

DESCRIPTION

Bonding of car body, bonding metallic structures (racing vehicles, aeronautics), bonding inserts and composite structures

PROPERTIES

- 2 component high performance room temperature cured epoxy adhesive
- Non sagging paste product suitable for vertical applications and to fill irregular joints
- Excellent mechanical and thermal performances up to 130°C
- Excellent strength to dynamic loads (vibrations and impacts)
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition	RESIN	HARDENER	MIX	Method
Mix ratio by weight	100	90		
Mix ratio by volume at 25°C	100	100		
Colour	Beige (BG) Black (BK)	Beige	Beige (BG) Black (BK)	
Viscosity at 25°C, Pa.s ^(AKP)	950	NA	NA	LT-054 / 0.1 s ⁻¹
Density at 25°C ^(AKP)	1.38	1.21	-	LT-020
Density of mixed product at 23°C	-	-	1.30	ISO 2781
Pot life at 23°C on 100g, min ^(AKP)	-	-	25	LT-002
Open Time on 7 mm bead at 23°C, min	-	-	40	LT-006-B

(AKP): Axson Key Properties. These values are enclosed in Certificate Of Analysis.

MECHANICAL PROPERTIES

Hardness, Shore D*	80	ISO 868
Tensile strength, MPa *	30	ISO 527-2
Elongation at break, % *	2	
Young Modulus, MPa *	2500	
Recommended application temperature, °C	15 - 30	-
Working temperature, °C **	-40 to 130	LT-006-B

*cured 16H at 70°C

** Working temperature is defined as the temperature at which product keeps 80% of its initial Lap Shear Strength after 1000 hours ageing at this temperature, value on Aluminium, measured at 23°C.

HANDLING TIME

Handling time			
At 23°C	4h30		LT-006-B
At 40°C	1h45		
At 60°C	30 min		

Handling time is defined as the time needed to obtain Lap Shear Strength on Aluminum at 23°C, of 1MPa.

MECHANICAL PROPERTIES ON ASSEMBLIES (Cured 16H at 70°C)

Lap Shear Strength at 23°C				
Aluminium 2017A sandblasted		20 CF	MPa	LT-006-B
	After wet cataplastm 7days 70°C/100% RH	20 CF		
	After 15 cycles D3**	20 CF		
	After 3 weeks immersion in :			
	Motor oil at 70°C	16 CF		
	Hydrochloric acid (0.1 N) at 23°C	17 CF		
	Soda (0.1N) at 23°C	20 CF		
	Seawater at 23°C	20 CF		
	Gasoil at 23°C	19 CF		
	Gas at 23°C	20 CF		
Stainless Steel 304 sandblasted		23 CF	MPa	LT-006-B
	After wet cataplastm 7 days at 70°C/100% RH	20 CF		
Electro galvanised Steel sandblasted		21 CF		
Electro galvanised Steel Acetone wipe		15 AF/CF		
ABS Sanded + Isopropanol		3.5 SF		
PC Sanded+Isopro.+ Plastic primer*		4 SF		
PVC Sanded + Isopropanol		5 SF		
PMMA Sanded + Isopro.+Plastic primer*		4.5 SF		
PA6E Sanded + Isopropanol		3.5 SF		
GFR Polyester Isopropanol wipe		8 DF		
GFR Epoxy Isopropanol wipe		21 SCF/CF		

CF: Cohesive Failure, AF: Adhesive Failure, SCF: Special Cohesive Failure, SF: Substrate Failure

