



# ADHESIVES STRUCTURAL BONDING

AUTOMOTIVE - TRANSPORTATION - MARINE - AEROSPACE - GENERAL INDUSTRY



**BUILDING TRUST**



# COMPANY SUMMARY

**WITH OVER 60 YEARS OF EXPERIENCE**, SikaAxson is the world leading provider and developer of high-performance resins, boards and pastes for model and mould making. SikaAxson offers customized solutions for the composites industry - from the model to the shape and finished parts up to the fitting structural adhesive. In addition, SikaAxson offers casting resins and functional coatings for industrial filters and dielectrics.

SikaAxson generates an annual turnover of € 130 million with 450 employees.

SikaAxson is part of Sika AG, which is headquartered in Baar, Switzerland. Sika has subsidiaries in 90 countries world-wide, with more than 160 manufacturing sites. It has approx. 17,000 employees, who generated an annual turnover of CHF 5.6 billion in 2014.



## INTEGRATED PRESENCE

ADEKIT by SikaAxson is a brand of Pu, MMA and Epoxies adhesives developed and designed to achieve:

### EASY DISPENSING:

The ADEKIT range is compatible with all dosing and dispensing equipment offered in the market.

Packaging for manual operations range from 50cc to 400cc cartridges and bulk applications range from 1 liter to 200 liters. The cartridge product offering is completed with a range of accessories from guns to mixers and primers.

SikaAxson products ensure the best compromise between flow characteristics and the necessary thixotropic effects for a wide variety of applications including vertical surfaces and potting.

### TAILOR MADE CURING PROFILE:

As productivity matters a good balance between open time and handling time is always a key development objective. The longest open time is required to secure industrial dispensing while the shortest handling time is preferred to speed up productivity.

Thanks to SikaAxson global raw material sourcing, unique technologies like carbon nano fillers, the use of induction sensitivity or thermo latent catalyst are proposed to optimize process time.

### HIGH PERFORMANCES:

The structural assembly of two materials require the optimization of different properties e.g. High modulus link to elastic behavior.

SikaAxson adhesives are designed to meet the requirements of different properties and achieve the targets for product shear, peel and fatigue resistance within the same product.

These developments are part of the long and unique SikaAxson experiences spent at very close of customer requirements and demanding specifications.



## CUSTOMIZED AND INNOVATIVE SOLUTIONS

As an innovative formulator SikaAxson is keen to customize systems and formulations to comply with the exact needs of industrial applications. Based on a solid experience in formulation for over 70 years and implementing the latest technologies into our adhesives enables us to bring solutions to new material assembly.

Using unique Nano fillers technologies to enhance simultaneously properties like shear and peel resistance SikaAxson adhesives combine properties that normally are impossible to combine. The control of chemical reactions are accurately managed thanks to new catalyst technologies that fully comply with REACH. This offers extended open times with very short handling time opening the doors of process demanding industries like automotive and composite.

SikaAxson have been involved in advanced adhesive formulations for decades. This long lasting experience, in a very demanding field of activities, today results in a strong competence in structural bonding which has been acquired in tandem to customer specifications and processes. Hereunder some applications list and recommended materials are listed.

# TRANSPORT: VEHICLES, AEROSPACE AND RAILWAY

## AUTOMOTIVE AND TRANSPORTATION

SikaAxson's range covers large thermoplastic, laminate composites and metallic assemblies that require a wide spectrum of modulus from flexible to rigid material:

### FLEXIBLE

PU is preferred for dissimilar assembly with low adhesive thickness: absorb CTE gap, high elongation. Good energy absorption (crash). Handling in a few minutes with limited activation energy.



