

GUIDELINES FOR YOUR ASSEMBLIES

	Steels	Stainless steel	Galvanised metals	Aluminium	ABS	PMMA	PVC	Polycarbonate	Nylons	Wood	Glass	Concrete/cements	Ceramic	Carbon/Epoxy composites	Glass/Epoxy composites	Glass/Polyester Composites (SMC, GRP, RTM)
Steels																
Stainless steel																
Galvanised metals																
Aluminium																
ABS																
PMMA																
PVC																
Polycarbonate																
Nylons																
Wood																
Glass																
Concrete/cements																
Ceramic																
Carbon/Epoxy composites																
Glass/Epoxy composites																
Glass/Polyester composites (SMC, GRP, RTM)																

ADEKIT A 100 serie Epoxy

ADEKIT A 200 serie Polyurethane

ADEKIT A 300 serie Methacrylate

ADEKIT A 100 or A 200 series

ADEKIT A 200 or A 300 series

ADEKIT A 100 or A 300 series

ADEKIT A 100, A 200 or A 300 series

Non intended combination of the joint parts

The ADEKIT performances are only guaranteed if good conditions of surface pre-treatment and curing of the adhesive are being followed. Please contact our Technical Support Dept for your specific requirements.

PRIMERS SURFACE PREPARATION FOR OPTIMUM BONDING

What is it?

Certain materials need a modification of their surface to be bonded and/or ensure a durability of the assembly. The application of a primer is a mean to transform the substrate into a modified surface in a chemical and/or a physical way, in order to reinforce the adherence in long term.

What are the effects?

Axson primers offer a triple action :

- 1 Improve the performance of the bonding, offering a better adherence and a better aging resistance.
 - 2 Create a barrier against plasticizers and additives present in the glue, avoiding discolouration and stress cracking* for the bonding of thermoplastics.
 - 3 Protect and stabilise metallic surfaces for Metal Primer.
- * Chemical attack of the plastic degrading mechanical properties of the material (tear strength + elongation) and which weakens it during thermal expansion.

	GLASS PRIMER	PLASTIC PRIMER	METAL PRIMER
Code	Z35850	Z35670	06626
Substrate	Glass and Plastic	Plastic	Metal
Colour	Black	Transparent	Ochre
Density	0,90 ± 0,05	0,94 ± 0,02	1,00 ± 0,03
Drying time Touch dry	15 min at 20°C	5 min at 20°C	10 to 15 min at 23°C
Drying time before adhesive application	15 min at 20°C	20 min at 20°C	25 to 30 min at 23°C
Application temperature	10 to 35 °C	10 to 35 °C	10 to 35 °C

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More information and downloads available on the Website: www.axson.com



Products overview



++	Very well
+	Well
o	Medium

Substrates															Resistance				
Ferrous metals	Non ferrous metals	Composites, laminates	Thermoplasts	Glass, ceramics	Foam materials	Elastomer (PU, PS)	Polyurethane (hard)	Temperature	Chemically	Water	Shear stress	Peel stress	Ageing						

Ref.	Application, description	Colour	Liquid	Viscous	Pasty	Open time	Hardness (shore)	Viscosity (Pa.s.)	Handling time	Lap shear strength on alu (MPa)	Peel resistance (kN/m)	Elongation at break (%)	Ferrous metallic / Non ferrous / Composites / Thermoplastics / Glass, ceramic / Foam materials / Elastomer, rubber / Polyurethane / Temperature / Chemically / Water / Shear stress / Peel stress / Ageing														50 ml	400 ml	Other sizes	Industrial packages
POLYURETHANE																														
A 220	Excellent for vibration, impact and noise dampening. Excellent behaviour at low temperature. Product adapted to assemblies involving dissimilar materials.				X	9'	90A	600	90'	16	12	95	o	+	++	+	+	+	+	+	+	++	++	++	+	A 220	X	X	Kit & drum: H6220	
A 230	Bonding of composite parts (RTM, SMC, wet lay-up laminate...) & metallic structures. High strenght & high peel combined with flexibility. Non sagging paste product suitable for vertical applications and to fill irregular joints.				X	7'	70D	thixo	30'	15	6	30	++	++	++	+	o	+	o	++	+	+	++	++	+	+	A 230		X	Drum: H6230
A 231	A231: faster manipulation.				X	3'	70D	thixo	15'	15	6	30	++	++	++	+	o	+	o	++	+	+	++	++	+	+	A 231		X	Drum: H6231
A 236	Allows production with gaps up to 40 mm and parts assembly with large dimensions (deck/hull, wind mill). Available in various reactivities and colours (white or grey).				X	30' 90'	60D	pasty	4h	14	4	60	++	++	++	o	o	++	o	+	+	++	++	++	+	++	A 236		X	Drum: H6236
A 252	Non sagging paste product suitable for vertical applications and to fill irregular joints. Fast setting product to reduce assembly time. High flexibility.				X	5'	70A	600	60'	11	9	300	o	+	++	+	++	+	++	+	o	o	++	o	++	+	A 252	X	X	Drum: H6252
A 257	Product recommended for the bonding of plastics sensitive to the phenomena of bond line witness marks (thermoplastic, composite). Low hardness. Flexible product.				X	5'	50A	pasty	90'	5	10	350	+	+	++	++	++	++	o	+	+	+	++	+	++	++	A 257		X	Drum: H6257
A 280 A 290	Structural bonding of metallic inserts/big head to composites. Bonding of small parts. Bonding of large-scale production such as vehicle bodywork. Also for repair. Vibration absorbing. Good chemical resistance.				X	6' 3'	90A 60D	600	45' 10'	15	10 9	85 90	+	+	++	+	+	+	+	++	+	+	++	++	++	+	A 280 A 290	X	X	Drum: H6280 Drum: H6290
A 299	Non sagging thixotropic product for vertical applications. Fast setting for parts where speed is needed. Repair of RIM-parts or injection molded parts.				X	40'	60D	pasty	1'	14	4	27	o	+	++	+	o	+	+	++	+	o	+	+	+	++	A 299	X	X	Drum: H6299
A 722	Polyurethane bi component without MDI. Ideal for structural bonding having resistance in expansion and vibration.				X	7'	60A	pasty	45'-60'	4	5	100	o	++	++	+	+	+	+	+	+	++	++	++	+	A 722		X		
P 4202	Ideal for production of high dimension bonding. Bonding of honeycomb panels (Nomex, thermoplastics, foam). Bonding of wood, sheet aluminium or sheet steel. Bonding of polyester, composite materials.		X			75'	45-60D	4 to 10	8h	13	6	100	+	+	++	++	o	++	o	+	+	o	++	+	++	+	P 4202			Drum
P 4302			X			120'	80D	3 to 13	4h	20	6	10	++	++	++	+	o	++	o	+	+	o	++	++	+	+	P 4302			Drum

