

DESCRIPTION

Bonding of bodywork, bonding of metallic structures (racing vehicles aeronautics), bonding of insert and composite structure.

PROPERTIES

- 2 component room temperature cure polyurethane adhesive
- Non sagging paste product suitable for vertical applications and to fill irregular joints
- Slow setting product adapted to cover and bond big surfaces
- Excellent vibrations, impacts and noise damping
- Excellent behaviour at low temperature
- Product adapted to assemblies involving dissimilar materials
- Excellent mechanical performances and ageing
- Excellent strength to dynamic loads (vibrations and impacts)
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition	POLYOL	ISOCYANATE	MIX	METHOD
Mix ratio by weight	100	67		
Mix ratio by volume at 25°C	100	100		
Colour	Grey *	Pale amber	Grey *	
Aspect	Paste	Thixotropic liquid	Thixotropic paste	
Density at 25°C ^(AKP)	1,70	1,08	-	LT-020
Pot life at 23°C on 100g, min ^(AKP)	-	-	40 - 50	LT-002-B
Open time (min)	-	-	60	

*Due to the Polyol chemical nature, some colour variations, from Beige to Green, might be observed but they don't affect product performances.

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

MECHANICAL PROPERTIES

Hardness, Shore A* ^(AKP)	92	LT-022
Tensile strength, MPa **	6	ISO 527
Elongation at break, % **	80	
Use temperature, °C	15 à 35	-
Working temperature, °C	-40 à 100	LT-006-B

*Cured 2H at 80°C

**Cured 16H at 70°C

ADEKIT A 210 ADEKIT H 6210

POLYURETHANE ADHESIVE
LONG POT LIFE

HANDLING TIME

Handling Time			
At 23°C	5	hour	LT-006-B

Handling time is defined as the time needed to obtain Lap Shear Strength on Aluminum at 23°C, of 1M

MECHANICAL PROPERTIES ON ASSEMBLIES (Cured 16H at 70°C)

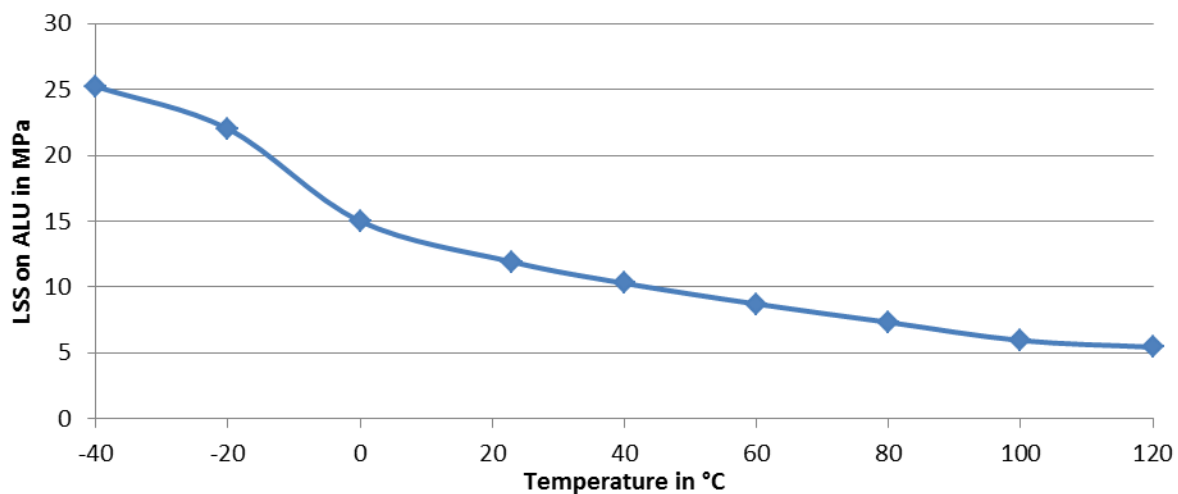
Lap Shear Strength at 23°C				
Aluminium 2017A Sandblasted	Initial	10 CF	MPa	LT-006-B
	After wet cataplast 15 days at 80°C/100% RH	7 CF		
	After 15 cycles D3*	10 CF		
	After 3 weeks at 100°C	10 CF		
	After 3 weeks immersion in :			
	Motor oil at 70°C	9 CF		
	Hydrochloric acid (0.1N) at 23°C	9 CF		
	Soda (0.1N) at 23°C	6 CF		
	Seawater at 23°C	10 CF		
	Gasoil at 23°C	9 CF		
	Gas at 23°C	6 CF		

CF: Cohesive Failure, according to EN ISO 10365 standard.

*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



ADEKIT A 210 ADEKIT H 6210

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EQUIPMENT

ADEKIT 210 packaged in 50 ml and 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.

STORAGE CONDITIONS

Shelf life of ADEKIT A210, H6210 Polyol and H6210 Isocyanate is **12 months** stored in its original unopened packaging at a temperature between +15°C and 25°C.

PACKAGING

A210/ 50ml	A210/ 400ml	H 6210
12 cartridges	12 cartridges	(27 + 42) kg

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