

A-J215

1-component fast-curing, high-strength elastomeric adhesive

Product Description

A-J215 is a one-component elastic adhesive based on silane-modified polymer and provides excellent adhesion to most metals, thermoplastics, composites and other substrates common to the commercial vehicle industry¹. It is isocyanate & solvent-free, fast-curing, and highly flexible; it is intended for use in semi-structural bonding applications for vehicle assembly. Available in 290ml cartridges, 600ml sausage packs, 20L [5gal] pails, and 200L [50gal] drums.

Technical Data

TYPICAL PROPERTIES			
		A-J215	Test Method
Physical Properties	Appearance	Black, white, grey	-
	Tack-Free Time	30 min.	-
	Cure-Rate ²	2 - 3mm/24h	-
	Viscosity	180,000 cPs - 280,000 cPs	-
	Shore A Hardness	50	DIN 53505
	Density	1.6 kg/L, [13.3 lb/gal]	-
	Application Temperature ³	5 to 40°C, [40 to 104°F]	-
	Service Temperature	-40 to 100°C, [-40 to 212°F], brief periods to 120°C, [248°F]	-
Mechanical Properties	Tensile Strength	2.0 MPa, [290 psi]	DIN 53504
	E Modulus @ 100%	≥ 1.2 MPa, [174 psi]	DIN 53504
	Strain-to-Failure	≥ 250%	DIN 53504
	Volume Resistivity	-	-
	Solvent Content	None	-

Chemical Resistance⁶ Good resistance to water, salt water and mild acids and caustics. Not resistant to fuels, polar solvents, chlorine, strong acids & bases. Resistance to any expected chemical exposure should be tested against specific customer conditions and exposures.⁵

Environmental Resistance Resistant to weathering, salt spray & UV-radiation (QUV, 500h).

Shelf Life & Storage Conditions

Shelf Life	Best results within 12 months (bulk), 12 months (cartridge & sausage pack) – stored at <25°C, [77°F] in original packaging. Long-term exposure to elevated temperature can cause the material to lose performance characteristics.
Special Handling	Keep away from direct sunlight and all sources of heat and ignition. Do not apply in the presence of curing silicone. Do not use any alcohol or alcohol containing products in the presence of curing product.

Surface Preparation

General	The following recommendations are for informational purposes only. Before attempting any bonding application users should test the adhesion to the surface using their specific material and application. Any applications involving critical or serial production should consult L&L Products Technical Service & Support Staff. Surfaces must be clean, dry; and free of dust, debris and any loose oxides or coatings. Residual oils and grease must be removed. Clean surfaces thoroughly using a general purpose industrial organic solvent, and allow to completely flash-off. It may be necessary to use an additional surface preparation product or mechanical process. Consult L&L Products Technical Service & Support Staff.
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Application

Cartridge & Sausage Application	Pierce the top of the cartridge to permit extrusion. A partially-used cartridge can be stored with the nozzle in place. To continue use, replace nozzle and continue. Remove one end of a sausage pack with a knife or snippers. Put the sausage adapter in place and ensure there is a retaining ring on the applicator barrel. Partially used sausages can be stored with the sausage adapter or nozzle in place. To continue use, replace the sausage adapter or nozzle and continue. Ensure cartridges/sausages are within the application temperature range before applying.
Bulk Application	L&L Products elastomeric adhesives can be applied by several commercially available pumping systems. Consult with L&L Products Technical Service & Support staff for advice on selection and operation of pumping systems.
Bonding Process	Parts should be mated and in final position before the expiration of the working time, and should remain in position, unstressed & undisturbed until the material is sufficiently cured to support the bonded parts without movement. Note that working and cure-rate are heavily influenced by temperature and humidity. Warm, humid conditions shorten working times and cool, dry conditions slow the curing process. The application temperature for the adhesive, parts and bonding area should ideally be between 15-30°C [60-85°F]. Use enough adhesive to completely fill the desired bond area and avoid entrapping air within the joint. Avoid over-squeezing the joint causing insufficient material to remain in the bond area once any clamps or jigs are removed.
Sanding & Overpainting	L&L Products elastomers are generally sandable & overpaintable. It is necessary to test any paint-system before beginning a new bonding application. Consult L&L Products Technical Service & Support Staff.
Tooling & Clean-Up	Excess material should be removed before curing. Do not use any alcohol or alcohol-containing product as a tooling agent, or for clean-up of excess material. Avoid disturbing the bond area during clean-up. After curing, the material must be removed mechanically, followed by a light solvent wipe to remove any residue.

Health & Safety

Safety Precautions	Avoid contact with skin and eyes. Consult product-specific Safety Data Sheet for all safety and environmental information concerning use and disposal of this product.
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Notes	<ol style="list-style-type: none">1. Test all applications according to anticipated production and service conditions.2. Varies with ambient conditions. Tested at 23°C/50% R.H.3. Skin development and cure-rate vary widely with ambient conditions. Evaluate adhesive performance at anticipated application conditions. Consult L&L Products Technical Service & Support Staff.4. Test all serial or critical applications for adhesion and mechanical performance. Consult with L&L Products Technical Service & Support Staff.5. Chemical resistance heavily influenced by concentration, temperature, frequency and duration of exposure. Consult L&L Products Technical Service & Support Staff.
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