| Ref.  | Main features  | Open time | LSS (MPa) | Peel (N/mm) | Elongation (%) | Impact Resist. (N/mm) |
|-------|--|-----------|-----------|-------------|----------------|-----------------------|
| A 252 | Non sagging paste product suitable for vertical applications and to fill irregular joints. Fast setting product to reduce assembly time. High flexibility. | 8'        | 11        | 9           | 300            | 50                    |
| A 256 | For plastics bonding sensitive to the phenomenon of bond line witness marks (composite, thermoplastic). Can be used in thick seal, vertical or ceiling.    | 5'<br>25' | 4         | 5           | 100            | NA                    |
| A 257 | Bonding of plastics sensitive to the phenomena of bond line witness marks (thermoplastic, composite). Short handling with limited heating.                 | 5'        | 5         | 10          | 350            | 55                    |

### SEMI RIGID

For assembly with similar material or dissimilar with regular adhesive thickness.



| Ref.                    | Main features  | Open time        | LSS (MPa) | Peel (N/mm) | Elongation (%) | Impact Resist. (N/mm) |
|-------------------------|--|------------------|-----------|-------------|----------------|-----------------------|
| A 220<br>A 280<br>A 290 | Excellent for vibration, impact and noise dampening. Excellent behavior at low temperature. Product adapted to assemblies involving dissimilar materials with regular glue thickness. Structural bonding of spoiler, metallic inserts/big head to composites. Good chemical resistance. Short handling with limited heating. | 15'<br>10'<br>3' | 16        | 12          | 80             | 30                    |
| A 230<br>A 231          | Bonding of composite parts (RTM, SMC, laminate...) & metallic structures. High flexibility. Suitable for vertical applications and to fill irregular joints.   | 7'<br>3'         | 15        | 6           | 30             | 15                    |

### RIGID

Epoxy is preferred for assembly requiring high modulus, high energy absorption (crash test).



| Ref.  | Main features  | Open time | LSS (MPa) | Peel (N/mm) | Elongation (%) | Impact Resist. (N/mm) |
|-------|--|-----------|-----------|-------------|----------------|-----------------------|
| A 140 | Multipurpose with very good mechanical features. Pastynon sagging Gap filler material. Impact Resist: 10 N/mm.   | 40'       | 21        | 5           | 2              | 10                    |
| A 155 | Pasty constructive adhesive with long pot life. For large composite parts, repair and maintenance. Good mechanical performance & chemical and temperature resistance. Impact Resist: 15 N/m. | 120'      | 22        | 3           | 8.5            | 15                    |

## AEROSPACE AND RAILWAY

SikaAxson range of certified products have been used in railway and aerospace industries for decades. SikaAxson propose product design for specific demanding applications like leading edge assembly or honeycomb manufacturing.



| Ref.             | Main features   | Open time | LSS (MPa) | Peel (N/mm) | Elongation (%) |
|------------------|---|-----------|-----------|-------------|----------------|
| H9951T<br>H9951T | Non-filled adhesive for bonding large surfaces (ie panels) when mechanical and ageing as well as high peel resistance is needed. T for thixotropic product (hot cure process). Used in Railway. | 50'       | 26        | 9           | 10             |
| H9952            | High shear/peel/ageing resistance. Filled with Nanoparticles. Short handling time with limited heating. Self extinguishable. Used in railway and aerospace applications.                        | 2h        | 26        | 10          | 3              |
| A 171            | High performance room temperature cured adhesive. Slow setting product adapted to cover and bond wide surfaces. Self-extinguishing adhesive with FAR 25.853.                                    | 37'       | 20        | 5           | 5              |
| A 211            | For electronic components bonding. Self-extinguishing adhesive with FAR 25.853  | 40'       | 10        | 9           | 80             |
| A 140            | Multipurpose with very good mechanical features. Pasty non sagging Gap filler material. Impact Resist: 10 N/mm.   | 40'       | 21        | 5           | 2              |



