

THE ADEKIT RANGE

Your Solution for bonding

Axson have developed a wide range of structural adhesives (Epoxies, Polyurethanes and Methacrylates) tailored to respond to the vast majority of applications using bonding as a method of assembly. Our products have been formulated through strong partnerships established with our customers throughout the years and exhibit high performances as well as simple processing methods.

	Steels	Stainless steel	Galvanised metals	Aluminium	ABS	PMMA	PVC	PC	Nylons	Glass/Polyester Composites (SMC, GRP, RTM)	Carbon/Epoxy composites	Glass	Ceramics	Concrete/cement	Wood
A130	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A135	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A145	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A161	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A140	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A170	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A175	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
H9951	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A220	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A280	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A290	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A210	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A211	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A252	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
A310NF	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good

- Excellent
- Good
- Fair

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.



ADEKIT EPOXY MULTIPURPOSE (A 1XX)

- For simple assemblies
- Where mechanical loads are low during the assembly lifetime
- Which will be exposed to a moderate chemical and thermal environment
- For transparent assemblies

Ageing Performances:

- ★ Fair
- ★★ Good
- ★★★ Excellent

METHODS :

- Potlife at 25°C on 100g unless otherwise stated
- Open Time is the time until which the substrates can be assembled without affecting the assembly properties
- Lap Shear Strength (LSS) as in ISO 4587-95 and Peel Strength as in ISO 4578-95 on chromic acid etched 2017A Aluminium, cured 8hrs at 80°C followed by 48hrs at RT
- 1MPa corresponds to a strength at which the assembly can be manipulated
- Elongation as in ISO 527-96

ADEKIT

	Fast setting		Slow setting
	Liquid	Transparent	Liquid
	A130	A135	A145
Potlife (mins)	6	6	70
Open time (mins)	6	6	85
Time to reach 1MPa in Lap Shear Strength (LSS) at 25°C	15mins	15mins	7h
Time to reach 50% of full strength at 25°C	30mins	30mins	16h
Lap Shear Strength (MPa)	27	27	32
Peel strength (N/mm)	3	3	4
Elongation (%)	3	3	24
Overall ageing performances	★	★	★
Colours available			
Packagings			
Cartridges	50mL	50mL	50 & 400mL
Bulk	6(0,5+0,5)Kg	-	6(0,5+0,4)Kg (5 + 4)Kg
	-	-	

- To assemble thermoplastics and hard-to-bond materials
- To bond materials with high expansion coefficients
- With high mechanical performances
- Presenting good thermal and chemical resistance
- Where high production output is required

ADEKIT POLYURETHANE (A 2XX) & METHACRYLATE (A 3XX) ADHESIVES

ADEKIT	Fast setting				Slow setting		
	High mechanical & ageing performances			High elongation	High mechanical & ageing performances	High elongation	
	Very fast setting	Limited surface pretreatment					Self-extinguishing
	A290	A280	A310	A252	A220	A210	A211
Potlife (mins)	3	6	-	5 (50g)	9	45	35
Open time (mins)	3	10	15	8	16	60	40
Time to reach 1MPa in Lap Shear Strength (LSS) at 25°C	10mins	45mins	30mins	1h	90mins	5h	5h
Time to reach 50% of full strength at 25°C	30mins	3h	75mins	3h30	4h	18h	16h
Lap Shear Strength (MPa)	15	19	20	11	16	10	10
Peel strength (N/mm)	9	10	3	9	12	5	9
Elongation (%)	90	85	40	300	95	77	80
Overall ageing performances	★★★	★★★	★★★	★★★	★★★	★★	★★★
Colours available							
Packagings							
Cartridges	400mL	400mL	50 & 400mL	50 & 400mL	50 & 400mL	50 & 400mL	50mL
Bulk	-	(40+32)Kg	(40+32)Kg	(44+33)Kg	(6.5+5)Kg	-	-
	-	-	-	-	-	(27+42)Kg	-

LECTOR CHART

ADEKIT EPOXY HIGH PERFORMANCE (A 1XX)

Fast setting

Slow setting

Paste

Toughened

On-site application

High gap-filling

Toughened

Good gap-filling

Liquid

A161

A170

A140

A175

H9951

23

23

30

70

50 (50g)

40

30

40

90

60-70mins

2h30

3h30

4h30

10h

6h30

5h

19h

20h

20h30

20h

22

24

21

21

29

3

5

5

4

4

3

5

2

5

10

★★

★★★★

★★★★

★★★★

★★★★

400mL

400mL

400mL

50mL

50 & 400mL

400mL

-

-

-

-

-

6(0,5+0,45)Kg

(16+14)Kg

6(0.5+0.31)Kg

-

-

(5+4,5)Kg

-

(5+4,5)Kg

-

(5+3,1)Kg

-

-

-

-

(40+36)Kg

-

(25+15,5)Kg

- With high mechanical and thermal performances
- With good resistance when exposed to aggressive environments
- For assemblies which will be working under strong vibrations and impacts
- To bond high performance composites

ADEKIT GUIDELINES FOR YOUR ASSEMBLIES

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

■ Série A 1XX
 ■ Série A 2XX
 ■ Série A 3XX
 ■ Série A 1XX ou A 2XX
 ■ Série A 2XX ou A 3XX
 ■ Série A 1XX ou A 3XX
 ■ Série A 1XX ou A 2XX ou A 3XX
 ■ unexpected combination

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SURFACE PREPARATION PRODUCTS PRIOR TO BONDING

Careful pre-treatment of the surface before application of the adhesive is a fundamental step to ensure optimal performances of the assembly in its lifetime.

Axson supply a range of surface pre-treatment products suitable for all types of materials you may need to bond. It is strongly recommended to perform some testing with the selected primer to check its adequacy with the material to bond.

ADEKIT CLEANER

With adhesion promoters

Boxes of 6 x 0.794Kg

METAL PRIMER

Aluminium, Copper, Steel
(untreated, chromated, galvanised)

1Kg

Diluent 1Kg

POLYESTER PRIMER

GRP, SMC, filament winding, etc

Boxes of 6 x 1.314Kg

THERMOPLASTIC PRIMER

ABS, PVC, PC, PMMA

1Kg



A datasheet explaining how to use these primers is available from our Technical Support Dept and from our Website.

AVAILABLE ADEKIT PACKAGING AND APPLICATION EQUIPMENT

ADEKIT 50ML AND 400ML CARTRIDGES

with their corresponding static mixers and guns.

APPLICATION EQUIPMENT FOR ADEKIT CARTRIDGES

Manual guns for ADEKIT 50mL cartridges

Code : Z30311

Pneumatic guns for ADEKIT 50mL cartridges

Code : Z35220

Manual guns for ADEKIT 400mL cartridges

Code : Z35104

Pneumatic guns for ADEKIT 400mL cartridges

Code : Z30317



A datasheet explaining how to use these primers is available from our Technical Support Dept and from our Website.

SMALL KITS OF 1KG AND 5 KG

INDUSTRIAL PACKAGING IN 30L AND 220L



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