determine the applicability of such information and recommendations and the suitability of any Product for its own particular purpose, and to ensure that its intended use of the Product does not infringe any intellectual property rights.

The Product may be or become hazardous. Buyer should (i) obtain Material Safety Data Sheets and Technical Data Sheets from Huntsman containing detailed information on Product hazards and toxicity, together with proper shipping, handling and storage procedures for the Product, (ii) take all steps necessary to adequately inform, warn and familiarize its employees, agents, direct and indirect customers and contractors who may handle or be exposed to the Product of all hazards pertaining to and proper procedures for safe handling, use, storage, transportation and disposal of and exposure to the Product and (iii) comply with and ensure that its employees, agents, direct and indirect customers and contractors who may handle or be exposed to the Product comply with all safety information contained in the applicable Material Safety Data Sheets, Technical Data Sheets or other instructions provided by Huntsman and all applicable laws, regulations and standards relating to the handling, use, storage, distribution and disposal of and exposure to the Product. Please note that products may differ from country to country, if you have any queries, kindly contact your local Huntsman representative.

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