

DESCRIPTION

Bonding of composite parts (RTM, SMC, Wet lay up laminate ...) and metallic structures.
The adhesive is a chemical thixotropy system suitable for equipment with pressurized tanks or by gravity.

PROPERTIES

- 2 components high performance room temperature cured polyurethane adhesive.
- Non sagging paste product suitable for vertical applications and to fill irregular joints.
- Fast curing time.
- 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	POLYOL	ISOCYANATE	MIX	Method
Mix ratio by weight	100	78		
Mix ratio by volume at 25°C	100	100		
Colour	Grey beige (GY)	Dark amber	Beige (BG)	
Viscosity at 25°C, Pa.s ^(AKP)	15 - 20	6 - 8	Paste	LT-001
Density at 25°C	1.48 ^(AKP)	1.15	-	LT-020-A
Density of cured product at 23°C	-	-	1.34	ISO 2781
Pot life at 23°C on 25 g, min ^(AKP)	-	-	6 - 8	LT-002-B
Open Time on 7 mm bead at 23°C, min	-	-	5 - 6	LT-006-B

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

MECANICAL PROPERTIES

Hardness, Shore D*	70	ISO 868
Tensile strength, MPa *	14	ISO 527-2
Elongation at break, % *	30	
Young Modulus, MPa *	200	
Recommended use temperature, °C	15 - 25	-
Working temperature, °C **	-40 to 130	LT-006-B

*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.

ADEKIT A 230 BG

H 6230 GY POLYOL

H 6230 ISOCYANATE

POLYURETHANE ADHESIVE

HANDLING TIME

Handling time			
At 23°C	35	min	LT-006-B
At 40°C	20		
At 60°C	10		

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)

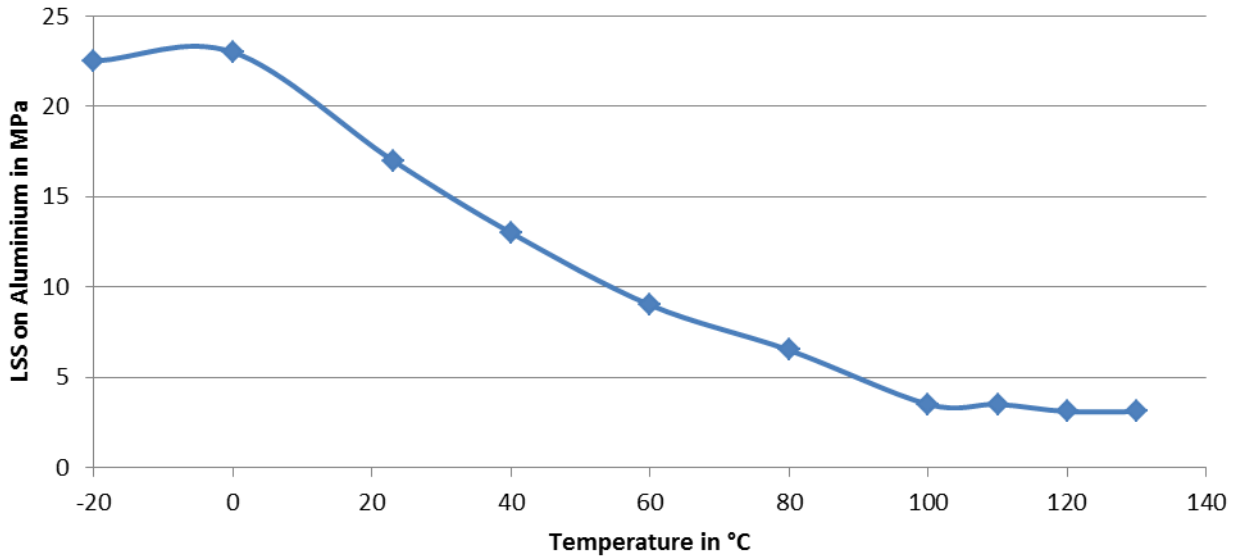
Lap Shear Strength at 23°C				
Aluminium 2017A sandblasted		17 CF	MPa	LT-006-B
	After wet cataplasms 7 days at 70°C/100% RH	7 AF		
	After 15 cycles D3*	15 SCF/CF		
Stainless Steel 304 sandblasted		18 CF		
	After wet cataplasms 7 days at 70°C/100% RH	12 AF		
Electro galvanised Steel sandblasted		15 SCF		
Electro galvanised Steel Acetone wipe		15 SCF/AF		
ABS Sanded + Isopropanol		4 SF		
PC Isopropanol wipe		4 SF		
PVC Sanded + Isopropanol		5 SF		
PMMA Sanded + Isopropanol		5 SF		
PA6E Sanded + Isopropanol		2.5 SCF		
GFR Polyester Isopropanol wipe		10 DF		
GFR Epoxy Isopropanol wipe		22.5 CF		

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

*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		6.5	KN/m	ISO 4578

Lap Shear Strength on Aluminium versus Temperature



EQUIPMENT: ADEKIT A230 BG is packaged in 400 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.

STORAGE CONDITIONS

Shelf life of ADEKIT A230 BG and of ADEKIT H 6230 GY POLYOL / H 6230 ISOCYANATE is **9 months**, stored in its original unopened packaging at temperature between +15°C and +25°C.



BUILDING TRUST



ADEKIT A 230 BG

H 6230 GY POLYOL

H 6230 ISOCYANATE

POLYURETHANE ADHESIVE

PACKAGING

A230 BG / 400ml	Box of 12 cartridges
H 6230 GY POLYOL & H 6230 ISOCYANATE	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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