

## DESCRIPTION

Maintenance or diverse repairs, metal, glass, wood and plastic bonding, fancy jewels, bonding of decontamination filters.

## PROPERTIES

- 2 component room temperature cure liquid epoxy adhesive
- Liquid product suitable for injection
- Unfilled product suitable for transparent assemblies
- Fast setting product adapted to reduce assembly time
- Excellent mechanical performances

### PHYSICAL PROPERTIES

| Composition  | RESIN              | HARDENER                       | MIXED              | Method          |
|--|--------------------|--------------------------------|--------------------|-----------------|
| Mix ratio by weight                                  | 100                | 100                            |                    |                 |
| Mix ratio by volume at 25°C                          | 100                | 100                            |                    |                 |
| <b>Colour</b>  | <b>Clear amber</b> | <b>Yellow</b>                  | <b>Yellow</b>      |                 |
| <b>Viscosity at 25°C, Pa.s</b>                       | <b>11 - 14</b>     | <b>15 – 31<sup>(AKP)</sup></b> | -                  | LT-001          |
| Density at 25°C                                      | 1.16               | 1.14                           | -                  | LT-020          |
| <b>Pot life at 23°C on 100g, min<sup>(AKP)</sup></b> | -                  | -                              | <b>4'30 – 5'30</b> | <b>LT-002-B</b> |
| <b>Open time on 7mm bead at 23°C, min</b>            | -                  | -                              | <b>5 - 6</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>85</b>         | <b>LT-022</b>   |
| <b>Tensile strength, MPa *</b>                 | <b>54</b>         | <b>ISO 527</b>  |
| <b>Elongation at break, % *</b>                | <b>3.5</b>        |                 |
| <b>Young Modulus, MPa *</b>                    | <b>3400</b>       |                 |
| <b>Recommended application temperature, °C</b> | <b>15 - 25</b>    | -               |
| <b>Working temperature, °C **</b>              | <b>-40 to 120</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       | 12 | min | LT-006-B |

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<br>sandblasted           |   | 17.5 AF | MPa<br>LT-006-B |
|  | After wet cataplasma 7days 70°C/100% RH     | 14 AF   |                 |
|  | After 15 cycles D3**                        | 14 AF   |                 |
| Stainless Steel 304<br>sandblasted       |   | 20 AF   |                 |
|  | After wet cataplasma 7 days at 70°C/100% RH | 17 AF   |                 |
| Electro galvanised Steel<br>sandblasted  |   | 17.5 AF |                 |
| Electro galvanised Steel<br>Acetone wipe |   | 11.5 AF |                 |
| ABS<br>Sanded + Isopropanol              |   | 3.5 SF  |                 |
| PC<br>Sanded + Isopropanol               |   | 4 SF    |                 |
| PVC<br>Sanded + Isopropanol              |   | 5 SF    |                 |
| PMMA<br>Sanded + Isopropanol             |   | 4 SF    |                 |
| PAGE<br>Sanded + Isopro.+Plastic primer* |   | 2 AF    |                 |
| GFR Polyester<br>Isopropanol wipe        |   | 7 DF    |                 |
| GFR Epoxy<br>Isopropanol wipe            |   | 13 AF   |                 |

AF: Adhesive Failure,

SF: Substrate Failure,

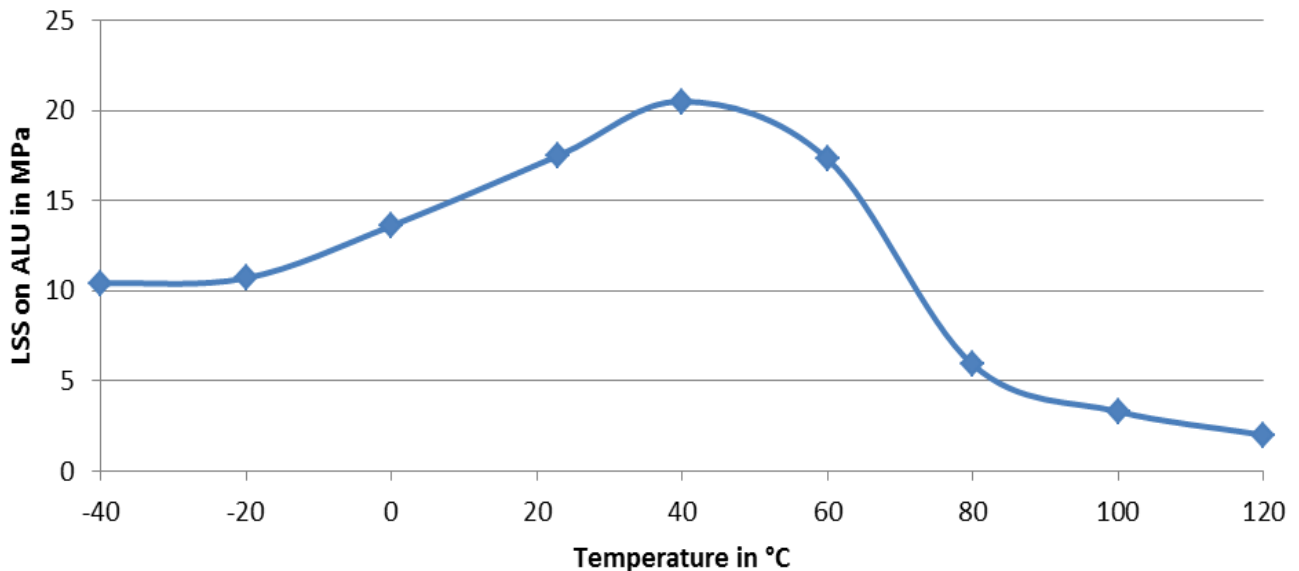
DF: Delamination Failure, according to EN ISO 10365 Standard.

\*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<br>sandblasted         |  | 1.5 | KN/m | ISO 4578 |

## Lap Shear Strength on Aluminium versus Temperature



## EQUIPMENT

ADEKIT A135 is packaged in 50 ml cartridges and requires a manual or pneumatic gun. Please consult our tec 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.



BUILDING TRUST



# ADEKIT A 135

# ADEKIT H 9935

EPOXY ADHESIVE, MULTIPURPOSE, QUICK SETTING, LIQUID

## STORAGE CONDITIONS

Shelf life of ADEKIT A135 and H9935 Resin and Hardener is **12 months** stored in its original unopened packaging at a temperature between +15°C and +25°C.

## PACKAGING

|                              |                                     |
|------------------------------|-------------------------------------|
| A130 / 50ml                  | Box of 12 cartridges                |
| H9935 Resin & H9935 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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