

DESCRIPTION

Bonding of body panels, metallic structures and composite materials.

PROPERTIES

- Two component, room-temperature cure polyurethane adhesive
- Non-sagging paste product suitable for vertical applications and to fill irregular joints
- Slow setting product designed to cover and bond large surface areas
- Excellent vibration, impact and noise damping
- Excellent behavior at low temperatures
- Product is designed for bonding dissimilar materials
- Excellent mechanical performance
- Excellent strength under dynamic loads such as vibration and impacts
- Product designed to resist aging and aggressive environments

PHYSICAL PROPERTIES				
Composition		Polyol	Isocyanate	Mixed
Reacting Ratio by volume @ 77°F (25°C)		100	100	
Appearance		Paste	Thick Liquid	Paste
Color		Black	Brown	Black
Viscosity @ 77°F (25°C) (mPa.s)	Brookfield LVT	6,400,000	7,000	600,000
Density @ 77°F (25°C) (g/cm ³)		1.50	1.15	
Cured density @ 73°F (23°C)				1.35
Open time at @ 77°F (25°C) (minutes)	TECAM Gel Timer			40

THERMAL AND MECHANICAL PROPERTIES ¹			
Hardness	ISO 868 : 2003	Shore D1	50
Tensile strength	ISO 527 : 1993	psi (MPa)	1890 (13)
Elongation at break	ISO 527 : 1993	%	90
Working temperature		°F (°C)	-40 to 212 (-40 to 100)

MECHANICAL PROPERTIES ON ASSEMBLIES¹

Time to reach 145 psi (1 MPa) LSS ² at 77°F (25°C)	ISO 4587 : 1993	hours	3
Time to reach 50% of final LSS at 77°F (25°C)	ISO 4587 : 1993	hours	8
Lap shear strength ³	ISO 4587 : 1993	psi (MPa)	2470 (17) CF ⁴
Floating roller peel resistance ³	ISO 4578 : 1993	pli (kN/m)	57 (10) CF
After aging LSS – 15 days of D3 cycles ⁵	ISO 4587 : 1993	psi (MPa)	2030 (14) CF
¹ Cured 48 hours at room temperature + 8 hours at 176°F (80°C) ² Lap shear strength ³ On sand blasted aluminum 2017A ⁴ According to ISO 10365:1992; CF = Cohesive failure ⁵ See appendix for details of D3 aging cycle			

HANDLING PRECAUTIONS

It is recommended to use this product at temperatures between 65 – 95°F (18 – 35°C) Normal health and safety precautions should be observed when handling these products :

Ensure good ventilation

Wear gloves, and safety glasses.

Wear impervious clothing.

For further information, please consult the material safety data sheet.

STORAGE CONDITIONS

Product is guaranteed for 12 months stored in its original unopened packaging at a temperature between 60 - 77°F (15 – 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.

APPENDIX

THERMAL SHOCK TEST ACCORDING TO ISO 9142 : 1993 NORM

D3 cycle

