

# ADEKIT A171-1

# ADEKIT H9971-1

EPOXY ADHESIVE

High Performances – SELF EXTINGUISHING

*Temporary Technical Data Sheet*

BUILDING TRUST



## DESCRIPTION

Bonding inserts in honey comb structures, bonding composite structure in aeronautics, bonding structures requiring good flame resistance

## PROPERTIES

- 2 component high performance room temperature cured epoxy adhesive
- Self-extinguishing according to FAR 25§853 ((a), Amdt 21) and ABD0031 (issue G)
- Slow-setting product adapted to cover and bond wide surfaces
- Suitable for edgewise assemblies
- Excellent mechanical and thermal performances up to 100°C
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition	RESIN	HARDENER	MIXED	METHOD
Mix ratio by weight	100	100		
Mix ratio by volume at 25°C	100	100		
Aspect	Thixotropic paste	Thixotropic paste	Thixotropic paste	
Colour	white	beige	clear beige	
Viscosity at 25°C, Pa.s	90	220	130	LT-001
<b>Density at 25°C (KP)</b>	<b>1.24</b>	<b>1.23</b>	-	<b>LT-020</b>
Density of cured product at 23°C	-	-	1.23	LT-047
<b>Pot life on 100 g at 25°C, min (KP)</b>	-	-	<b>37</b>	<b>LT-002-C</b>
Open Time on 7 mm bead at 23°C, min	-	-	45 - 50	LT-006-B

(KP): Key Properties. These values are included in Certificate Of Analysis.

## MECHANICAL PROPERTIES

<b>Hardness, Shore D*</b>	<b>83</b>	<b>LT-022</b>
<b>Tensile strength, MPa *</b>	<b>30</b>	<b>ISO 527</b>
<b>Elongation at break, % *</b>	<b>3</b>	
<b>YOUNG Modulus, MPa *</b>	<b>2500</b>	
<b>Recommended application temperature, °C</b>	<b>15 - 35</b>	-
<b>Working temperature, °C **</b>	<b>-40 à 100</b>	<b>LT-006-B</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.

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## HANDLING TIME

Handling Time			
At 23°C	6h30	h/min	LT-006-B
At 40°C	2h50	h/min	
At 60°C	1h	h	

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	22.5 CF	MPa	LT-006-B
	After wet cataplasm 7 days 70°C/100% RH	17 CF		
Stainless Steel 304 sandblasted		23 CF		
Electro galvanised Steel sandblasted		26 SCF		
Electro galvanised Steel Acetone wipe		21 SCF/AF		
ABS Sanded + Isopropanol		2 AF		
PC sanded+ Isopro+Plast prim*		2.5 AF		
PVC Sanded + Isopropanol		7 SF		
PMMA sanded + Isopro+Plast.prim*		3.5 SF		
PA6E Sanded + Isopropanol		4.5 SF/AF		

AF: Adhesive Failure  
CF: Cohesive Failure  
SCF: Special Cohesive Failure  
SF: Substrate Failure, according to EN ISO 10365 Standard.

\*Plastics sanded, Isopropanol wipe and coated with Sika Advanced Resins Plastic primer 5069.

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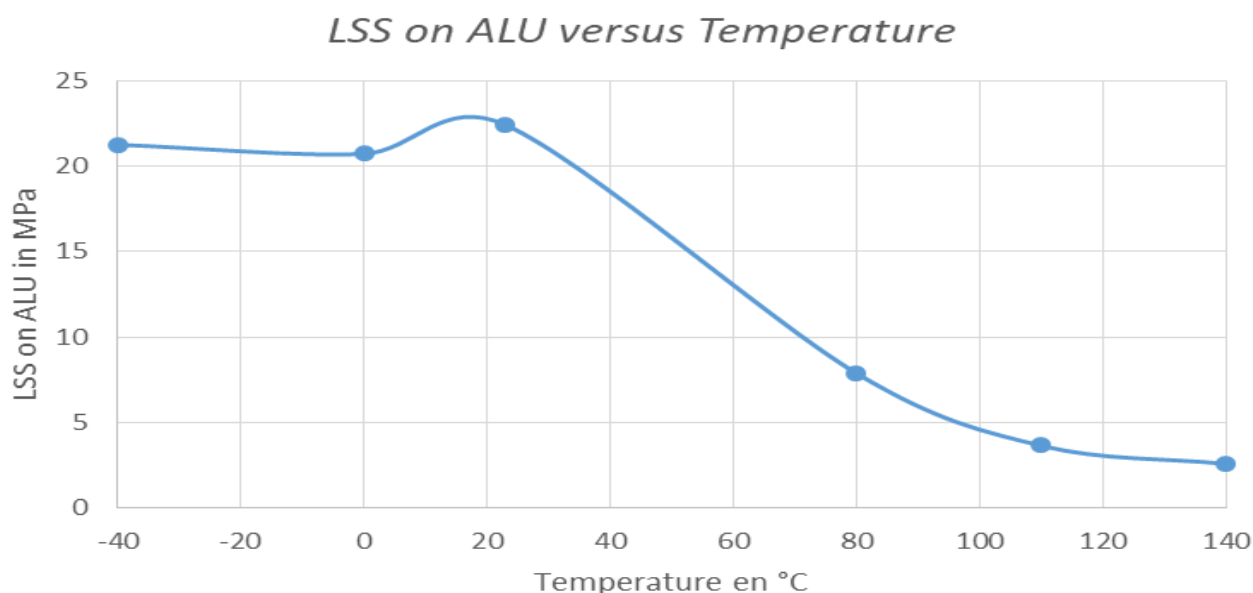
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Floating roller Peel strength at 23°C				
Aluminum 2017A sandblasted		4	KN/m	ISO 4578

## Lap Shear Strength versus Temperature



## EQUIPMENT

ADEKIT A 171-1 is packaged in 400 ml cartridges and require 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 to choose adapted degreaser or cleaner.

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## 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 A171-1 and H9971-1 is **12 months** stored in their original unopened packaging at a temperature between +15°C and +25°C.

## PACKAGING

A171-1 BG/ 400ml	Box of 12 cartridges
H9971-1 Resin	25 Kg
H9971-1 Hardener	25 Kg

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## GUARANTEE

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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