

DESCRIPTION

- *Adekit H9952 is a high performances two components epoxy adhesive, especially formulated to bond high dimensions surfaces and providing high level of mechanical and aging properties.*
- *Nano enhanced systems*
- *Self extinguish*
- *Contains 200µm bead to calibrate adhesive thickness*
- *High shear and peel*
- *Long open time for big parts assembly*

PROPERTIES

- *High performances assembly*
- *Bonding of panels: honeycomb, aluminium sheet, stainless-steel sheet, composite materials, wood, thermoplastics, foam...*
- *Bonding of Carbon & glass epoxy composite, Polyester composite, metal structure*

PHYSICAL PROPERTIES				
Composition		RESIN	HARDENER	MIXED
Mix ratio by weight		100	47	-
Mix ratio by volume at 25°C		100	50	-
Aspect		Thick liquid	Thick liquid	Thick liquid
Colour		Black	Beige	Black
Viscosity @ 25°C 10tr (Pa.s)	BROOKFIELD	150	220	90
Viscosity @ 25°C 2.5tr (Pa.s)	BROOKFIELD	350	650	200
Specific gravity at 25°C (g/cm ³)	ISO 1675	1,40	1,30	-
Mixed adhesive specific gravity at 23°C	ISO 2781	-	-	1,38
Pot life at 25°C on 100 g (min)	Gel Timer TECAM	-	-	120

MECHANICAL AND THERMAL PROPERTIES (1)			
Hardness	ISO 868	Shore D	85
Tensile strength	ISO 527	MPa	42
Elongation at break	ISO 527	%	3
Working temperature *	AXSON method	°C	-40 ; + 150

(1) Curing conditions : 16h at 70 °C

*working temperature is defined as the temperature in which product still exhibits Lap Shear Strength value on Aluminium, measured at 23 °C, of 1 MPa or 10% of initial Lap Shear Strength value on Aluminium, measured at 23 °C, after 1000 hours exposure at this temperature.

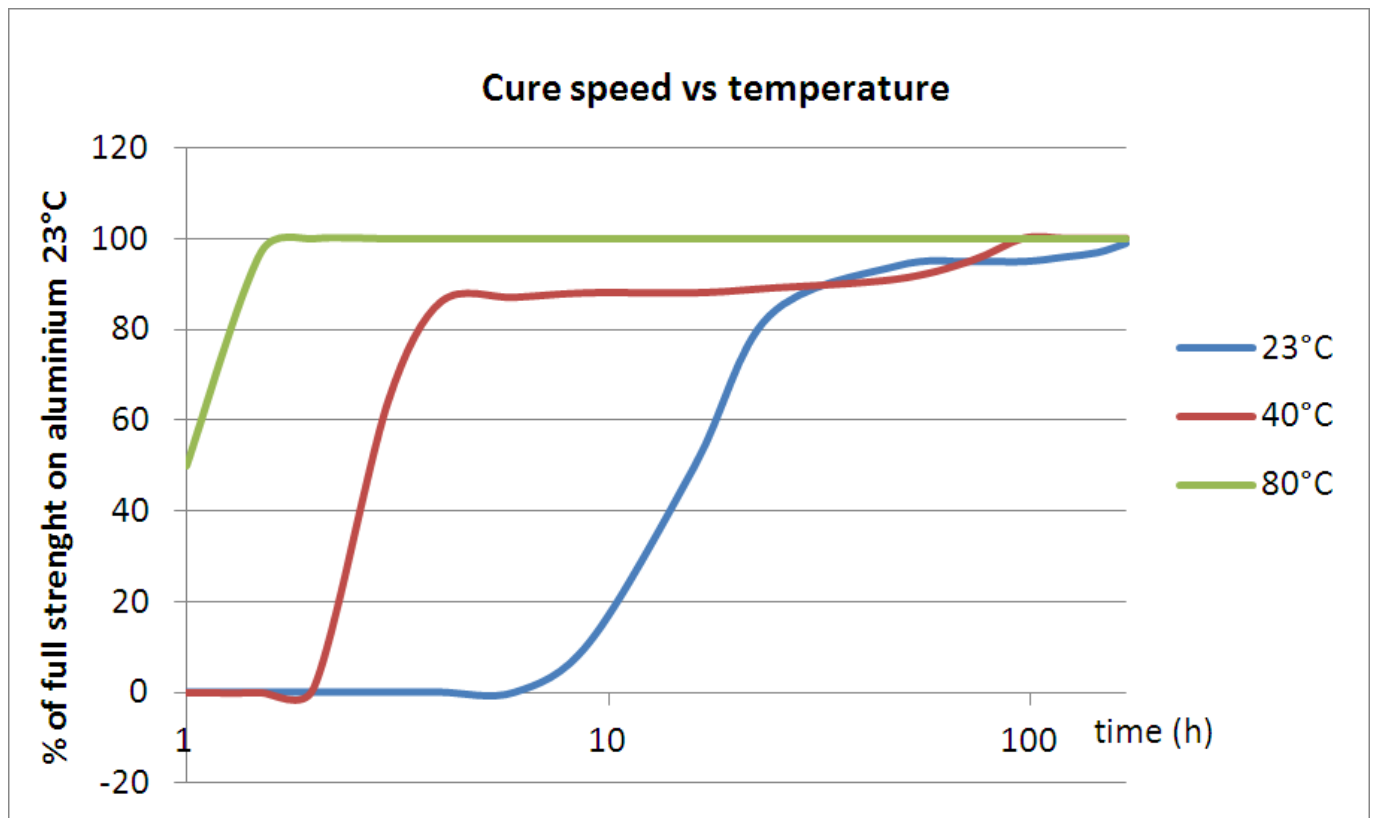
EQUIPMENT

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. Please consult our technical support and refer to the technical data sheet about surface preparations to choose adapted degreaser or cleaner.