# PRODUCT OVERVIEW SELECTOR GUIDE

| Ref.                | Application, description  | Colour      | Liquid | Viscous | Pasty | Open time          | Hardness (shore) | Viscosity (Pa.s.) |
|---------------------|---|-------------|--------|---------|-------|--------------------|------------------|-------------------|
| <b>POLYURETHANE</b> |   |             |        |         |       |                    |                  |                   |
| A 211               | For electronic components bonding. Self-extinguishing adhesive with <b>FAR 25.853</b> .   |             |        |         | X     | 40'                | 95A              | thixo             |
| A 220               | Excellent for vibration, impact and noise dampening. Excellent behavior at low temperature. Product adapted to assemblies involving dissimilar materials with regular glue thickness. Impact resistance : 30 N/mm.              |             |        |         | X     | 15'                | 48D              | 150               |
| A 230<br>A 231      | Bonding of composite parts (RTM, SMC, laminate...) & metallic structures. High strength & high peel combined with flexibility. Suitable for vertical applications and to fill irregular joints.                                 |             |        | X       |       | 7'<br>3'           | 70D              | thixo             |
| H 6235              | Large dimensions assembly. Gap filling capacity. Used in industry assembling big parts.   |             |        |         | X     | 30'<br>60'         | 45D              | 100               |
| A 236               | Allows gaps up to 40mm and parts assembly with large dimensions (deck/hull, wind mill). Various reactivities and colours. Machine or hand mix version. <b>Lloyd's Register</b> .  |             |        |         | X     | 30'<br>90'<br>120' | 60D              | pasty             |
| A 252               | Non sagging paste product suitable for vertical applications and to fill irregular joints. Fast setting product to reduce assembly time. High flexibility. Impact Resist: 50N/mm.   |             |        |         | X     | 8'                 | 70A              | 600               |
| A 256               | Recommended for plastics bonding sensitive to the phenomenon of bond line witness marks (composite, thermoplastic). Broad spectrum of accession. Available in two reactivities, can be used in thick seal, vertical or ceiling. |             |        |         | X     | 5'<br>25'          | 80A              | pasty             |
| A 257               | Recommended for the bonding of plastics sensitive to the phenomena of bond line witness marks (thermoplastic, composite). Low hardness. Flexible product. <b>Short handling with limited heating</b> . Impact Resist: 55 N/mm.  |             |        |         | X     | 5'                 | 50A              | pasty             |
| A 280<br>A 290      | Structural bonding of spoiler, metallic inserts/big head to composites. Vibration absorbing. Good chemical resistance. <b>Short handling with limited heating</b> . Impact Resist: 30 N/mm.                                     |             |        |         | X     | 10'<br>3'          | 48D              | 150               |
| P 4302              | High dimension pannels bonding (skin on core), honeycomb (Nomex, aluminium, foam thermoplastics...). Wood, aluminium or metal sheets. 3 Iso combinable (P 4004, 4002, 4003).  |             | X      |         |       | 120'               | 80D              | 13<br>6<br>3      |
| <b>METHACRYLATE</b> |   |             |        |         |       |                    |                  |                   |
| A 300-1<br>A 310-1  | Excellent mechanical and thermal performances up to 120 °C. Multipurpose product with thermoplastic aspect. Product able to bond dissimilar materials   |             |        |         | X     | 5'<br>10'          | 75D              | pasty             |
| <b>EPOXY</b>        |   |             |        |         |       |                    |                  |                   |
| A 130<br>A 135      | Fast cure at room temperature. Suitable for injection. Bonding of substrates such as composites, metal, wood, concrete.   | Transparent | X      | X       |       | 6'                 | 80D              | 45<br>15          |
| A 140               | Multipurpose with very good mechanical features. Pasty non sagging Gap filler material. Impact Resist: 10 N/mm.   |             |        |         | X     | 40'                | 80D              | 430               |
| A 145               | Liquid adhesive. Long pot life. Excellent mechanical performance and chemical resistance.   | Transparent | X      |         |       | 85'                | 75D              | 30                |
| A 155               | Pasty constructive adhesive with long pot life. For large composite parts, repair and maintenance. Good mechanical performance & chemical and temperature resistance. Impact Resist: 15 N/mm                                    |             |        |         | X     | 120'               | 84D              | 160               |
| A 170<br>A 171      | High performances room temperature curing adhesive. Slow setting product adapted to cover and bond wide surfaces. A 171: Self-extinguishing adhesive with <b>FAR 25.853</b> .   |             |        |         | X     | 30'<br>37'         | 83D              | 1600<br>130       |
| A 175               | High performances room temperature curing adhesive. Slow setting product adapted to bond wide surfaces and heavy duty applications subject to impact or vibration. Shock resistant.   |             |        |         | X     | 90'                | 80D              | 940               |
| H 9011              | Multipurpose liquid adhesive. Bond most of materials. For general industry and maintenance.   | Transparent | X      |         |       | 100'               | 80D              | 45                |
| H 9950<br>H 9950T   | Non-filled adhesive. High structural performances and low outgassing for aerospace applications. Large sizes bodies, structural and panel bonding. Long open time.  |             |        | X       | X     | 2h                 | 80D              | 65<br>200         |
| H 9951<br>H 9951T   | Non-filled adhesive for bonding large surfaces (ie panels) when mechanical and ageing as well as high peel resistance is needed. T for thixotropic product (hot cure process). <b>Used in railway</b> .                         |             | X      | X       |       | 50'                | 75D              | 9<br>22           |
| H 9952              | High shear/peel/ageing resistance. Filled with Nanoparticles. Short handling time with limited heating. Self extinguishable ( <b>EN45545 HL3 for R1, R2, R3, R6, R7, R17</b> ). Used in railway and aerospace applications.     |             |        |         | X     | 120'               | 85D              | 180               |

