

STRUCTURAL EPOXY ADHESIVE

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MULTI-APPLICATION

DESCRIPTION

- Multi-application
- Bonds most of commonly used materials

TECHNOLOGIES

- Good resistance to dynamic loads and shocks
- Low shrinkage

PROPERTIES

- · Bonding of several metals, ceramic, glass, rubber, rigid plastics
- Bonding of commonly used materials
- Suitable for most of industrial and artisanal applications

PHYSICAL PROPERTIES							
Composition		RESIN	HARDENER	MIXED			
Mix ratio by weight Mix ratio by volume at 25 <i>°</i> C		100 100	80 100				
Colour		neutral	light amber	light yellow			
Viscosity at 25℃ (Pa.s)	ISO 3219	25-50	20-35	30-50			
Density at 25 °C Density of cured product at 23 °C	ISO 1675 : 1985 ISO 2781 : 1996	1,16 -	0,96	- 1,07			
Pot life at 25 ℃ on 100 g (min)	Gel Timer TECAM	-	-	100			

MECHANICAL PROPERTIES at 23 °C (1)						
Glass transition temperature (Tg)DSC°C. 40						
Tensile strength	ISO 527 : 1993	MPa	30			
Elongation at break	ISO 527 : 1993	%	9			
Working temperature*	Axson method	°C	-40;120			

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

SURFACE PREPARATION

ADEKIT H 9011 must be applied on dry and clean surfaces, free from contaminants (grease, dust...). To choose a degreasing or an adapted primer, please consult our technical service and refer to our sheet about surface preparation.

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ADEKIT H 9011



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	MECHANICAL PROPERTIES ON ASSEM	BLIES (1)		
Handling time (2)				
at 23°C				7H
at 40°C				2H
at 60°C				30 min
at 100°C				6 min
Lap Shear Strength				
	at 23°C			19 AF
Aluminium 2017A	at 23°C (cured 16H at 70°C)			24 AF
sandblasted	after moist cataplasm at 70°C and 100% RH:			
	1 week			17 AF
Inox 304 sandblasted	at 23°C			21 AF
Galvanised Steel sandblasted	at 23°C	ISO 4587	587 MPa	21 AF
Polycarbonate*	at 23°C			5 AF
ABS*	at 23°C			3 AF
Polyamide*	at 23°C			4.5 SF
Carbone pre-pregComposite*	at 23°C			15 AF
Floating roller Peel stren	gth			
Aluminium 2017A sandblasted at 23°C		ISO 4578	KN/m	5

(1) Curing conditions: 16H at 40 °C

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

*Substrates slightly abraded and Isopropanol wiped

AF: Adhesion Failure SF: Substrate Failure, according to ISO 10365.

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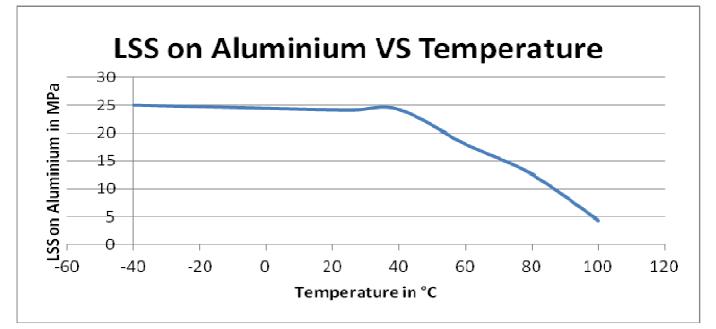
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Curing conditions: 16H at 70 ℃

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 H 9011 is **2 years** in a dry place and in their original unopened containers at a temperature between 15 and 25 $^{\circ}$ C

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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