

## DESCRIPTION

Bonding of large composite parts (RTM, SMC, GRP, Laminate), metallic structures, plywood for application requiring high performances and flexibility in transport industries (truck, bus) and Marine (hull bonding, deck bonding, interior design). Exist in 2 cure speeds.

## PROPERTIES

- Non sagging paste product with gap fill up to 30mm in vertical and ceiling application; 60mm in horizontal
- Exist in grey and clear green.
- Excellent strength to dynamic loads (vibration and impact)
- Odor and solvent free
- Long open time with reduced handling time
- Lloyds Nautical Certification
- Usable with dispensing machines equipped with pressure vessels.

PHYSICAL PROPERTIES						
Composition			POLYOL	ISOCYANATE	MIX	Method
Mix ratio by weight			92	100		
Mix ratio by volume			100	100		
Colour	A236	-25 -120	Clear grey Clear blue	Beige	Grey Clear green	
Density at 25°C (AKP)		-25 -120	1.29	1.40	-	LT-020
Viscosity at 25°C, Pa.s (AKP)		-25 -120	210* 110**	12.5*	Thixotropic paste	LT-001* LT-063 / 9s <sup>-1</sup> **
Open Time on 10 mm diameter bead at 23°C, min (AKP)		-25 -120	-	-	30 105	LT-002-B
Flow threshold on bead, % (AKP)			-	-	< 5	LT-017/ Comb-shaped spatula of 40 mm
Working Temperature			-	-	-40°C to 110°C	

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

MECHANICAL PROPERTIES at 23°C (1)			
Hardness	ISO 868 : 2003	Shore D	60
Tensile strength	ISO 527 : 1993	MPa	12
Elongation at break	ISO 527 : 1993	%	60
Tensile modulus	ISO 527 : 1993	MPa	84
Shear modulus	ISO 527 : 1993	MPa	30

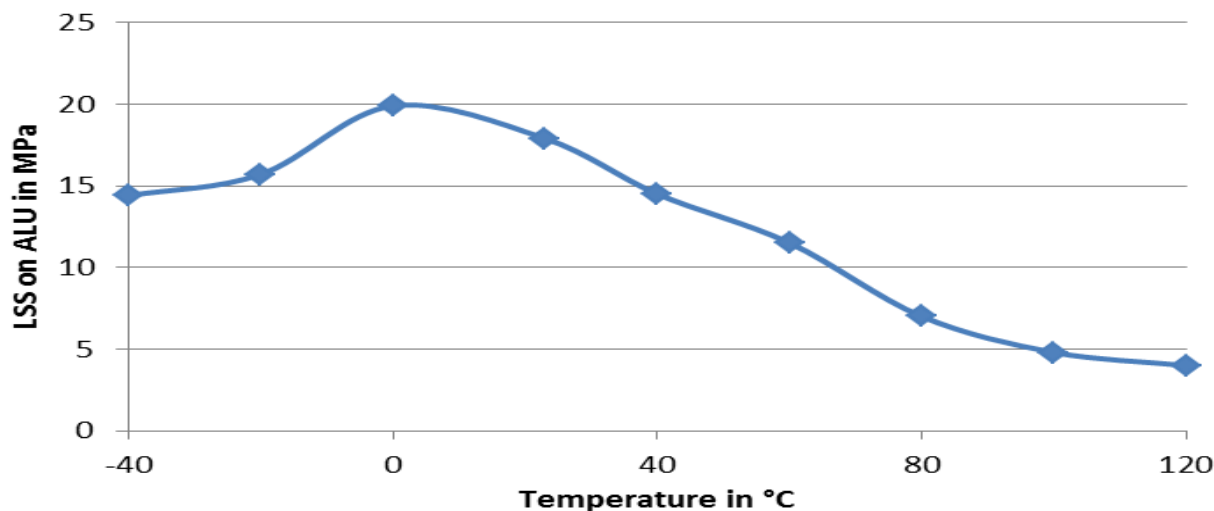
MECHANICAL PROPERTIES ON ASSEMBLIES (1)			
Lap Shear Strength on sanded Aluminium (2)	ISO 4587	MPa	14 (CF) 7 (CF)
<ul style="list-style-type: none"> <li>at 23°C</li> <li>at 80°C</li> </ul>			
Peel strength on sanded aluminium at 23°C	ISO 4578	N/mm	4 (CF)
Lap Shear Strength on infused Polyester laminate	ISO 4587	MPa	8 (composite substrate delaminating failure) 8 (composite substrate delaminating failure) 8 (composite substrate delaminating failure) 6 (composite substrate delaminating failure) 9 (composite substrate delaminating failure)
<ul style="list-style-type: none"> <li>Initial</li> <li>After 10 days immersion in 50°C water</li> <li>After 150 hours of salt spray test at 50°C</li> <li>After 21 days of D3 cycle (3)</li> <li>After 21 days immersion in Gasoil at 23°C</li> </ul>			

(1): Hardening conditions: 7 days at room temperature.

(2): Lap shear strength - CF: Cohesive Failure

(3): D3 cycle – 16hrs at 45°C/95%RH+4hrs at -20°C+4hrs at 70°C/50%RH

**Lap Shear Strength on ALU versus Temperature**





BUILDING TRUST



# ADEKIT A 236

# ADEKIT H 6236

**POLYURETHANE ADHESIVE**  
FOR LARGE COMPOSITE PARTS BONDING

## PROCESSING CONDITIONS

The item to be bonded must be free of all dirt, oil or other foreign matter. A clean, dry surface is a must. Please consult our Technical Support and refer to the technical data sheet about surface preparations to choose adapted degreaser or cleaner.

## HANDLING PRECAUTIONS

It is recommended to use the product at a temperature between +15°C and +35°C. 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.

## STORAGE CONDITIONS

Shelf life of ADEKIT A236-25, A236-120, H6236-25 Polyol, H6236-120 Polyol and H6236 Isocyanate is **9 months** stored in their original unopened packaging at a temperature between +15°C and +25°C.

## PACKAGING

<b>A236-25</b>	<b>Box of 12 cartridges</b>
<b>A236-120</b>	<b>Box of 12 cartridges</b>
<b>H6236-25 Polyol / H6236 Isocyanate</b>	<b>28Kg Polyol + 30Kg Isocyanate</b>
<b>H6236-120 Polyol / H6236 Isocyanate</b>	<b>5.5Kg Polyol + 6Kg Isocyanate</b> <b>28Kg Polyol + 30Kg Isocyanate</b>

## 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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