| Handling time<br>(*with 70°C<br>activation) | Lap shear<br>strength on alu<br>(MPa) | Peel resistance<br>(kN/m) | Elongation<br>at break (%) | Substrates        |                       |                          |              |                    |                            |                   |                        |             | Resistance |       |              |             |                    |              | Ref.   | 50 ml  | 400 ml                           | Other<br>sizes | Industrial<br>packages |
|---|---------------------------------------|---------------------------|----------------------------|-------------------|-----------------------|--------------------------|--------------|--------------------|----------------------------|-------------------|------------------------|-------------|------------|-------|--------------|-------------|--------------------|--------------|--------|--------|----------------------------------|----------------|------------------------|
|   |                                       |                           |                            | Ferrous<br>metals | Non ferrous<br>metals | Composites,<br>laminates | Thermoplasts | Glass,<br>ceramics | Foam materials<br>(PU, PS) | Elastomer, rubber | Polyurethane<br>(hard) | Temperature | Chemically | Water | Shear stress | Peel stress | Ageing             | ++ Very well |        |        |                                  |                |                        |
| 4h  | 10                                    | 9                         | 80                         | o                 | +                     | ++                       | +            | +                  | +                          | +                 | +                      | +           | +          | ++    | +            | +           | A 211              | X            |        |        |                                  |                |                        |
| 60'   | 16                                    | 12                        | 80                         | o                 | +                     | ++                       | +            | +                  | +                          | +                 | +                      | +           | +          | ++    | ++           | ++          | A 220              | X            | X      |        | Kit & drum:<br>H 6220            |                |                        |
| 30'<br>15'                                  | 15                                    | 6                         | 30                         | ++                | ++                    | ++                       | +            | o                  | +                          | o                 | ++                     | +           | +          | ++    | ++           | +           | A 230<br>A 231     |              | X      |        | Drum: H 6230<br>H 6231           |                |                        |
| 4h<br>5h                                    | 13                                    | 6                         | 5                          | ++                | ++                    | ++                       | +            | o                  | ++                         | o                 | +                      | +           | o          | ++    | ++           | +           | H 6235             |              |        |        | Drum                             |                |                        |
| 2,5h<br>5h<br>6h                            | 14                                    | 4                         | 60                         | ++                | ++                    | ++                       | o            | o                  | ++                         | o                 | +                      | +           | ++         | ++    | ++           | +           | A 236              |              | X      |        | Drum: H 6236<br>ready to mix kit |                |                        |
| 60'   | 11                                    | 9                         | 300                        | o                 | +                     | ++                       | +            | ++                 | +                          | ++                | +                      | o           | o          | ++    | o            | ++          | A 252              | X            | X      |        | Drum: H 6252                     |                |                        |
| 30' (7')*<br>4h                             | 5                                     | 7                         | 150                        | +                 | +                     | ++                       | ++           | ++                 | ++                         | ++                | +                      | +           | o          | ++    | +            | ++          | ++                 | A 256        |        | X      | 420 ml                           | Drum           |                        |
| 90' (2')*<br>4h                             | 5                                     | 10                        | 350                        | +                 | +                     | ++                       | ++           | ++                 | ++                         | o                 | +                      | +           | +          | ++    | +            | ++          | ++                 | A 257        |        | X      |                                  | Drum: H 6257   |                        |
| 45' (11')*<br>10' (5')*                     | 16                                    | 12                        | 80                         | +                 | +                     | ++                       | +            | +                  | +                          | +                 | ++                     | +           | +          | ++    | ++           | ++          | A 280<br>A 290     | X            | X      |        | Drum: H 6280<br>H 6290           |                |                        |
