



# H 6257 - A 257

Flexible polyurethane adhesive

- Product adapted to assemblies involving dissimilar materials.
- Fast setting product adapted to reduce assembly time.
- Very high heat reactivity.
- Flexible product.
- Very high heat reactivity.
- Low hardness, low modulus of elasticity.
- High elongation at break.
- Chemical thixotropic system. Can be applied on vertical applications and to fill irregular joints.
- Available in cartridges.

**Automotive industry**  
**Transport**  
**Bus**



# A 257 FLEXIBLE POLYURETHANE ADHESIVE H6257-A 257



## Benefits:

This new polyurethane adhesive has been designed to offer a high flexibility to absorb CTE gap between different materials like composite and metal or thermoplastic.

Thanks to this flexibility, totally different materials can be bonded without any mechanical or cosmetic issue, opening new possibilities in term of design and cost efficiency.

A 257 offers a comfortable open time of 5 minutes and the possibility to cure at room temperature.



### >Automotive market.

Bonding of SMC to SMC and SMC to Coated steel inserts for composite spoilers production . Bonding of SMC to SMC or SMC / Plastic.

Bonding of coated "big head" inserts to composite body parts for sport cars.

### >Trucks market

Bonding of RTM to RTM (glass polyester parts) for roof trucks production.

Bonding of RTM to coated metallic inserts for roof trucks production.

### >Composites & general industry

Bonding of powder painted metallic inserts on RTM bath tubes.

Bonding of aluminium profiles for honeycomb panel edging

# A 257 FLEXIBLE POLYURETHANE ADHESIVE H6257-A 257



## ➤ Recommendations

**H6257** is recommended for applications between -30°C and 100°C.

The chemical thixotropy of this product does not permit manual mixing. The use of a dual-component dosing machine or ADEKIT cartridges is recommended.

**H6257 (or A257)** is highly reactive. Therefore special care must be taken to respect the open time for this product. Polymerization at "high temperatures" may be achieved using infra-red lamps, or heating or induction pads in order to reduce assembly handling times.

The **H6257** product shall preferably be used on substrates receiving the following surface preparations:

## ➤ Surface preparation

- SMC BMC ZMC\*
- RTM – GELCOAT
- RTM – FIBRE
- EPOXY LAMINATE
- PHENOLIC STRATUM
- THERMOPLASTIC SUBSTRATE

DIRECT  
BONDING

OR



SANDING



ADEKIT  
CLEANER

- UNTREATED METAL FRAME
- STAINLESS STEEL/ALUMINIUM/  
STEEL INSERT
- UNCOATED METAL SUPPORT



SANDING



ADEKIT  
CLEANER



PRIMER  
METAL

- WET POLYESTER LAMINATE



SANDING

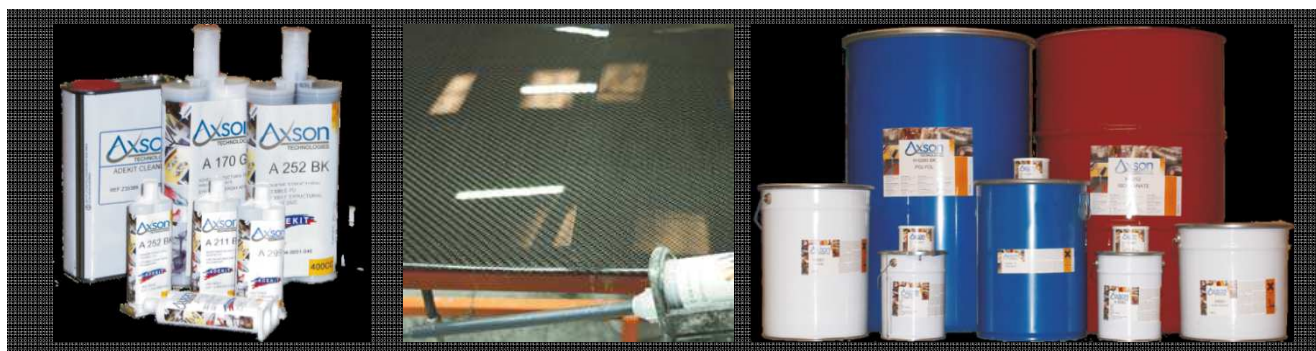


ADEKIT  
CLEANER

\* if applied directly, preliminary bonding tests are necessary.

\*\* on polyester coatings, a test must be carried out to check the bonding properties.

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## ➤ Conditioning/Accessories and auxiliary products

APPLICATIONS	PRODUCTS
M10-24 static mixers	To be used for machine applications and cartridges
RZ444 – RZ303	Cleaning machines
400 cc cartridge pneumatic gun	Recommended for use with cartridges
ADEKIT CLEANER	Cleaning & preparing surfaces before assembly
METAL PRIMER	Preparing metal substrate surfaces before assembly

## ➤ Conditioning references

**08370 ADEKIT A 257/400 BK 12 pcs**

