

PROPERTIES

Bonding with high structural performances and low outgassing for aeronautic applications (satellite, optical tables, performance tools...).

Bonding of big-sized bodies in the industry.

APPLICATIONS

- Thixotropic product, suitable for vertical applications
- Low outgassing product conforming to ECSS-Q-70-02C and ASTM E595 space standard
- Volume Ratio 100 / 100
- Long Open Time

| PHYSICAL PROPERTIES | | | | |
|---|-------------------------|--------------|--------------|--------------|
| Composition | | RESIN | HARDENER | MIXING |
| Mix ratio by weight | | 100 | 84 | |
| Mix ratio by volume AT 25°C | | 100 | 100 | |
| Aspect | | pasty liquid | pasty liquid | pasty liquid |
| Colour | | white | yellow | light yellow |
| Viscosity at 25°C (Pa.s) | ISO 3216 RM 100 LAMY | 100 | 180 | 90 |
| Density at 25°C (g/cm ³) | ISO 1675 | 1,18 | 1,00 | - |
| Specific gravity of the cured product at 23°C | ISO 2781 | - | - | 1,10 |
| Pot life at 25°C on 35 g | TROMBOMAT | | | 105 minutes |
| Open Time at 25°C on lap shear strength specimen (>1 MPa) | ISO 4587 | | | 4 hours |

| MECHANICAL PROPERTIES AT 23°C ⁽¹⁾ | | | |
|---|----------|----------------|------------------------|
| Hardness | ISO 868 | Shore D1 / D15 | 85 / 82 |
| Lap shear strength on sand blasted 2017 aluminium | ISO 4587 | MPa | 15 – AF ⁽²⁾ |
| Lap shear strength on sandblasted stainless steel 304 | ISO 4587 | MPa | 17 – AF ⁽²⁾ |

(1) : Average values obtained on standard specimens / Hardening 16 hr at 80°C +24 hr at 23°C

(2) : Adhesive Failure (AF) according ISO 10365 :1992

| THERMAL AND SPECIFIC PROPERTIES ⁽¹⁾ | | | |
|---|-------------|----------------------------------|----|
| Glass transition temperature (tg) | ISO 11359-2 | °C | 71 |
| Coefficient of thermal expansion (CTE) (0°C to +80°C) | ISO 11359-2 | 10 ⁻⁶ K ⁻¹ | 78 |

(1) : Average values obtained on standard specimens / Hardening 16 hr at 80°C +24 hr at 23°C

PROCESSING CONDITIONS

Before use, the two parts have to be mixed thoroughly in order to ensure their homogeneity. Physical properties are guaranteed for room temperature between 18 °C and 25 °C. Outside this range, viscosity and reactivity could be observed.

STORAGE CONDITIONS

Shelf life of Adekit H9950 is 12 months in a dry place and in its original unopened containers at a temperature between 15 and 25 °C.

Any opened can must be tightly closed under dry nitrogen.

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.*

PACKAGING

| H9950 RESIN | H9950 HARDENER |
|--------------------|-----------------------|
| 215 Kg | 180 Kg |

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.