| 4h  | 18                                    | 6                         | 5<br>10<br>30              | ++                | ++                    | ++                       | +            | o                  | ++                         | o                 | +                      | +           | o          | ++    | ++           | +           | P 4302             |              |        |        | Drum                             |                |                        |
| 20'<br>45'                                  | 24                                    | 9                         | 40                         | ++                | ++                    | ++                       | ++           | o                  | o                          | o                 | o                      | ++          | +          | ++    | ++           | +           | A 300-1<br>A 310-1 | X            | X      |        | Drum                             |                |                        |
| 15'   | 27                                    | 3                         | 3                          | +                 | +                     | +                        | o            | +                  | ++                         | o                 | ++                     | o           | o          | +     | ++           | o           | A 130<br>A 135     | X<br>X       |        | 200 ml | Kit & drum:<br>H 9930            |                |                        |
| 4h30'                                       | 21                                    | 5                         | 2                          | ++                | ++                    | ++                       | o            | ++                 | ++                         | o                 | ++                     | ++          | +          | ++    | ++           | +           | A 140              | X            | X      |        | Kit & drum:<br>H 9940/<br>H 9945 |                |                        |
| 7h  | 32                                    | 4                         | 24                         | +                 | +                     | +                        | +            | +                  | ++                         | +                 | +                      | +           | +          | +     | ++           | +           | A 145              | X            | X      |        |                                  |                |                        |
| 8h  | 22                                    | 3                         | 8,5                        | +                 | +                     | ++                       | o            | +                  | ++                         | +                 | ++                     | ++          | +          | ++    | ++           | o           | A 155              |              |        | 420 ml | Drum: H 9955                     |                |                        |
| 3h30'                                       | 24<br>20                              | 5<br>3                    | 5                          | ++                | ++                    | ++                       | o            | ++                 | ++                         | +                 | ++                     | ++          | +          | ++    | ++           | +           | A 170<br>A 171     |              | X<br>X |        | Drum: H 9970<br>Drum: H 9971     |                |                        |
| 10h   | 21                                    | 4                         | 5                          | ++                | ++                    | ++                       | o            | ++                 | ++                         | +                 | ++                     | ++          | ++         | ++    | ++           | +           | A 175              |              | X      |        | Drum: H 9975                     |                |                        |
| 7h  | 24                                    | 5                         | 9                          | ++                | ++                    | ++                       | +            | +                  | ++                         | +                 | +                      | +           | +          | ++    | ++           | +           | H 9011             | X            | X      | 200 ml | Kit & drum                       |                |                        |
| 4h  | 18                                    | 3                         | 3                          | ++                | ++                    | ++                       | o            | +                  | ++                         | o                 | +                      | ++          | ++         | ++    | ++           | +           | H 9950<br>H 9950T  |              |        |        | Drum                             |                |                        |
| 6h  | 26                                    | 4                         | 10                         | ++                | ++                    | ++                       | +            | +                  | +                          | o                 | ++                     | ++          | +          | +     | ++           | +           | H 9951<br>H 9951T  |              |        |        | Kit & drum                       |                |                        |
| 8h  | 26                                    | 6                         | 3                          | ++                | ++                    | ++                       | +            | o                  | ++                         | o                 | +                      | ++          | ++         | ++    | ++           | +           | H 9952             | X            |        | 420 ml | Drum                             |                |                        |

