

PRODUCT OVERVIEW SELECTOR GUIDE

BUILDING TRUST



++ Very well + Well 0 Medium

Ref.	Application, description	Colour	Liquid	Viscous	Pasty	Open time	Hardness (shore)	Viscosity (Pa.s.)	Handling time HT 23°C / HT 60°C	Lap shear strength on alu (MPa)	Peel resistance (kN/m)	Elongation at break (%)	Substrates							Resistance					Ref.	50 ml	400 ml	Other sizes	Industrial packages		
													Ferrous metals	Non ferrous metals	Composites, laminates	Thermoplasts	Glass, ceramics	Foam materials (PU, PS)	Elastomer, rubber	Polyurethane (hard)	Temperature	Chemically	Water	Shear stress						Peel stress	Ageing
POLYURETHANE																															
A 210	Bonding of bodywork, metallic structures (racing vehicles and aeronautics), of inserts and composite structures.				X	60'	93A	thixo	5h	10	5	80	0	+	++	+	+	+	+	+	+	++	+	+	+	A 210	X	X			
A 211	For electronic components bonding. Self-extinguishing adhesive with FAR 25.853.				X	40'	95A	thixo	4h	10	9	80	0	+	++	+	+	+	+	+	+	++	+	+	+	A 211	X				
A 220	Excellent for vibration, impact and noise dampening. Excellent behavior at low temperature. Product adapted to assemblies involving dissimilar materials with regular glue thickness. Impact resistance: 30 N/mm.				X	15'	48D	150	60' (15')	16	12	95	0	+	++	+	+	+	+	+	+	++	++	++	+	A 220	X	X		Kit & drum: H 6220	
A 230 A 231	Bonding of composite parts (RTM, SMC, laminate,...) & metallic structures. High strength & high peel combined with flexibility. Suitable for vertical applications and to fill irregular joints.			X	6' 4'	70D	thixo	35' (10') 20' (6')	15	6	30	++	++	++	+	0	+	0	++	+	+	++	++	+	+	A 230 A 231		X		Drum: H 6230 H 6231	
H 6235	Large dimensions assembly. Gap filling capacity. Used in industry assembling big parts.				X	40'	80D 45D	100	2h	19	6	10 25	++	++	++	+	0	++	0	+	+	0	++	++	+	H 6235				Drum	
A 236	Allows gaps up to 40mm and parts assembly with large dimensions (deck/hull, wind mill). Various reactivities and colours. Machine or hand mix version.				X	25' 120'	55D	pasty	3,5h 6h	16	5	60	++	++	++	0	0	++	0	+	+	++	++	+	++	A 236		X		Drum: H 6236 ready to mix kit	
A 252	Non sagging paste product suitable for vertical applications and to fill irregular joints. Fast setting product to reduce assembly time. High flexibility. Impact Resist: 50 N/mm.				X	4'	75A	600	60' (10')	12	9	300	0	+	++	+	++	+	++	+	0	0	++	0	++	A 252	X	X		Drum: H 6252	
A 256	Recommended for plastics bonding sensitive to the phenomenon of bond line witness marks (composite, thermoplastic). Broad spectrum of accession. Available in two reactivities, can be used in thick seal, vertical or ceiling.				X	4' 25'	80A	pasty	90' 5h	5	7	200	+	+	++	++	++	++	++	+	+	0	++	+	++	A 256		X	400 ml	Drum	
A 257	Recommended for the bonding of plastics sensitive to the phenomena of bond line witness marks (composite, thermoplastic). Low hardness. Flexible product. Short handling with limited heating. Impact Resist: 55 N/mm.				X	5'	60A	pasty	90' (2)	5	10	350	+	+	++	++	++	++	0	+	+	++	+	++	++	A 257		X		Drum: H 6257	
A 280 A 290	Structural bonding of spoiler, metallic inserts/big head to composites. Vibration absorbing. Good chemical resistance. Short handling with limited heating. Impact Resist: 30 N/mm.				X	10' 3'	48D	150	45' (10') 10' (4')	16	12	95	+	+	++	+	+	+	+	++	+	++	++	+	A 280 A 290	X	X		Drum: H 6280 H 6290		
