

## DESCRIPTION

Bonding of parts in large series, bonding of body elements (spoiler, tailgate...) made of composite (SMC, RTM, BMC, ..) or thermoplastics materials (ABS, PP, PC/PET, ASA, ...). Design to bond dissimilar materials with high CTE gap.

## PROPERTIES

- Two component room temperature cure polyurethane adhesive
- Non sagging paste product suitable for vertical applications and to fill irregular joints
- Fast setting product adapted to reduce assembly time
- Excellent vibrations, impacts and noise damping
- Excellent behaviour at low temperatures
- High cure speed in temperature
- 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 volume at 25°C	100	100		
Colour	Black	Clear amber	Black	
Viscosity at 25°C, Pa.s <sup>(AKP)</sup>	12,5	32	-	LT-001
Density at 25°C <sup>(AKP)</sup>	1.40	1.10	-	LT-020
Density of cured product at 23°C	-	-	1.26	ISO 2781
Pot life on 25g at 23°C, min <sup>(AKP)</sup>	-	-	5	LT-002-B
Open time at 23°C on 6-7 mm bead, min	-	-	4.5 – 5.5	LT-006-B
Open time at 35°C on 6-7 mm bead*, min	-	-	3.5 *	

\* Room temperature, Adhesive and substrates are used at 35°C for open time measure.

(AKP): Axson Key Properties. These values are enclosed in COA delivered with each batch.

MECHANICAL PROPERTIES			
Hardness* <sup>(AKP)</sup>	Shore A	60	LT-022
Tensile strength	MPa	3	ISO 37
Elongation at break	%	350	
Tensile Modulus at 10% elongation	MPa	1	
Working temperature**	°C	-40 ; +80	LT-006-B

\*Cured 24H at 23°C, measured at 7 seconds.

\*\* 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

At 23°C	90	min	LT-006-B
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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 40°C)

Lap Shear Strength on sandblasted Aluminium 2017A After 16H at 40°C + 8H at 23°C <sup>(AKP)</sup>	≥ 5 CF	MPa	LT-006-B
Lap shear strength on flame treated Polypropylene *	4 CF		
Lap shear strength on flame treated Polypropylene at 80°C *	2 CF		
Lap Shear Strength on flame treated Polypropylene after 1 week moist cataplasms at 70°C*	2.5 CF		
Floating roller Peel strength	10 CF	N/mm	ISO 4578

(AKP): Axson Key Properties. These values are enclosed in COA delivered with each batch.

\* Flame treatment parameters: speed of 900mm/s to 90mm to the flame. Ratio/flow rate : Qair 335 L/min – Qgaz 14.5 L/min.

CF: Cohesive Failure according to EN ISO 10365 standard.

## HANDLING PRECAUTIONS

It is recommended to use the product at a temperature between +18°C and +35°C. 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 A257 and ADEKIT H6257BK is **6 months**, stored in their original unopened packaging at a temperature between +5°C and +30°C.

## 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.