

DESCRIPTION

- Multi-application
- Bonds most of commonly used materials
- 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		100	80	
Mix ratio by volume at 25 °C		100	100	
Colour		neutral	light amber	light yellow
Viscosity at 25 °C (Pa.s)	ISO 3219	25-50	20-35	30-50
Density at 25 °C	ISO 1675 : 1985	1,16	0,96	-
Density of cured product at 23 °C	ISO 2781 : 1996	-	-	1,07
Pot life at 25 °C 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 °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.

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.

MECHANICAL PROPERTIES ON ASSEMBLIES (1)				
Handling time (2)		ISO 4587		
at 23°C				7H
at 40°C				2H
at 60°C				30 min
at 100°C				6 min
Lap Shear Strength		ISO 4587	MPa	
Aluminium 2017A sandblasted	at 23°C			19 AF
	at 23°C (cured 16H at 70°C)			24 AF
	after moist cataplasma at 70°C and 100% RH: 1 week			17 AF
Inox 304 sandblasted	at 23°C			21 AF
Galvanised Steel sandblasted	at 23°C			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 strength		ISO 4578	KN/m	
Aluminium 2017A sandblasted	at 23°C			5

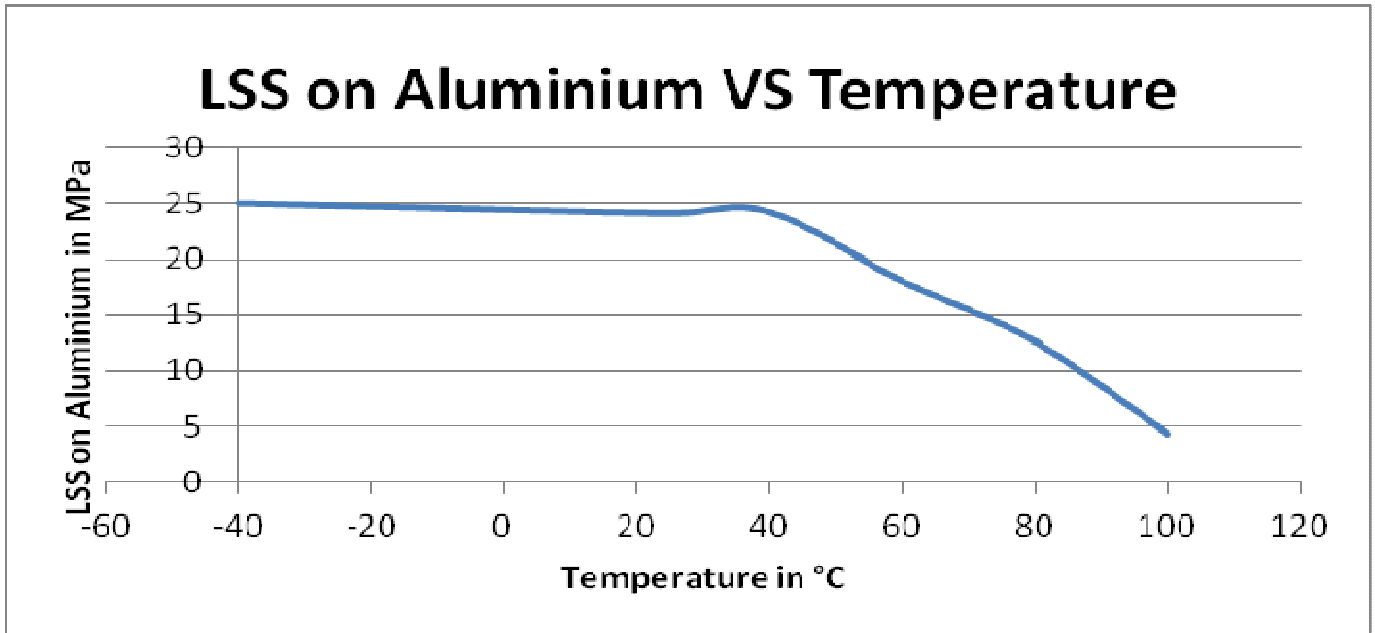
(1) Curing conditions: 16H at 40°C

(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.



Curing conditions: 16H at 70°C

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°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.