CURING PERFORMANCE



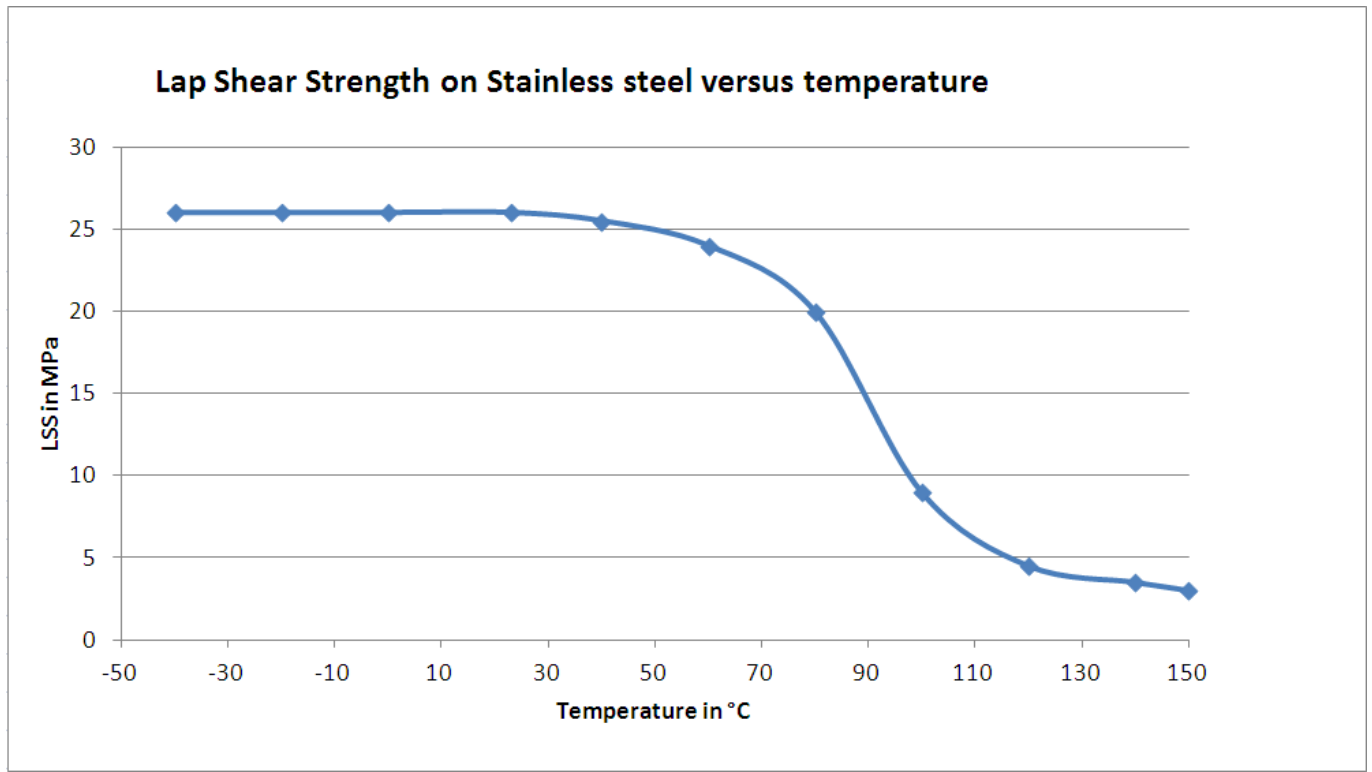
MECHANICAL PROPERTIES ON ASSEMBLIES (1)				
Handling time (2)		ISO 4587	h	6-8
Lap Shear Strength		ISO 4587	MPA	
<i>Stainless steel 304 sandblasted</i>	at 23°C			26 SCF
	after moist cataplasms at 70°C and 100% RH: 1 week			24 SCF
<i>Aluminium 2017A sandblasted</i>	à 23°C			22 SCF
	after moist cataplasms at 70°C and 100% RH: 1 week			22 SCF
	2 weeks			20 SCF
	3 weeks			17 SCF
4 weeks	17 SCF			
<i>Electrogalvanised Steel sandblasted</i>	at 23°C	22 AF		
<i>Carbon Pre-preg Composite</i>	at 23°C	17 SCF		
<i>Polyamide</i>	at 23°C	5 SF		
Floating roller peel strength		ISO 4578	KN/m	
<i>Aluminium 2017A sandblasted</i>	at 23°C			5
	after moist Cataplasms at 70°C et 100% RH: 1 week	4.5		

(2) Handling time is defined as the time needed to obtain Lap Shear Strength on Aluminium, at 23 °C of 1 MPa.

SCF: Special Cohesive Failure

AF: Adhesion Failure

SF: Substrate Failure, according to ISO 10365.



HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

For further information, please consult the product safety data sheet.

STORAGE CONDITIONS

Shelf life of ADEKIT H9952 is 24 months in a dry place and in their original unopened containers at a temperature between 15 and 25 °C

Any open can must be tightly closed under dry nitrogen.

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.