

DESCRIPTION

Bonding of large composite parts (RTM, SMC, GRP, Laminate), metallic structures, plywood for application requiring high performances and flexibility in transport industries (truck, bus) and Marine (hull bonding, deck bonding, interior design). Exist in 2 cure speeds.

PROPERTIES

- Non sagging paste product with gap fill up to 30mm in vertical and ceiling application; 60mm in horizontal
- **Exist in grey, black for Carbon bonding, clear green and white.**
- Excellent strength to dynamic loads (vibration and impact)
- Odor and solvent free
- Long open time with reduced handling time
- Usable with dispensing machines equipped with pressure vessels.

PHYSICAL PROPERTIES					
Composition		Polyol	Isocyanate	MIX	Method
Mix ratio by weight		92	100		
Mix ratio by volume		100	100		
Colour*	A236	-25 -120	Clear grey/Black Clear blue/White	Beige	Grey/Black Green/White
Density at 25°C* (AKP)					
Density on cured product at 23°C**					
		-25 -120	1.29*	1.40*	1.34** 1.35**
Viscosity at 25°C, Pa.s (AKP)					
		-25 -120	210* 95**	55*	Thixotropic paste
Open Time on Polyester Composite, 7 mm diameter bead at 23°C, min					
		-25 -120	-	-	25 120
Flow threshold on bead, % (AKP)					
			-	-	< 5
Working Temperature					
			-	-	-40°C to 120°C
					LT-020* ISO 2781**
					LT-001* LT-063 / 9s⁻¹ **
					LT-006-B
					LT-017/ Comb-shaped spatula of 40 mm

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

*Colour can change with light exposure.

MECHANICAL PROPERTIES

Hardness, Shore D* (AKP)	55	ISO 868
Tensile strength, MPa **	12	ISO 527
Elongation at break, % **	60	
Young Modulus, MPa **	84	
Recommended use temperature, °C	15 - 35	-
Working temperature, °C ***	-40 à 120	LT-006-B

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

*Cured 24H at 23°C

**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	A236-25	3h30	h/min	LT-006-B
	A236-120	6h		
At 40°C	A236-25	1h30		
	A236-120	3h		
At 60°C	A236-25	30 min		
	A236-120	50 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	Initial	16 CF/SCF	MPa	LT-006-B
	After wet cataplastm 7 days 70°C/100% RH	15 AF/CF		
Stainless steel 304 sandblasted	Initial	18.5 SCF		
	After wet cataplastm 7 days 70°C/100% RH	18.5 SCF /AF 20%		
Electro galvanized steel sandblasted		13 AF		
Electro galvanized steel Acetone wipe		16.5 CF		
ABS Sanded + Isopropanol		3 SF		
PC Sanded+Isopro.+Plast.Prim*		2.5 AF		
PVC Sanded+Isopro.+Plast.Prim*		5 SF		
PMMA Sanded + Isopropanol wipe		5 SF		
PA6E Sanded+Isopro.+Plast.Prim*		2.5 SF		
GFR Polyester Isopropanol wipe		8 DF		

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

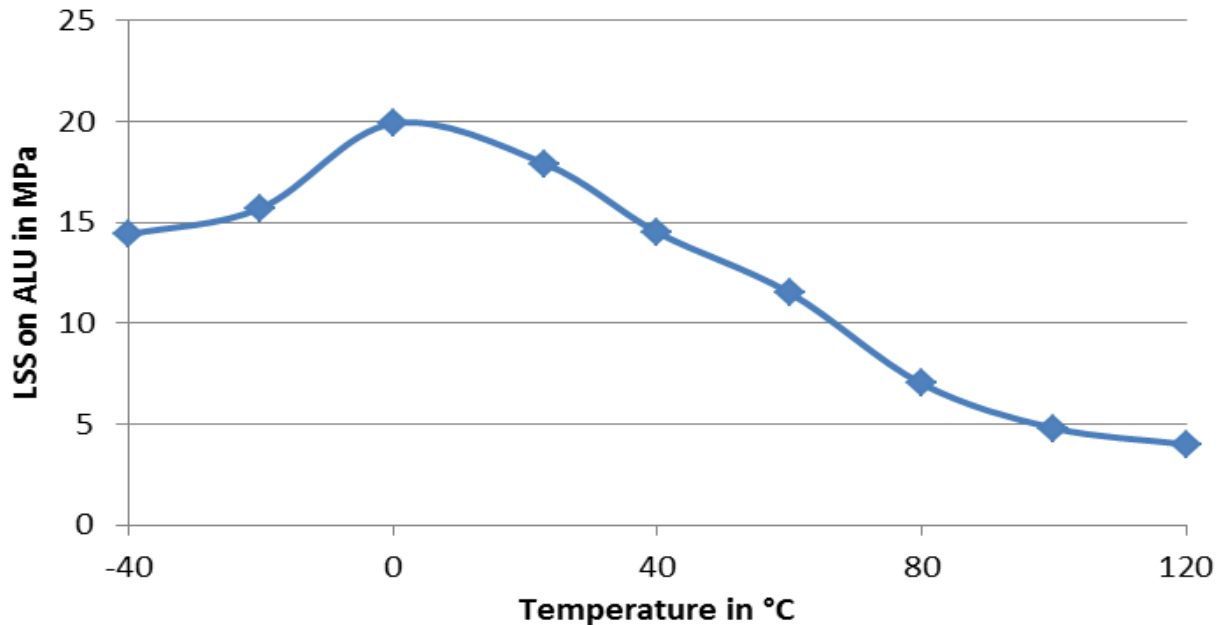
DF: Delamination Failure, according to EN ISO 10365 Standard.

*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				
Aluminium 2017A sandblasted		5	KN/m	ISO 4578

Lap Shear Strength on ALU versus Temperature



EQUIPMENT

ADEKIT A236-25 and A236-120 packaged in 400 ml cartridges require a 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. Please consult our Technical Support and refer to the technical data sheet about surface preparations to choose adapted degreaser or cleaner.

Wet Lay- up Polyester or Vinyl ester must be primed or grinded prior to bonding.

Infused Polyester or Vinyl ester: remove the peel ply just before bonding.

HANDLING PRECAUTIONS

It is recommended to use the product at a temperature between +15°C and +35°C.

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

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

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



BUILDING TRUST



ADEKIT A 236 ADEKIT H 6236

**POLYURETHANE ADHESIVE
FOR LARGE COMPOSITE PARTS BONDING**

STORAGE CONDITIONS

Shelf life of **ADEKIT A236-25 and A236-120** is **9 months** stored in their original unopened packaging at a temperature between +15°C and +25°C.

Shelf life of **ADEKIT H6236-25 and H6236-120** is **9 months** stored in their original unopened packaging at a temperature between +15°C and +25°C.

Shelf life of **ADEKIT H6236 Isocyanate** is **9 months** stored in their original unopened packaging at a temperature between +15°C and +25°C.

PACKAGING

A236-25	Box of 12 cartridges
A236-120	Box of 12 cartridges
H6236-25 Polyol / H6236 Isocyanate	28Kg Polyol + 30Kg Isocyanate
H6236-120 Polyol / H6236 Isocyanate	5.5Kg Polyol + 6Kg Isocyanate 28Kg Polyol + 30Kg Isocyanate
A236-120 WE* Polyol	28.5 Kg

*A236-120 White Polyol

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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