

DESCRIPTION

Bonding of flexible parts and for repairs (elastomers, polyurethane foam, rubber...).

PROPERTIES

- 2 component room temperature cure polyurethane adhesive
- Liquid product suitable for injection
- Fast setting product adapted to reduce assembly time
- Excellent vibrations, impacts and noise damping
- Excellent behaviour at low temperatures
- High elongation product (300%) ideal for assemblies where dissimilar materials are bonded
- Excellent mechanical performances and ageing
- Excellent strength to dynamic loads (vibrations and impacts)
- Product adapted to stringent ageing and aggressive environments

PHYSICAL PROPERTIES				
Composition		POLYOL	ISOCYANATE	MIXED
Mix ratio by weight		100	77	
Mix ratio by volume at 25°C		100	100	
Aspect		thick liquid	liquid	thick liquid
Colour		black	amber	black
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT			
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	1.50	1.10	1.29
Pot life at 25°C on 100 g (min)	Gel Timer TECAM			5
Open time (min)	-	-		8

THERMAL AND MECHANICAL PROPERTIES (1)			
Hardness	ISO 868 : 2003	Shore A	65
Tensile strength	ISO 527 : 1993	MPa	7
Elongation at break	ISO 527 : 1993	%	300
Glass transition temperature (tg)	ISO 11359 : 2002	°C	-
Coefficient of thermal expansion (CTE) (15°C à 90°C)	ISO 11359: 1999	10 ⁻⁶ K ⁻¹	-
Working temperature	-	°C	-40; +80

EQUIPMENT

ADEKIT A251 packaged in 50 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



ADEKIT A 251

LIQUIDPOLYURETHANE ADHESIVE
BONDING FLEXIBLE PARTS

MECHANICAL PROPERTIES ON ASSEMBLIES

Time to obtain 1 MPa lap shear strength at 25°C	ISO 4587 : 2003	min	60
Time to obtain 50% final lap shear strength at 25°C	ISO 4587 : 2003	hr	-
Lap shear strength on aluminium	ISO 4587 : 2003	MPa	11 CF(3)
Floating roller peel resistance (2)	ISO 4578 : 1997	kN/m	9 CF
Lap shear strength after moist cataplastm 15 days at 80°C	ISO 4587 : 2003	MPa	
Lap shear strength after a thermal shock ageing cycle 15 cycles D3 (see annex)	ISO 4587 : 2003	MPa	

(1) Lap shear strength on aluminium 2017A etched in sulfochromic bath

(2) Hardening conditions: 8 hrs at 80°C + 48 hrs at room temperature

(3) According to ISO 10365:1992 : CF = Cohesive failure

HANDLING 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.

STORAGE CONDITIONS

Shelf life of ADEKIT A251 is 6 months stored in its original unopened packaging at a temperature between +15°C and +25°C.

PACKAGING

A251/50

12 cartridges

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.