



H 9951

NON-FILLED STRUCTURAL EPOXY ADHESIVE 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	light yellow
Specific gravity at 25°C	1.16	0.98	1.08
Brookfield viscosity at 25°C (mPa.s)	12,000	10,000	11,000
Pot life (50 g) at 25°C			50 min.

MECHANICAL PROPERTIES ON ASSEMBLIES			
Lap shear strength on aluminium	ISO 4587-95	MPa	25 AF
Floating roller peel resistance (2)	ISO 4578-90	kN/m	4 AF

Lap shear strength on aluminium 2017A etched in sulfochromic bath
(1) Hardening conditions: 8 hrs at 80°C + 48 hrs at room temperature
(2) 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.

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MECHANICAL PROPERTIES ON ASSEMBLES			
Lap shear strength after moist cataplasms 15 days at 80°C	ISO 4587-95	MPa	20 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;+60]°C	TMA-METTLER	10 ⁻⁶ K ⁻¹	70
Working temperature	-	°C	-40;+120

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

H 9951	
6 x 0,5 kg	6 x 0,31 kg
25 kg	15,5 kg
5 kg	3,1 kg

STORAGE CONDITIONS

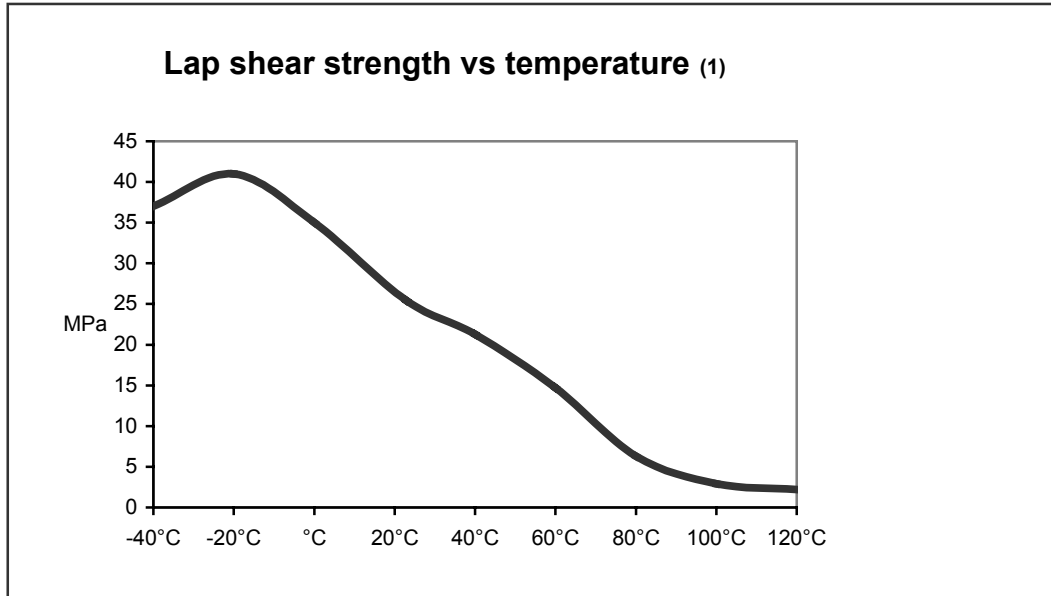
Use within 18 months of the manufacturing date. Expiry date indicated on the packaging.

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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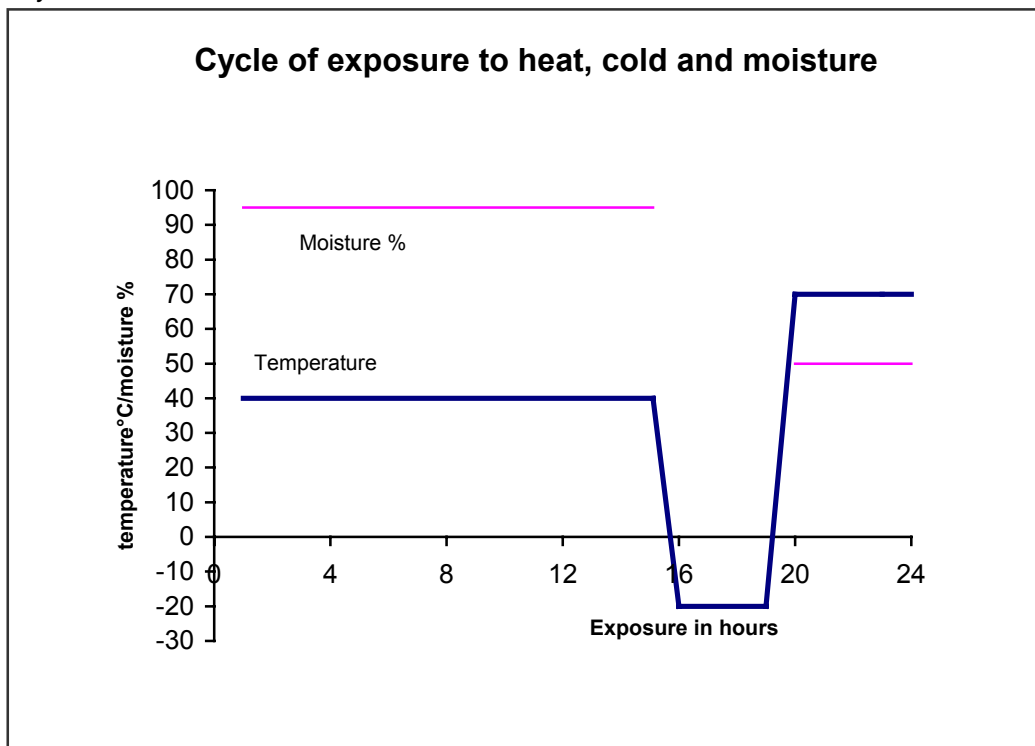
ANNEX



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

THERMAL SHOCK TEST ACCORDING TO ISO 9142-93 NORM

D3 cycle



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