A 730	High performance bonding for assembly requiring high modulus and stiffness. White UV stable and sandable. Safe PU.				X	6'	85	20	30'	25	2	10	++	++	++	+	0	0	0	+	+	++	++	+	++	A 730		X	400 ml		
P 4302	High dimension pannels bonding (skin on core), honeycomb (nomex, aluminium, foam thermoplastics,...). Wood, aluminium or metal sheets. 3 Iso combinable (P 4004, 4002, 4003).		X			60' 80'	80D	13 6 3	4h 5h	18	6	5 10 30	++	++	++	+	0	++	0	+	+	0	++	++	+	P 4302				Drum	
METHACRYLATE																															
A 300-1 A 310-1	Excellent mechanical and thermal performances up to 120°C. Multipurpose product with thermoplastic aspect. Product able to bond dissimilar materials.				X	5' 10'	75D	pasty	20' 40'	24	9	30 35	++	++	++	++	0	0	0	0	++	+	++	++	+	++	A 300-1 A 310-1	X	X		Drum
EPOXY																															
A 130 A 135	Fast cure at room temperature. Suitable for injection. Bonding of substrates such as composites, metal, wood, concrete.	Transparent	X	X		6'	75D 85D	45 15	12'	17	1.5	3	+	+	+	0	+	++	0	++	0	0	+	++	0	+	A 130 A 135	X X		200 ml	Kit & drum: H 9930
A 140	Multipurpose with very good mechanical features. Pasty non sagging gap filler material. Impact Resist: 10 N/mm.				X	40'	80D	430	4h30' (30')	20	6	4	++	++	++	0	++	++	0	++	++	+	++	++	+	A 140	X	X		Kit & drum: H 9940/ H9945	
A 145	Liquid adhesive. Long pot life. Excellent mechanical performance and chemical resistance.	Transparent	X			85'	75D	25	7h	22	4	24	+	+	+	+	++	+	+	+	+	++	+	++	+	A 145	X	X			
A 155	Pasty constructive adhesive with long pot life. For large composite parts, repair and maintenance. Good mechanical performance & chemical and temperature resistance. Impact Resist: 15 N/mm.				X	60'	84D	160	10h (1')	35	3	8.5	+	+	++	0	+	++	+	++	++	+	++	++	0	++	A 155		X	400 ml	Drum: H 9955
A 170 A 171	High performances room temperature curing adhesive. Slow setting product adapted to cover and bond wide surfaces. A 171: self-extinguishing adhesive with FAR 25.853.				X	30' 50'	83D	1600 130	3h30'	24 20	5 3	3	++	++	++	0	++	++	+	++	++	+	++	++	+	A 170 A 171		X X		Drum: H 9970 H 9971	
A 175	High performances room temperature curing adhesive. Slow setting product adapted to bond wide surfaces and heavy duty applications subject to impact or vibration. Shock resistant.				X	90'	80D	940	10h (45')	21	4	5	++	++	++	0	++	++	+	++	++	++	++	+	++	A 175		X		Drum: H 9975	
H 9011	Multipurpose liquid adhesive. Bond most of materials. For general industry and maintenance.	Transparent	X			100'	75D	45	7h (30')	24	5	9	++	++	++	+	+	++	+	+	+	++	++	+	++	H 9011	X	X	200 ml	Kit & drum	
H 9950 H 9950T	Non-filled adhesive. High structural performances and low outgassing for aerospace applications. Large sizes bodies, structural and panel bonding. Long open time.			X	X	2h	80D	50 200	4h	15	3	3	++	++	++	0	+	++	0	+	++	++	++	+	++	H 9950 H 9950T				Drum	
H 9951 H 9951T	Non-filled adhesive for bonding large surfaces (ie panels) when mechanical and ageing as well as high peel resistance is needed. T for thixotropic product (hot cure process). Used in railway.		X	X		40'	75D	9 28	6h	26	4	10	++	++	++	+	+	+	0	++	++	+	++	+	++	H 9951 H 9951T				Kit & drum	
H 9952	High shear/peel/ageing resistance. Filled with Nanoparticles. Short handling time with limited heating. Self-extinguishing according to EN 45545-2, FAR 25 (FAR 25.853 @ 60s) and AITM (ABD0031) standards.				X	120'	85D	230	8h (30')	25	5	3	++	++	++	+	0	++	0	+	++	++	++	+	++	H 9952	X	X	400 ml	Drum	