



BUILDING TRUST



ADEKIT H 9951

NON FILLED STRUCTURAL EPOXY ADHESIVES FOR BONDING PANELS

PROPERTIES

ADEKIT H 9951 is a two-component non-filled epoxy adhesive whose properties make it the ideal product for bonding high dimension surfaces having high levels of mechanical and ageing resistance.

APPLICATIONS

Bonding of panels: honeycomb, aluminium sheet, steel sheet, composite materials, wood, thermoplastics, foam, etc...

PHYSICAL PROPERTIES			
	RESIN	HARDENER	MIXING
Mix ratio by weight	100	62	
Mix ratio by volume	100	73	
Aspect	light amber	translucent red	pink
Specific gravity at 25°C	1.16	0.98	1.08
Brookfield viscosity at 25°C (mPa.s)	10,000	8,000	9,000
Pot life (50 g) at 25°C (min)	Gel timer		50

MECHANICAL PROPERTIES ON ASSEMBLIES			
Time to obtain 1 Mpa RTC at 25°C	ISO 4587 : 95	h	6
Time to obtain 50% final RTC at 25°C	ISO 4578 : 90	h	12
Lap shear strength on aluminium ⁽¹⁾	ISO 4587 : 95	MPa	29 AF ⁽²⁾
Floating roller peel resistance ⁽¹⁾	ISO 4578 : 90	kN/m	4 AF ⁽²⁾

Lap shear strength on aluminium 2017A sand blasted.

(1) Hardening conditions: 8 hours at 80°C + 48 hours at room temperature.

(2) According to ISO 10365:1992: AF = Adhesive Failure.

EQUIPMENT

Please consult our Technical Department for applications needing a machine.

PRECAUTIONS

It is recommended to use the product at a temperature between +18°C and +35°C.
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.

ADEKIT H 9951

NON FILLED STRUCTURAL EPOXY ADHESIVES FOR BONDING PANELS

MECHANICAL PROPERTIES ON ASSEMBLES			
Lap shear strength after moist cataplastm 15 days at 80°C	ISO 4587 : 95	MPa	27 AF ⁽²⁾
RTC after ageing by shock thermic 15 cycles D3 (see annex)	ISO 4587 : 95	MPa	29 AF ⁽²⁾
RTC after ageing by immersion for 3 weeks : <ul style="list-style-type: none"> motor oil at 70°C chlorhydrique acid (0.1N) at 23°C soda (0.1N) at 23°C sea water at 23°C gazole at 23°C oil at 23°C 	ISO 4587 : 95 ISO 175 : 99	MPa	29 AF ⁽²⁾ 28 AF ⁽²⁾ 29 AF ⁽²⁾ 29 AF ⁽²⁾ 28 AF ⁽²⁾ 28 AF ⁽²⁾
RTC after thermic ageing for 3 weeks at 100°C	ISO 4587 95:	MPa	28 AF ⁽²⁾

THERMAL AND MECHANICAL PROPERTIES			
Hardness	ISO 868 : 85	Shore D1 / D15	75/73
Tensile strength	ISO 527 : 96	MPa	30
Elongation at break	ISO 527 : 96	%	10
Glass transition temperature	TMA-METTLER	°C	60
Thermal coefficient of expansion (CTE) [-30 ; +50]°C	TMA-METTLER	10 ⁻⁶ K ⁻¹	70
Working temperature	-	°C	-40 ; +100

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.

PACKAGING

Resin	Hardener
6 x 0.5 kg	6 x 0.31 kg
5 kg	3.1 kg
25 kg	15.5 kg



BUILDING TRUST



ADEKIT H 9951

NON FILLED STRUCTURAL EPOXY ADHESIVES FOR BONDING PANELS

STORAGE CONDITIONS

Shelf life of the H9951 is 12 months stored in its original unopened packaging at a temperature between +15°C 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.

AXSON TECHNOLOGIES
Head Office France
+33 1 34 40 34 60
axson@axson.com
sikaaxson.com

