

### DESCRIPTION

Bonding elements of metallic or composite structures, bonding car body, aeronautical application

### PROPERTIES

- 2 component high performance room temperature cured epoxy adhesive
- Non sagging paste product suitable for vertical applications and to fill irregular joints
- Slow setting product adapted to cover and bond wide surfaces
- Excellent mechanical and thermal performances up to 130°C
- Excellent strength to dynamic loads (vibrations and impacts)
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition	RESIN	HARDENER	MIX	Method
Mix ratio by weight	100	90		
Mix ratio by volume at 25°C	100	100		
<b>Colour</b>	<b>Black</b>	<b>Clear Amber</b>	<b>Dark grey</b>	
Aspect	Paste	Paste	Paste	
Density at 25°C (AKP)	1.38	1.20	-	LT-020
Density of cured product at 23°C	-	-	1.30	ISO 2781
<b>Pot life at 23°C on 100g, min (AKP)</b>	-	-	<b>90</b>	<b>LT-002-C</b>
<b>Open time on 7 mm bead at 23°C ,min</b>	-	-	<b>100</b>	<b>LT-006-B</b>

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

### MECHANICAL PROPERTIES

<b>Hardness, Shore D*</b>	<b>80</b>	<b>ISO 868</b>
<b>Tensile strength, MPa **</b>	<b>30</b>	<b>ISO 527</b>
<b>Elongation at break, % **</b>	<b>5</b>	
<b>Young Modulus, MPa **</b>	<b>2500</b>	
<b>Recommended application temperature, °C</b>	<b>15 - 30</b>	<b>-</b>
<b>Working temperature, °C ***</b>	<b>-40 to 130</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.

### HANDLING TIME

Handling time			
At 23°C	10	H	LT-006-B
At 40°C	2	H	
At 60°C	45	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		20 CF	MPa	LT-006-B
	After wet cataplastm 7days 70°C/100% RH	19 CF		
	After 15 cycles D3**	20 SCF		
	After 3 weeks immersion in :			
	Motor oil at 70°C	19 CF		
	Hydrochloric acid (0.1 N) at 23°C	20 CF		
	Soda (0.1N) at 23°C	20 CF		
	Seawater at 23°C	20 CF		
	Gasoil at 23°C	20 CF		
Gas at 23°C	20 CF			
Stainless Steel 304 sandblasted		21 CF		
	After wet cataplastm 7 days at 70°C/100% RH	20.5 CF		
Electro galvanised Steel sandblasted		20.5 CF		
Electro galvanised Steel Acetone wipe		16 CF		
ABS Sanded + Isopropanol		4 SF		
PC Sanded + Isopropanol		3 SF		
PVC Sanded + Isopropanol		4.5 SF		
PMMA Sanded + Isopro.+Plastic primer*		1.5 AF		
PAGE Sanded + Isopropanol		2.5 SF		
GFR Polyester Isopropanol wipe		7 DF		

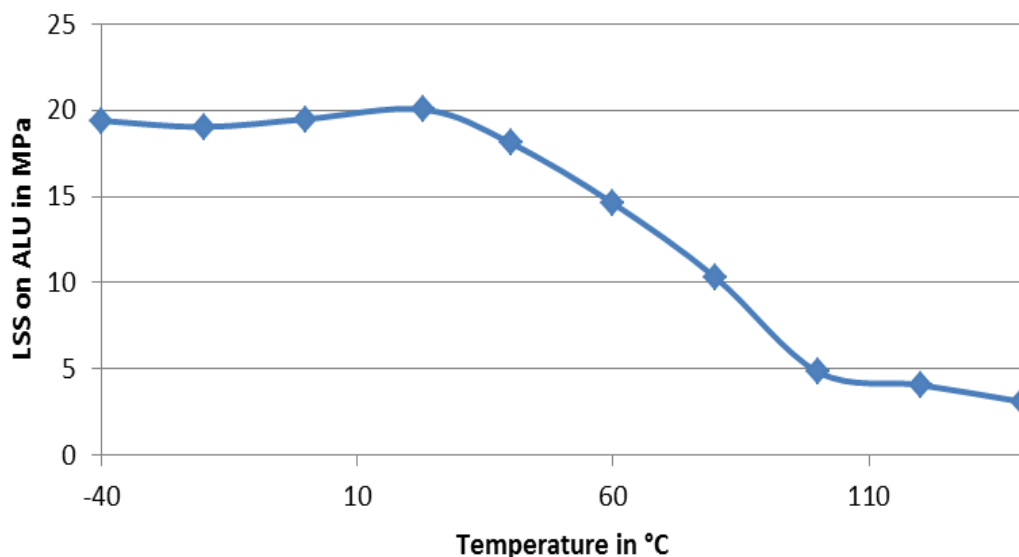
CF: Cohesive Failure, AF: Adhesive Failure, SCF: Special Cohesive Failure, SF: Substrate Failure  
DF: Delamination Failure, according to EN ISO 10365 Standard.

\*Plastic 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				
Aluminum 2017A sandblasted		4	KN/m	ISO 4578

### Lap Shear Strength on ALU versus temperature



## EQUIPMENT

ADEKIT A175 is packaged in 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.



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# ADEKIT A175 ADEKIT H 9975

## STRUCTURAL EPOXY ADHESIVE

### STORAGE CONDITIONS

Shelf life of ADEKIT A175 and of ADEKIT H 9975 POLYOL / H9975 ISOCYANTE is **12 months**, stored in its original unopened packaging at temperature between +15°C and +25°C.

### PACKAGING

A175 / 400ml	Box of 12 cartridges
H9975 Resin & H9975 Hardener	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.*

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