

PRODUCT DATA SHEET

SikaPower®-752 L120 FR BLACK (AB) (Adekit H9952BK)

TWO-COMPONENT EPOXY ADHESIVE

SELF-EXTINGUISHING ACCORDING TO EN 45545-2, FAR 25§853, ABD0031 - HIGH AGEING RESISTANCE

DESCRIPTION

High performances assembly
 Bonding of panels: honeycomb, aluminum sheet, stainless-steel sheet, composite materials, wood, thermoplastics, foam...
 Bonding of Carbon & glass epoxy composite, Polyester composite, metal structure

PROPERTIES

- High performances two components Epoxy adhesive, especially formulated to bond high dimensions surfaces and providing high level of mechanical and aging properties.
- Nano enhanced systems
- **Self-extinguishing according to EN 45545-2, FAR 25 (FAR 25§853) and AITM (ABD0031) Standards.**
- Contains 250 µm beads to calibrate adhesive thickness
- High sheer and peel
- Long open time for big parts assembly

PHYSICAL PROPERTIES

Composition	RESIN	HARDENER	MIX	METHOD
Mix ratio by weight	100	47		
Mix ratio by volume at 25 °C	100	50		
Aspect	Thixotropic paste	Thixotropic paste	Thixotropic paste	
Colour	Black	Beige	Black	
Viscosity at 25 °C ^(KP) (Pa.s)	145	185	80	LT-001/vit.10
	350	600	230	LT-001/vit.2.5
Density at 25 °C ^(KP)	1.40	1.30	-	LT-020
Density of cured product at 23 °C	-	-	1.38	LT-047
Pot life on 100 g at 23 °C ^(KP) (min)	-	-	120	LT-002-B

(KP) Key properties. These values are enclosed in Certificate of Analysis.

MECHANICAL PROPERTIES ⁽¹⁾

Hardness	(Shore D)	85	ISO 868
Tensile strength	(MPa)	42	ISO 527
Elongation at break	(%)	3	ISO 527
YOUNG Modulus ⁽²⁾	(Mpa)	4000	ISO 527
Recommended use temperature (°C)		15 to 30	
Working temperature ⁽³⁾	(°C)	- 40 to 150	LT-006-B

(1) Cured 16 hours at 70 °C

(2) Cured 1 h at 80 °C

(3) Working temperature is defined as the temperature at which product keeps 80% of its initial Lap Shear Strength after 1000 hours ageing at this temperature, value on Aluminium, measured at 23 °C.

SELF-EXTINGUISHING PROPERTIES

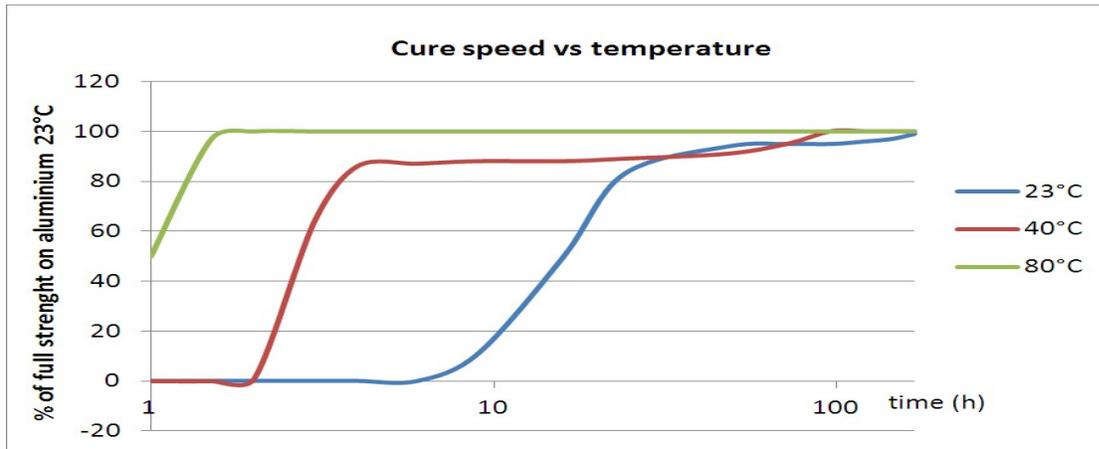
FIRE / SMOKE PROPERTIES – RAILWAY APPLICATIONS

Fire protection on railway vehicles	R1 HL3	EN 45545-2
Part 2 : requirements for fire behavior of materials and components	R2 HL3	
	R3 HL3	
	R6 HL3	
	R7 HL3	
	R17 HL3	

FIRE / SMOKE PROPERTIES – AIRCRAFT APPLICATIONS

	NORME	EXIGENCE
Determination of the resistance of the material to flame	AITM 2-0002 A (issue 3)	ABD0031 (issue G)
Vertical Bunsen Burner,	CS 25 App. F Part. I §(a)(1)(i)	CS 25 §853(a), Amdt 20
60 s ignition time	FAR 25 App. F Part. I §(a)(1)(i)	FAR 25 §853(a), Amdt 25-116
Determination of the resistance of the material to flame	AITM 2-0002 B (issue 3)	ABD0031 (issue G)
Vertical Bunsen Burner,	CS 25 App. F Part. I §(a)(1)(ii)	CS 25 §853(a), Amdt 20
12 s ignition time	FAR 25 App. F Part. I §(a)(1)(ii)	FAR 25 §853(a), Amdt 25-116
Determination of the Specific Optical Density of Smoke	AITM 2-0007 A (issue 3)	ABD0031 (issue G)
	CS 25 App. F Part. V	CS 25 §853(d), Amdt 20
	FAR 25 App. F Part. V	FAR 25 §853(d), Amdt 25-116
Determination of the Toxic Components on Combustion Products	AITM 3-0005 (issue 2)	ABD0031 (issue G)

CURING DATAS



HANDLING TIME ⁽¹⁾

At 23 °C	(h)	8	LT-006-B
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(1) Handling time is defined as the time needed to obtain Lap Shear Strength on Aluminium at 23 °C, of 1 MPa.