METHACRYLATE

A 310-1	Excellent mechanical and thermal performances up to 120 °C. Multipurpose product with thermoplastic aspect. Product able to bond dissimilar materials.				X	10'	75D	pasty	30'-45'	20-25	8	43	++	++	++	++	o	o	o	o	++	+	++	++	+	++	A 310-1	X	X		Drum
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MS POLYMER

A 645	Single component hybrid polymer based mastic. Sealing and semi-structural bonding. Applications in wet and marine environments.Joints and reinforcement				X	20'	45A	pasty		2	9	> 250	++	++							+	+	+	o	++	+	A 645			600 ml	
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EPOXY

A 130 A 135	Liquid room temperature cure adhesive. Suitable for injection. Bonding of substrates such as composites, metal, wood, concrete; all sorts of application.	Transparent		X		6'	80D	45 15	15'	27	3	3	+	+	+	o	+	++	o	++	o	o	+	++	o	+	A 130 A 135	X		200 ml	Kit & drum: H9930	
A 140	Filled adhesive suitable for a large variety of materials as metal, glass, ceramics, composites, wood... Non sagging paste product suitable for vertical applications and to fill irregular joints. Excellent mechanical and thermal performances up to 100 °C. Product adapted to stringent ageing and aggressive environments.				X	30'	80D	430	4h30'	21	5	2	++	++	++	o	++	++	o	++	++	+	++	++	+	+	A 140	X	X		Kit & drum: H9940	
A 145	Liquid adhesive. Long pot life. Excellent mechanical performance & chemical resistance. Bonding of composites & metals in industries like automotive. Bonding of large parts also for maintenance .	Transparent		X		80'	75D	30	7h	32	4	24	+	+	+	+	+	++	+	+	+	+	++	+	++	A 145	X	X		Kit & drum: H9945		
A 155	Pasty adhesive with long pot life. For large composite parts, repair and maintance. Good mechanical & chemical performance and temperature resistance.				X	120'	84D	160	8h	22	3	8,5	+	+	++	o	+	++	+	++	++	+	++	++	o	++	A 155			420 ml	Drum: H9955	
A 170 A 171	High performance room temperature cured adhesive. Slow setting product adapted to cover and bond wide surfaces. A 171: Self-extinguishing adhesive with FAR 25.853.				X	23' 37'	83D	1600 130	3h30'	24 20	5 3	5	++	++	++	o	++	++	+	++	++	+	++	++	+	o	++	A 170 A 171		X X		Drum: H9970 Drum: H9971
A 175	High performance room temperature cured adhesive. Slow setting product adapted to cover and bond wide surfaces. Ideal for heavy duty applications & for large surfaces subject to impact or vibration. Shock resistant.				X	70'	80D	940	10h	21	4	5	++	++	++	o	++	++	+	++	++	++	++	++	+	++	A 175		X		Drum: H9975	
H 9011	Multipurpose liquid adhesive. Bond most of material. For general Industry assembly and maintenance.	Translucent		X		90'	80D	45	9h	18	5	9	++	++	++		++									H 9011	X	X	200 ml	Kit		
H 9950 H 9950T	Non-filled adhesive with high structural performances and low outgassing for aeronautic applications (satellite, optical tables, performance tools...). Bonding of big-sizes bodies in the industry. Structural and panel bnding. Long open time. H 9950T with higher viscosity.			X	X	2h	80D	65 200	4h	18	3	3	++	++	++	o	+	++	o	+	++	++	++	++	+	++	H 9950 H 9950T				Drum	
H 9951 H 9951T	Non-filled adhesive whose properties make it the ideal product for bonding high dimension surfaces having high levels of mechanical and ageing resistance. For bonding panels. High peel resistance. H 9951T: Thixotropic product.		X	X		50'	75D	9 22	6h	26	4	10	++	++	++	+	+	+	o	++	++	+	+	++	+	++	H 9951 H 9951T				Kit & drum	
H 9952	High shear & peel. Bond most of material including stainless steel and thermoplastics. Contain Nanoparticles. High ageing resistance . Self extinguish.				X	120'	85D	180	8h	26	6	5	++	++	++	+	o	++	o	+	++	++	++	++	+	++	H 9952			420 ml	Drum	



ASSEMBLY