

APPLICATION

Bonding of parts in large series, bonding and repairing of body elements, bonding and repairing of composite parts

PROPERTIES

- 2 component room temperature cure polyurethane adhesive
- Non sagging paste product suitable for vertical applications and to fill irregular joints
- Excellent vibrations, impacts and noise damping
- Excellent behaviour at low temperatures
- Product adapted to assemblies involving dissimilar materials
- Excellent mechanical performances and ageing
- Excellent strength to dynamic loads (vibrations and impacts)
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition	POLYOL	ISOCYANATE	MIX	Method
Mix ratio by weight	130	100		
Mix ratio by volume at 25°C	100	100		
Colour	Black (BK)	Beige	Grey (GY)	
Viscosity at 25°C, Pa.s (AKP)	40-90 300-600		25-55 100-200	LT-063 / 15 s ⁻¹ LT-063 / 1.5 s ⁻¹
		11-19		LT-001
Density at 25°C (AKP) Density of cured product at 23°C	1.47	1.17	1.34	LT-020 ISO 2781
Pot life at 23°C on 50g, min (AKP)			12	LT-002-B
Open time on 7 mm bead at 23°C, min			16	LT-006-B

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

MECHANICAL PROPERTIES

Hardness, Shore D**	48	ISO 868
Tensile strength, MPa **	13	ISO 527
Elongation at break, % **	95	
Young Modulus, MPa **	40	
Use temperature, °C	15 à 30	-
Working temperature, °C ***	-40 à 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 (AKP)	60	min	LT-006-B
At 40°C	30		
At 60°C	15		

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		16 CF	MPa	LT-006-B	
	After wet cataplastm 7 days 70°C/100% RH on Aluminium coated with Axson Metal primer	11 CF			
	After wet cataplastm 7days 70°C/100% RH	6 AF			
	After 15 cycles D3*	13 CF			
	After 3 weeks immersion in :				
	Motor oil at 70°C	16 CF			
	Hydrochloric acid (0.1 N)	13 CF			
	Soda (0.1N)	9 CF			
	Seawater	15 CF			
	Gasoil	16 CF			
	Gas	5 CF			
Stainless Steel 304 sandblasted		16 CF			
	After wet cataplastm 7 days 70°C/100% RH	11 AF/CF			
Electro galvanized steel sandblasted		11 CF			
Electro galvanized steel Acetone wiped		14 CF/AF			
ABS Isopropanol+ Plastic Primer		6 SF			
PC		7 SF			
PA6 sandblasted		4 SCF			
PVC sandblasted		7 SF			
PMMA		5 SF			
Composite SMC sanded		7 SD			

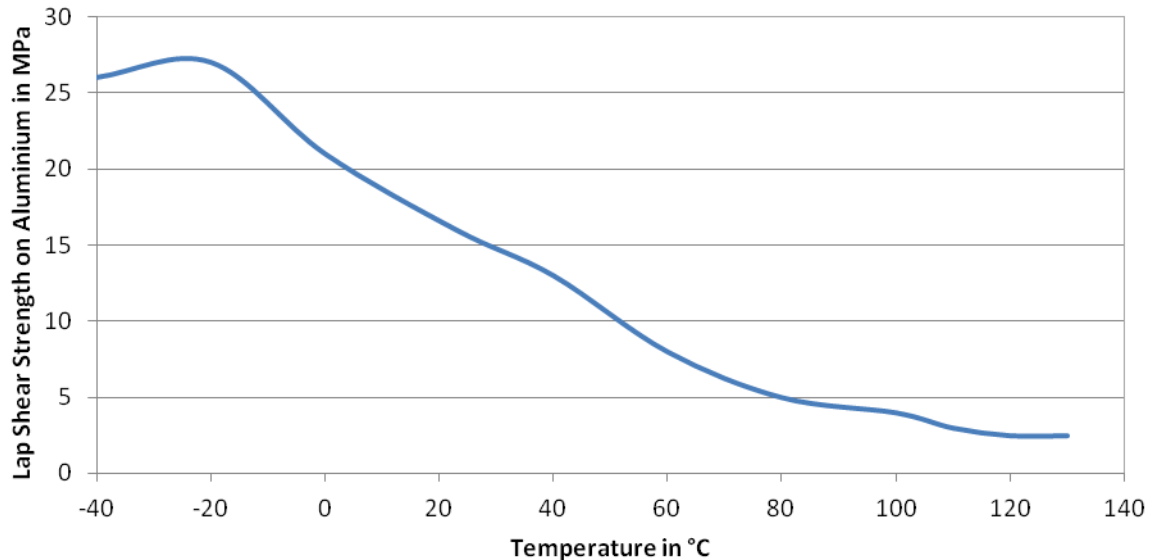
CF: Cohesive Failure AF: Adhesive Failure SCF: Special Cohesive Failure SF: Substrate Failure

SD: Substrate Delamination

*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				
Aluminium 2017A sandblasted		12	KN/m	ISO 4578

Lap Shear Strength on Aluminium versus Temperature



EQUIPMENT

ADEKIT A220 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.

STORAGE CONDITIONS

Shelf life of ADEKIT A220 is 9 months and 12 months for ADEKIT H 6220 POLYOL / H 6280 ISOCYANATE stored in its original unopened packaging at a temperature between +15°C and +25°C.



BUILDING TRUST



ADEKIT A 220 GY H 6220 BK POLYOL H 6280 ISOCYANATE POLYURETHANE ADHESIVE

PACKAGING

A220 GY / 50ml	Box of 12 cartridges
A220 GY / 400ml	Box of 12 cartridges
H 6220 BK POLYOL & H 6280 ISOCYANATE	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.

AXSON TECHNOLOGIES
Head Office France
+33 1 34 40 34 60
axson@axson.com
axson.com

GERMANY
+49 (0)7125 940 492
tooling@de.sika.com
www.sikaaxson.de

ITALY
+39 02 96 70 23 36
axson@axson.it
axson.it

SPAIN & PORTUGAL
+34 93 225 16 20
spain@axson.com
axson.es

U.K.
+44 1 638 66 00 62
sales.uk@axson.com
axson.com

SLOVAKIA
+421 37 642 25 26
axson.sk@axson.com
axson-ce.sk

USA
+1 248 588 2270
axsonmh@axson.com
axson-na.com

MEXICO
+52 55 52 64 49 22
marketing@axson.com.mx
axson.com.mx

JAPAN
+81 564 26 25 91
sales.japan@axson.com
axson.jp

CHINA
+86 21 58 68 30 37
marketing.china@axson.com
axson.cn

INDIA
+91 20 25560710
info.india@axson.com
axson.com