# INDUSTRY: MARINE, SPORT AND LEISURE AND MILITARY

## MARINE/LEISURE...

Material composite bonding in those fields often requires.

- 1 Long pot life products.
- 2 Filling gaps between substrates.
- 3 Various composites laminates bonding abilities.
- 4 Slightly thixotropic for easy processing.



| Ref.    | Main features   | Open time | LSS (MPa) | Peel (N/mm) | Elongation (%) |
|---------|---|-----------|-----------|-------------|----------------|
| A 236   | Allows gaps up to 40mm and parts assembly with large dimensions (deck/hull, wind mill). Various reactivities and colours. Machine or hand mix version. Lloyd's Register.                      | 30'       | 14        | 4           | 60             |
|         |   | 90'       | 14        | 4           | 60             |
| 6236 HM | Special version for hand mixing, provided in ready to use kit.  | 120'      | 14        | 4           | 60             |
| A 155   | Pasty constructive adhesive with long pot life. For large composite parts, repair and maintenance. Good mechanical performance & chemical and temperature resistance. Impact Resist: 15 N/mm. | 120'      | 22        | 3           | 8.5            |
| A 310-1 | Excellent mechanical and thermal performances up to 120 °C. Multipurpose product with thermoplastic aspect. Product able to bond dissimilar materials. Fast bonding of stainless steel.       | 10'       | 45        | 20          | 40             |

## GENERAL INDUSTRY

Base on the experience acquired in high tech industries like automotive or aero, these products offer a wide range of adhesion for the majority of processes, from maintenance to industrial production.



| Ref.               | Main features   | Open time | LSS (MPa) | Peel (N/mm) | Elongation (%) |
|--------------------|---|-----------|-----------|-------------|----------------|
| A 130<br>A 135     | Fast cure at room temperature. Suitable for injection. Bonding of substrates such as composites, metal, wood, concrete.   | 6'        | 15        | 27          | 3              |
| H9011              | Multipurpose liquid adhesive. Bond most of materials. For general industry and maintenance.   | 100'      | 7h        | 24          | 5              |
| H9950              | Non-filled adhesive with low outgassing for aerospace applications (satellite, optical tables, performance tools...). Structural and panel bonding. Long open time.                 | 2h        | 4h        | 18          | 3              |
| A 300-1<br>A 310-1 | Excellent mechanical and thermal performances up to 120 °C. Multipurpose product with thermoplastic aspect. Product able to bond dissimilar materials.                              | 5'<br>10' | 24        | 9           | 40             |
| A 170<br>A 171     | High performances room temperature curing adhesive. Slow setting product adapted to cover and bond wide surfaces.<br>A 171: Self-extinguishing adhesive with FAR 25.853.            | 30'       | 3h30'     | 24          | 5              |
| A 175              | High performances room temperature curing adhesive. Slow setting product adapted to bond wide surfaces and heavy duty applications subject to impact or vibration. Shock resistant. | 90'       | 10h       | 21          | 4              |