MECHANICAL PROPERTIES ON ASSEMBLIES ⁽¹⁾

	LAP SHEAR STRENGTH AT 23 °C (MPa)		METHOD
	Initial		
Aluminium 2017A (sandblasted)	Initial	22 SCF	LT-006-B
	After wet cataplast 7 days at 70 °C / 100 % RH	22 SCF	
	After wet cataplast 14 days at 70 °C / 100 % RH	20 SCF	
	After wet cataplast 21 days at 70 °C / 100 % RH	17 SCF	
	After wet cataplast 28 days at 70 °C / 100 % RH	17 SCF	
Stainless Steel 304 (sandblasted)	Initial	25 SCF	LT-006-B
	After wet cataplast 7 days at 70 °C / 100 % RH	24 SCF	
Electro-galvanized Steel (sandblasted)	Initial	22 AF	
	After wet cataplast 7 days at 70 °C / 100 % RH	16 SCF	
Pre preg Carbone Composite		17 SCF	
Polyamide		5 SF	

(1) Cured 16 hours at 70°C

SCF: Special Cohésive Failure, AF: Adhesive Failure, SF: Substrate Failure, according to EN ISO 10365 Standard.

FLOATING ROLLER PEEL STRENGTH AT 23°C

	(kN/m)	Initial		ISO 4578
Aluminium 2017A (sandblasted)			5	
		After wet cataplast 7 days at 70 °C / 100 % RH	4.5	

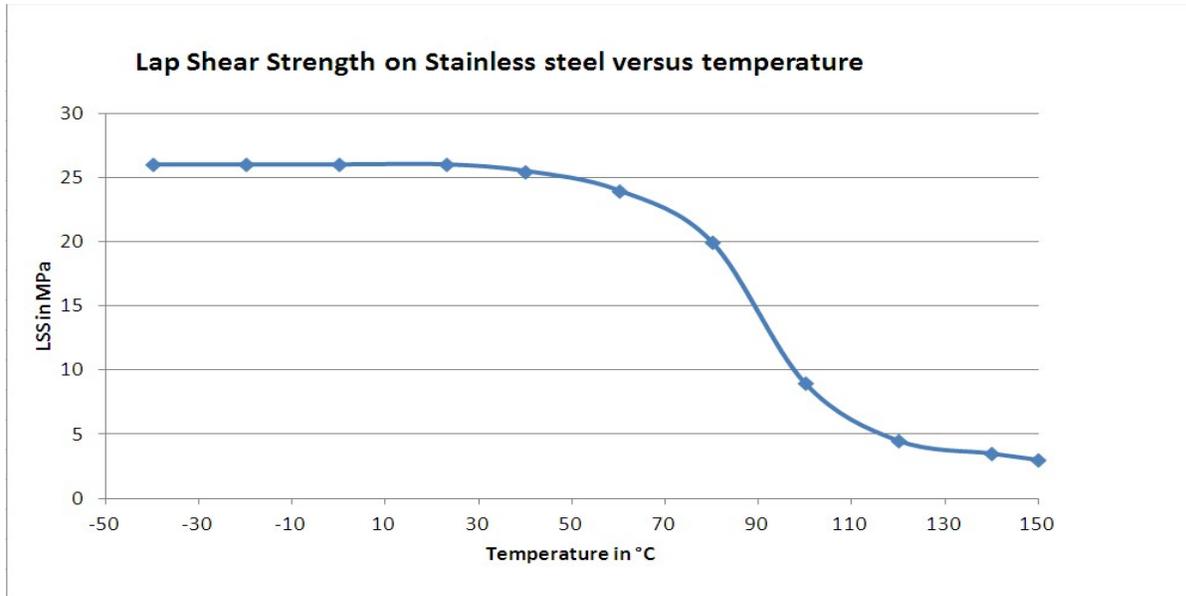
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(Adekit H9952BK)

May 2023, Version 01 /2023

Sika Advanced Resins



PROCESSING

- **Equipment:** SikaPower®-752 L120 FR BLACK (AB) packaged in 50 ml and 400 ml cartridges and require 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 about surface preparations.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheet.

STORAGE CONDITIONS

Shelf life of **SikaPower®-752 L120 FR BLACK (AB)** is **24 months** in a dry place and in original unopened containers at a temperature between 15 °C and 25° C.

Shelf life of **SikaPower®-752 L120 FR (A) BLACK (Resin)** is **24 months** in a dry place and in original unopened containers at a temperature between 15 °C and 25° C.

Shelf life of **SikaPower®-752 FR (B) (Hardener)** is **24 months** in a dry place and in original unopened containers at a temperature between 15 °C and 25° C.

PACKAGING

- | | |
|--|---------------------|
| ▪ SikaPower®-752 L120 FR BLACK (AB) / 50ml | Box of 12 cartridge |
| ▪ SikaPower®-752 L120 FR BLACK (AB) / 400ml | Box of 12 cartridge |
| ▪ SikaPower®-752 L120 FR (A) BLACK (Resin) | Pails of 39 kg |
| ▪ SikaPower®-752 FR (B) (Hardener) | Pails of 37 kg |
| ▪ KIT SikaPower®-752 L120 FR (A) BLACK +
SikaPower®-752 FR (B) | (2 x 39 kg + 37 kg) |

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets.

VALUE BASES

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTICE

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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