



BUILDING TRUST



# ADEKIT A155

# ADEKIT H 9955

## STRUCTURAL EPOXY ADHESIVE

### DESCRIPTION

Two component epoxy adhesive whose properties make it the ideal product for bonding large dimension parts for which a high level of mechanical and ageing properties are required.

### PROPERTIES

- 2 component high performance room temperature cured epoxy adhesive
- Non sagging paste product suitable for vertical applications and to fill irregular joints
- Long open time product adapted to cover and bond wide surfaces
- Excellent mechanical and thermal performances up to 130°C
- Excellent strength to dynamic loads (vibrations and impacts)
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition	RESIN	HARDENER	MIX	Method
Mix ratio by weight	100	47		
Mix ratio by volume at 25°C	100	50		
<b>Colour</b>	<b>translucent</b>	<b>white</b>	<b>white</b>	
<b>Viscosity at 25°C, Pa.s (AKP)</b>	<b>50 - 80</b>	<b>120 - 180</b>	-	<b>LT-063</b>
Density at 25°C (AKP)	1.16	1.07	-	<b>LT-020</b>
Density of mixed product at 23°C	-	-	1.12	<b>ISO 2781</b>
<b>Pot life at 23°C on 100g, min</b>	-	-	<b>170</b>	<b>TROMBOMAT</b>
<b>Open Time on 7 mm bead at 23°C, min</b>	-	-	<b>60</b>	<b>LT-006-B</b>

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

### MECHANICAL PROPERTIES

<b>Hardness, Shore D* (AKP)</b>	<b>83</b>	<b>LT-022</b>
<b>Tensile strength, MPa **</b>	<b>53</b>	<b>ISO 527-2</b>
<b>Elongation at break, % **</b>	<b>8.5</b>	
<b>Young Modulus, MPa **</b>	<b>1900</b>	
<b>Recommended use temperature, °C</b>	<b>15 - 30</b>	-
<b>Working temperature, °C ***</b>	<b>-40 to 130</b>	<b>LT-006-B</b>

\*Cured 2H at 80°C, measured at 1 second.

\*\*Cured 16H at 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.



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## HANDLING TIME

Handling time			
At 23°C	10	H	LT-006-B
At 40°C	3H15	H/min	
At 60°C	1	H	

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		22 AF	MPa	LT-006-B
	After wet cataplasme 7days 70°C/100% RH	18 AF		
	After 15 cycles D3*	18 AF		
	After 1 month immersion in :			
	Motor oil at 70°C	18 AF		
Stainless Steel 304 sandblasted		22 AF		
	After wet cataplasme 7 days at 70°C/100% RH	17 AF		
Electro galvanised Steel sandblasted		20 AF		
Electro galvanised Steel Acetone wipe		9 AF		
ABS Sanded+Isoprop.+ Plastic primer*		3.5 SF		
PC Sanded+Isoprop.+ Plastic primer*		4.5 SF		
PVC Sanded+Isoprop.+ Plastic primer*		3 SF		
PMMA Sanded+Isoprop.+ Plastic primer*		1.6 AF		
PAGE Sanded+Isoprop.+ Plastic primer*		3 SF		
GFR Polyester Isopropanol wipe		6.5 DF		
GFR Epoxy Isopropanol wipe		35 SCF/AF		

AF: Adhesive Failure, SCF: Special Cohesive Failure, SF: Substrate Failure,  
DF: Delamination Failure, according to EN ISO 10365 Standard.

\*Plastics sanded, Isopropanol wiped and coated with Plastic primer from AXSON.

\*\*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				
Aluminum 2017A sandblasted		3	KN/m	ISO 4578

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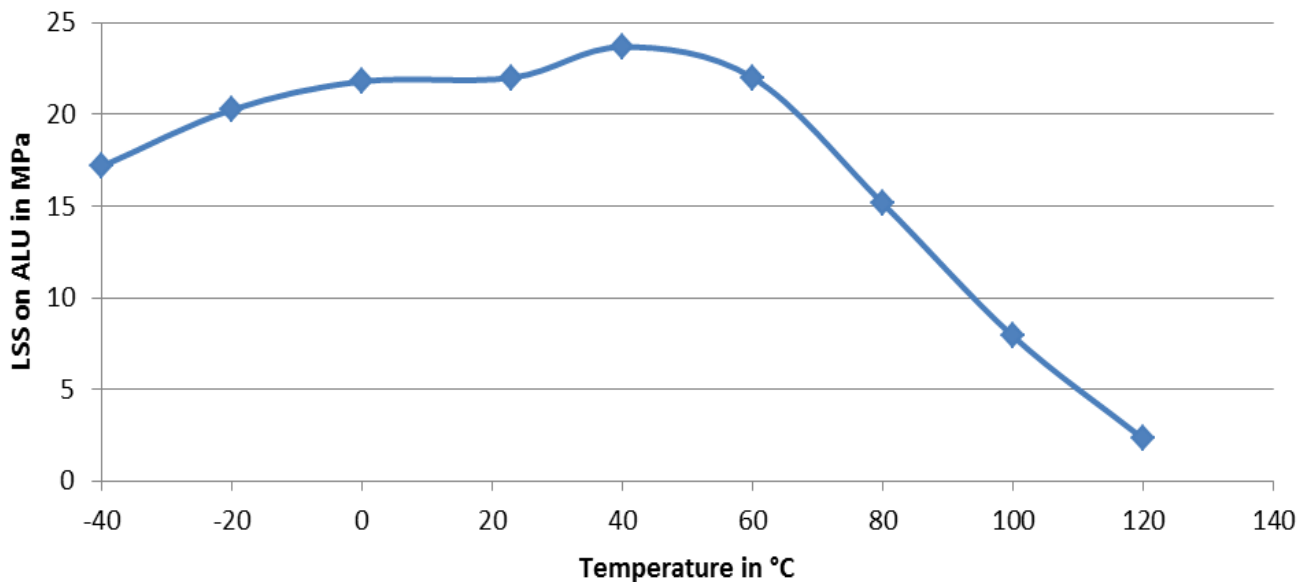
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### Lap Shear Strength on Aluminium versus Temperature



### EQUIPMENT

ADEKIT A155 is packaged in 420 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.



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## STORAGE CONDITIONS

Shelf life of ADEKIT A155, H9955 Resin and Hardener is **12 months** stored in its original unopened packaging at a temperature between +15°C and +25°C.

## PACKAGING

A155 / 420ml	Box of 12 cartridges
H9955 Resin & H9955 Hardener	Please consult our Sales Department

## 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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