## PANEL MANUFACTURING

SikaAxson developed with market leader of insulating panels a range dedicated to these specific applications : bonding skin on core and panel assembly.



| Ref.  | Main features   | Open time | LSS (MPa) | Peel (N/mm) | Elongation (%) |
|-------|---|-----------|-----------|-------------|----------------|
| P4302 | High dimension pannels bonding (skin on core), honeycomb (Nomex, aluminum, foam, thermoplastics...). Wood, aluminium or metal sheets.<br>3 Iso combinable (P 4004, 4002, 4003). | 120'      | 4h        | 18          | 6              |
| H6235 | Large dimensions assembly. Gap filling capacity. Used in industry assembling big parts.   | 90'       | 5h        | 13          | 6              |

# ANCILLIARY PRODUCTS

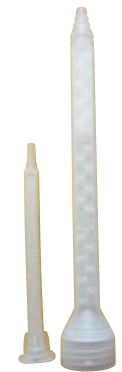
Axson technologies has selected a wide range of accessories hand tool equipment that combines perfectly with all materials listed.

## GUNS & MIXERS

All guns are designed for intensive work offering precision and productivity and are suitable for putty, liquid and all thixotropic systems. SikaAxson selected mixer «Turbo» in accordance with these different systems.

|                |           |         |   |
|----------------|-----------|---------|---|
| Manual Guns    | 50cc      | Z 30311 | 1 |
|                | 200cc     | Z 35657 |   |
|                | 400cc 2:1 | Z 35721 | 2 |
|                | 400cc 1:1 | Z 35738 |   |
| Pneumatic guns | 50cc      | Z 35220 | 3 |
|                | 200cc     | 06637   |   |
|                | 400cc     | Z 30317 |   |

| Cartridge    | Ratio     | Mixers        | Code   |
|--------------|-----------|---------------|--------|
| 50 cc        | 1/1 & 2/1 | Spiral 5 x 24 | C00602 |
|              |           | Turbo         | C00830 |
| 400 & 200 cc |           | Turbo         | Z36029 |



Mixers «Turbo»

## SURFACE PREPARATION

Surface preparation from cleaning to primer application is essential to optimize bonding properties. SikaAxson will recommend a surface preparation programme adapted to each case.



Glass Primer



Plastic Primer

|  | Glass Primer      | Plastic Primer | Metal Primer | Adekit Cleaner |
|--|-------------------|----------------|--------------|----------------|
| Code                                       | Z35850            | Z35670         | 06626        | Z35389         |
| Substrate                                  | Glass and plastic | Plastic        | metal        | -              |
| Colour                                     | black             | transparent    | ochre        | Colorless      |
| Density                                    | 0.90 ± 0.05       | 0.94 ± 0.02    | 1 ± 0.03     | 0.8            |
| Drying time<br>Touch dry                   | 15' at 20°C       | 5' at 20°C     | 15' at 23°C  | 5'             |
| Drying time before<br>adhesive application | 15' at 20°C       | 20' at 20°C    | 30' at 23°C  | 5'             |
| Application<br>temperature                 | 10° to 35°C       | 10° to 35°C    | 10° to 35°C  | 15° to 35°     |



Metal Primer



Adekit Cleaner

## PACKAGING

Several standard packaging are available depending on the recommended processing way from cartridges to large bulks. Final choice is a compromise between economical, productivity and overall quality performances.



