

## Technical Data Sheet

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### technicoll® 8055 Contact adhesive



#### Field of application

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Fast handling multifunctional contact adhesive with high initial tack and long contact life for porous substrates. Adhesion caused by technicoll® 8055 shows an excellent heat and water resistance (DIN 68705/AW100-test).

#### Handling data and product data

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Base	polychloroprene
Viscosity (+20 °C)	approx. 2300 mPas
Solid content	approx. 23 %
Density	approx. 0.9 g/cm <sup>3</sup>
Colour	brown yellow
Drying time	approx. 1 to 3 minutes
Contact life	approx. 5 to 20 minutes (depending on temperature, substrate and quantity of adhesive)
Way of application	two-sided
Processing temperature	+15 °C to +25 °C
Consumption	150 - 250 g/m <sup>2</sup> (two-sided application)
Dilution	not necessary, possible with technicoll® 8367
Cleaning agent / material	technicoll® 8367 technicoll® 9901 (metal cleaning spray) technicoll® 9902 (plastics cleaning spray)
Cleaning agent / tool	technicoll® 8367, technicoll® 9901 (spray)
Cleaning	Solid adhesive can only be removed mechanically.
Maximum time of storage	At least 18 months when stored in sealed original packaging in cool and dry places.
Preferred storage temperature	+10 °C to +25 °C
Behaviour at low temperature	Not susceptible to frost. Densification at low temperature. Once adjusted to processing temperature: fully employable.

## Favoured substrates

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- rubber
  - expanded rubber
  - fabrics, textile
  - leather
  - cork
  - plastics unplasticised
- to each other and:
- metals
  - PUR foam
  - derived timber products
  - coated surfaces (primed, painted)

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, PVC-plasticised (faux leather)  
PS-rigid foams (e.g. Styropor®)

Due to the large variety of possible materials and differences in adhesion behaviour hazard tests are mandatory before introducing the adhesive into the actual production process.

## Surface preparation

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Bonding surfaces must be dry and clean, especially free of oil, grease or release agents. In many cases, surface roughening prior to bonding improves strength of bonded joint. It is recommended when working with rubber and metals.

## Adhesion

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Stir adhesive before use. Apply a thin layer of technicoll® 8055 equally to both sides of the bonding surface of the substrates (brush, spraying gun). After the application solvent needs to evaporate. The usual waiting time is just a few minutes. It depends on the applied amount of adhesive and the indoor climate. The right time for the bonding has come as soon as the applied adhesive does not pull strings anymore when touching with the finger, but still feels very sticky. Join the substrates together accurately and assemble quickly under high pressure. The good bond strength that is achieved immediately, usually allows further processing with the bonded substances right away. Completely dried but not finally cured layers of adhesive can be activated by applying a solvent like technicoll® 8367.

Wait for a couple of days before assessing the final strength.

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**page 2/2**

Deviating information of earlier versions is invalid.

### Special notice:

All information given on this data sheet is based on our knowledge and experience at the time of printing. The information is not binding. We advise to determine the suitability of our products with respect to their intended use and method of application. Therefore, a warranty claim cannot be granted.