



BUILDING TRUST



# ADEKIT A256

**POLYURETHANE ADHESIVE**  
**LOW MODULUS – HIGH FLEXIBILITY**

## APPLICATION

*Flexible bonding. Automotive body parts made of thermoplastics, composite, coated metals. Glazings.*

## PROPERTIES

- Two component Polyurethane adhesive curing at room temperature.
- Non sagging paste product with big gap fill up in vertical application.
- Exists in two reactivity: 5 minutes and 25 minutes Open Time.
- Excellent strength to dynamic loads like vibration, impact and noise nuisance.
- Low elasticity Modulus and high elongation at break, ideal for dissimilar materials assembly.
- Resistant to aging.

PHYSICAL PROPERTIES						
Composition			POLYOL	ISOCYANATE	MIX	METHOD
Mix ratio by volume à 25°C			100	50	-	
Colour			Black	Beige	Black	
Viscosity at 25°C, Pa.s <sup>(AKP)</sup>	A256	-5 -25	75 – 125* 90 – 140*	5 – 15**	-	*LT-001/A7, vit20 **LT-001/A4, vit12
Density at 25°C <sup>(AKP)</sup>	A256	-5 -25	1.37 1.39	1.52	-	LT - 020
Pot life at 23°C on 25g, min <sup>(AKP)</sup>	A256	-5 -25	-	-	2'45'' - 3'45'' 20 - 30	LT-002-B
Open Time on 7 mm bead at 23°C, min	A256	-5 -25	- -	- -	3 - 4 20 - 25	LT-006-B

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



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## MECHANICAL PROPERTIES

Hardness, Shore A* (AKP)	75 - 90	LT-022
Tensile strength, MPa**	4	ISO 37
Elongation at break, %**	150 - 200	
YOUNG Modulus, MPa**	4	ISO 527
Recommended use temperature, °C	15 to 30	
Working temperature, °C***	-40 to 120°C	LT-006-B

\* Cured 2H à 80°C

\*\*Cured 16H à 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	A256-5	90	min	LT-006-B
	A256-25	300		
At 40°C	A256-5	30		
	A256-25	180		
At 60°C	A256-25	100		

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 sandblasted	Initial	5.5 CF	MPa	LT-006-B
	After wet cataplasm 7 days 70°C / 100% RH	1 AF		
	After 15 cycles D3*	ongoing		
Stainless Steel 304 sandblasted		4.5 CF		
	After wet cataplasm 7days 70°C / 100% RH	2 CF		
Electro-galvanized Steel sandblasted		4.5 CF		
Electro-galvanized Steel Acetone wipe		3 CF		
ABS sanded + Isopropanol		2 CF		
PC sanded + Isopropanol		2 SCF		
PVC sanded + Isopr+ plastic primer*		2 AF		
PMMA sanded + Isopropanol		1.5 SCF		
PA6E sanded + Isopropanol		1 SCF		
GFR Polyester Isopropanol wipe		3.5 CF		

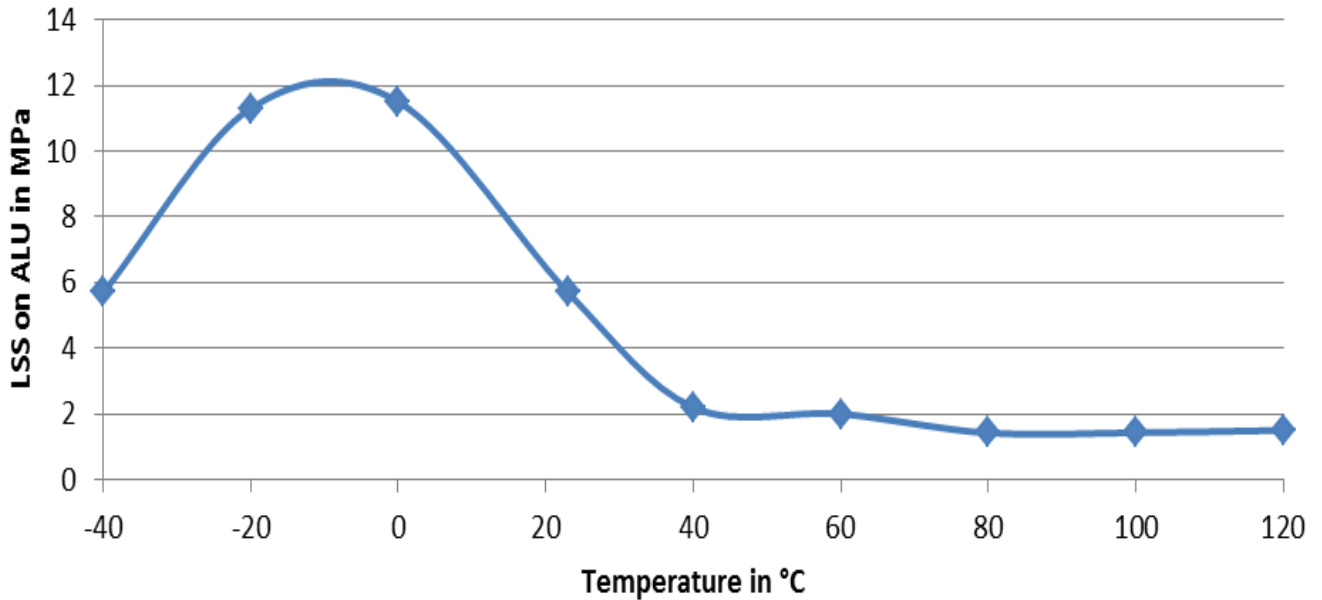
CF: Cohesive Failure, AF: Adhesive Failure, SCF: Special Cohesive Failure, according to EN ISO 10365 Standard.

\*Plastic sanded, Isopropanol wipe 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				
Aluminium 2017A sandblasted		6.5	KN/m	ISO 4578

## Lap Shear Strength on ALU versus Temperature



### EQUIPMENT

ADEKIT A256-5 and A256-25 are packaged in 420 ml cartridges and require 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 about surface preparations

### HANDLING PRECAUTIONS

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

- ensure good ventilation,
  - wear gloves and safety glasses.
- For further information, please consult the product safety data sheet.



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## STORAGE CONDITIONS

Shelf life of **ADEKIT A256-5 and A256-25 in cartridges** is **9 months** in a dry place and in original unopened containers at a temperature between 15 and 25° C.

Shelf life of **ADEKIT A256 ISOCYANATE** is **9 months** in a dry place and in original unopened containers at a temperature between 15 and 25° C.

Shelf life of **ADEKIT A256-5 and A256-25 POLYOL** is **12 months** in a dry place and in original unopened containers at a temperature between 15 and 25° C.

## PACKAGING

<b>A256-5</b>	<b>Box of 12 cartridges</b>
<b>A256-25</b>	<b>Box of 12 cartridges</b>
<b>A256-5 Polyol / A256 Isocyanate</b>	<b>38Kg Polyol + 30Kg Isocyanate</b> <b>235Kg Polyol + 255Kg Isocyanate</b>
<b>A256-25 Polyol / A256 Isocyanate</b>	<b>38Kg Polyol + 30Kg Isocyanate</b>

## GUARANTEE

The information of our technical data sheet are based on our present knowledge and the result of tests conducted 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 refuse any guarantee about 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 guarantee conditions are regulated by our general sale conditions.

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