Cartridge



Jerican



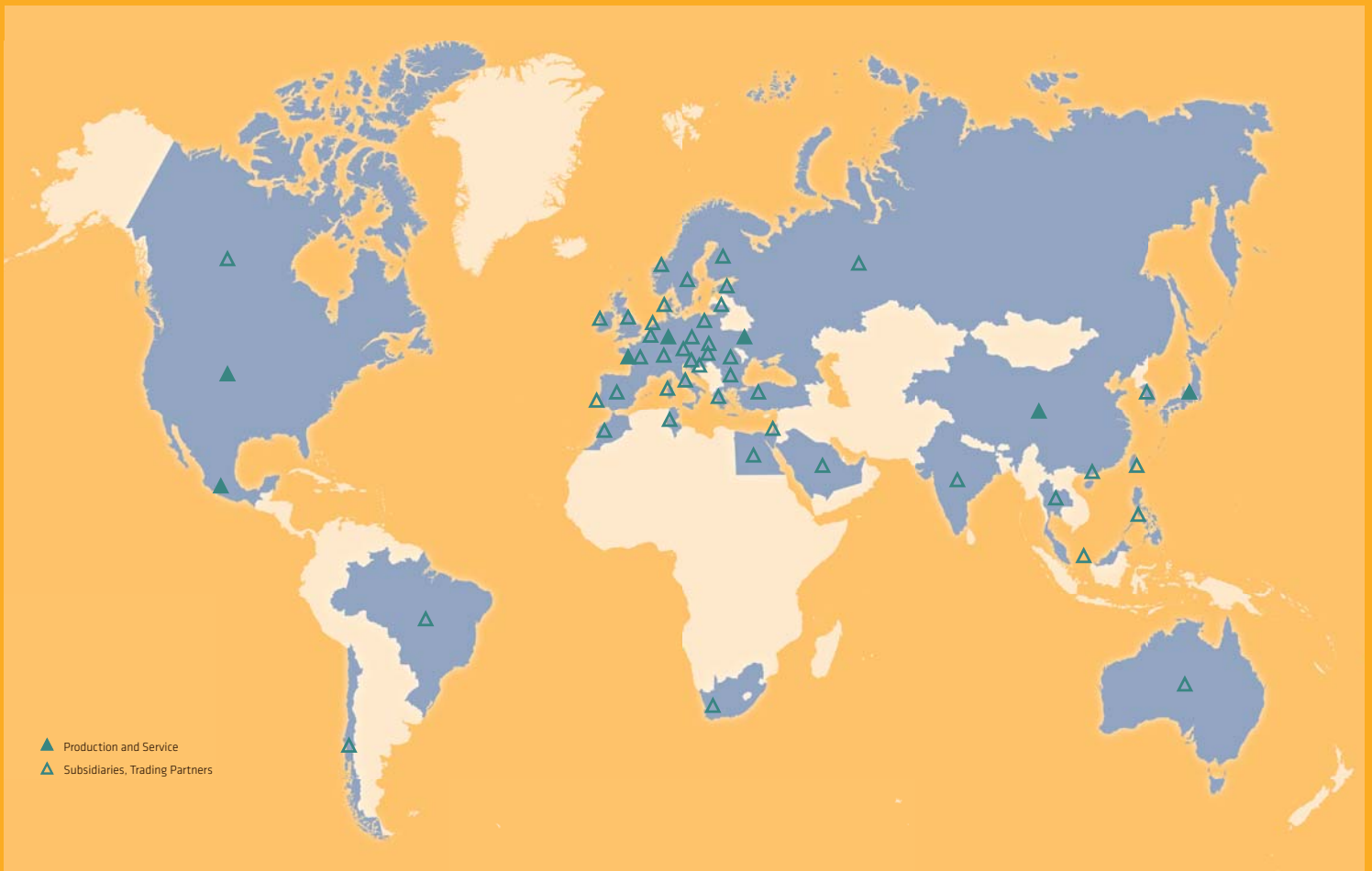
Pail



Drum



IBC



# GLOBAL SOLUTIONS - LOCAL SERVICE

Our most current General Sales Conditions shall apply.

Please consult the Product Data Sheet prior to any use and processing.

Actual Product Data Sheets and information about additional products please find in: [www.sikaaxson.fr](http://www.sikaaxson.fr) or [www.sikaaxson.com](http://www.sikaaxson.com)



ISO 9001



ISO 14001



RESPONSIBLE CARE



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