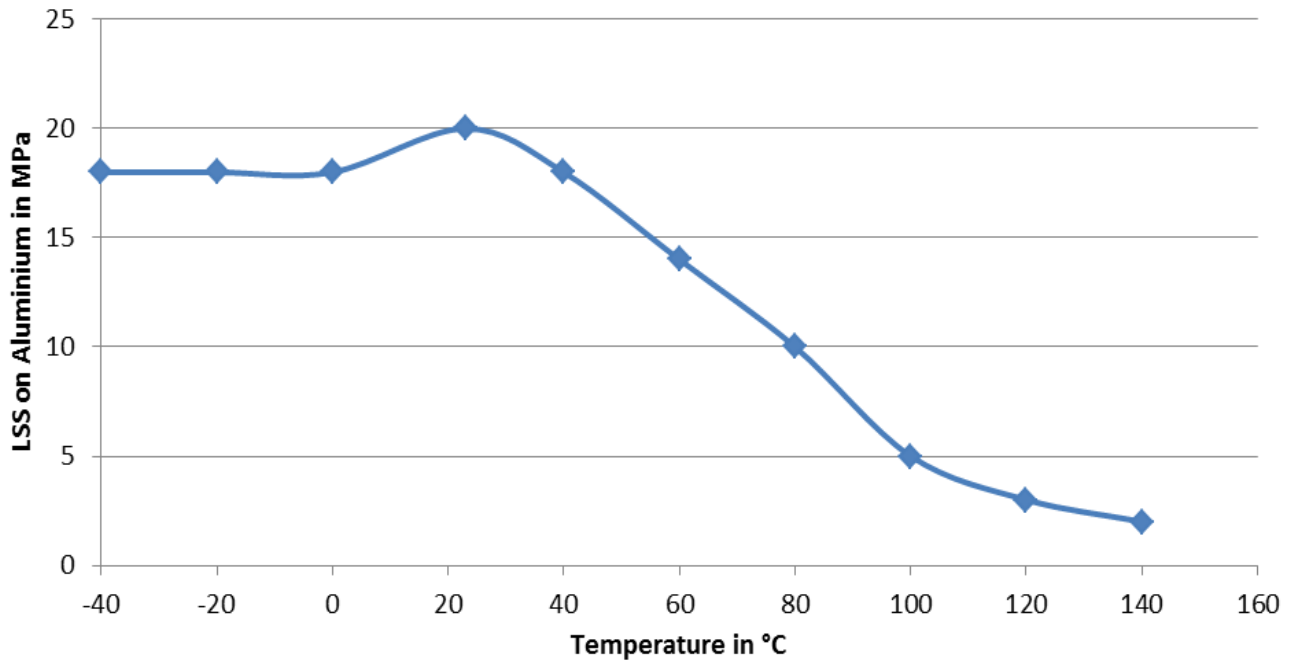
DF: Delamination Failure, according to EN ISO 10365 Standard.

*Plastics sanded, Isopropanol wiped and coated with AXSON Plastic Primer.

**Cycle D3: exposition cycle in the heat, in the cold and in the humidity according to ISO 9142 standard.

Floating roller Peel Strength at 23°C				
Aluminum 2017A sandblasted		5	KN/m	ISO 4578

Lap Shear Strength on Aluminium versus Temperature



EQUIPMENT: ADEKIT A140 is packaged in 50 ml and 400 ml cartridges and requires a manual or pneumatic gun. Please consult our technical department for applications needing a machine.

SUBSTRATE PREPARATION

The item to be bonded must be free of all dirt, oil or other foreign matter. A clean, dry surface is a must. Consult our Technical Support and refer to the technical data sheet about surface preparations to choose adapted degreaser or cleaner

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products :

- ensure good ventilation
- wear gloves and safety glasses
- wear waterproof clothes

For further information, please consult the product safety data sheet.



BUILDING TRUST



ADEKIT A140 ADEKIT H 9940

STRUCTURAL EPOXY ADHESIVE
HIGH PERFORMANCES

STORAGE CONDITIONS

Shelf life of ADEKIT A140 and of ADEKIT H 9940 POLYOL / H9940 ISOCYANTE is **12 months**, stored in its original unopened packaging at temperature between +15°C and +25°C.

PACKAGING

A140 / 50ml	Box of 12 cartridges
A140 / 400ml	Box of 12 cartridges
H9940 Resin & H9940 Hardener	Please consult our Sales Department

GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.

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