GERMANY
+49 (0)7125 940 492
tooling@de.sika.com
www.sikaaxson.de

ITALY
+39 02 96 70 23 36
axson@axson.it
axson.it

SPAIN & PORTUGAL
+34 93 225 16 20
spain@axson.com
axson.es

U.K.
+44 1 638 66 00 62
sales.uk@axson.com
axson.com

SLOVAKIA
+421 37 642 25 26
axson.sk@axson.com
axson-ce.sk

USA
+1 248 588 2270
axsonmh@axson.com
axson-na.com

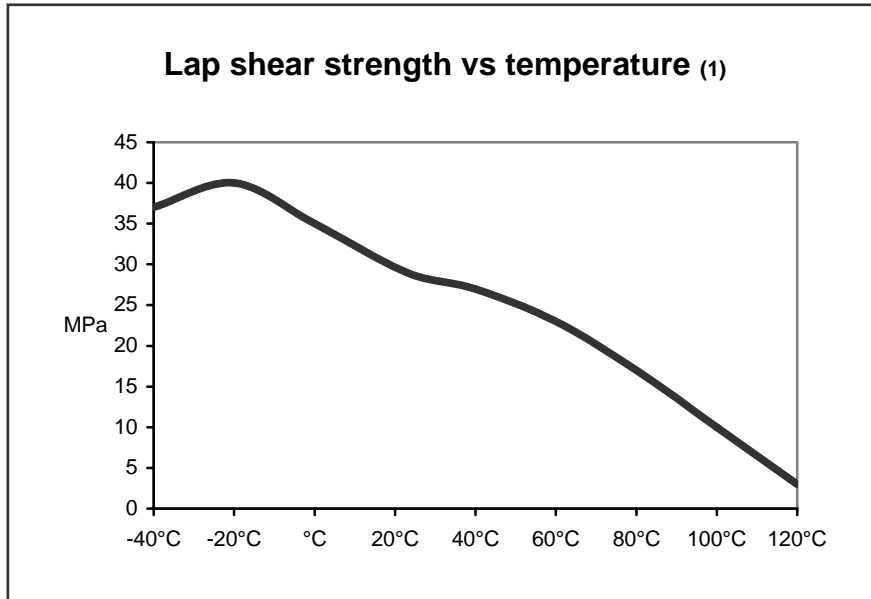
MEXICO
+52 55 52 64 49 22
marketing@axson.com.mx
axson.com.mx

JAPAN
+81 564 26 25 91
sales.japan@axson.com
axson.jp

CHINA
+86 21 58 68 30 37
marketing_china@axson.com
axson.cn

INDIA
+91 20 25560710
info.india@axson.com
axson.com

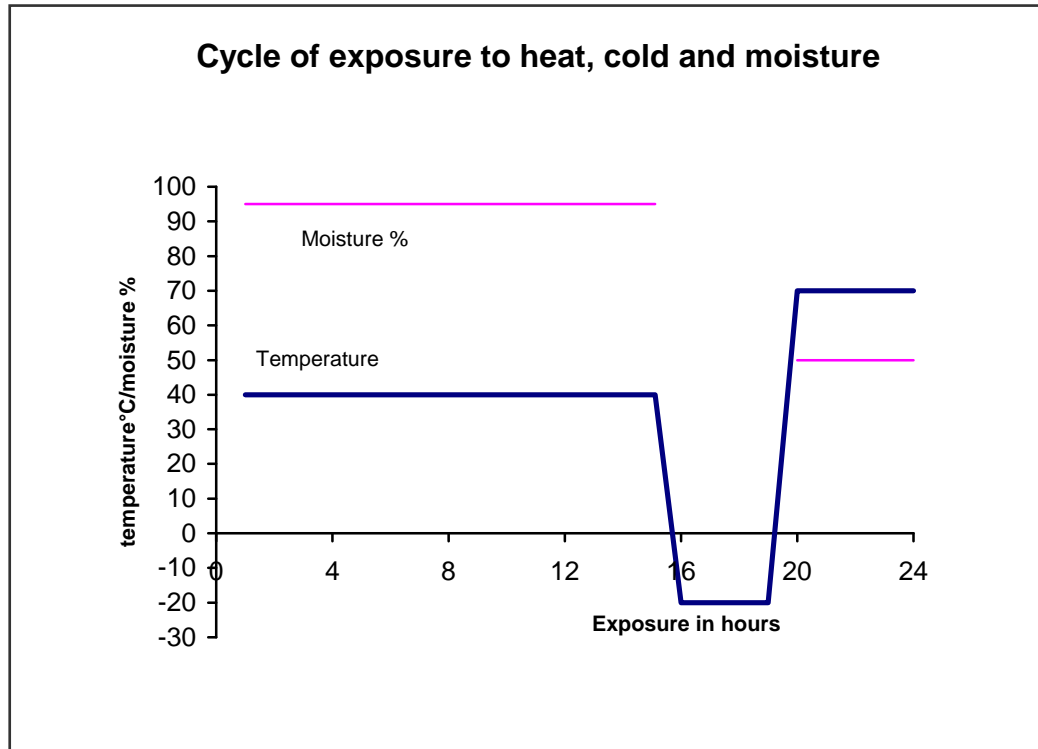
ANNEX



(1) Hardening conditions: 8 hours at 80°C + 48 hours at room temperature

THERMAL SHOCK TEST ACCORDING TO ISO 9142-93 NORM

D3 cycle



December 21st, 2016