

Technical Data Sheet



technicoll® 8266/8267 Paste-like 2-component epoxy adhesive

Field of application

Use technicoll® 8266/8267 for bonding metals, ceramics, thermosets, rubber, derived timber products and rigid foam.

Handling data and product data

	technicoll® 8266 A	technicoll® 8267 B	product
Mixing ratio			
Volume	100	100	
Mass	100	85	
Density	1.3 g/cm ³	1.1 g/cm ³	1.2 g/cm ³
Viscosity (+25 °C)	approx. 496 Pas	approx. 400 Pas	approx. 410 Pas
Colour	red	brownish	red-brownish
Pot life (+25 °C)	for 100 g for 500 g	70 minutes 50 minutes	
Curing time	approx. 12 hours		
Solid content	100 %		
Shore hardness D	approx. 70 (curing 30 minutes at +120 °C)		
Processing temperature	+15 °C to +25 °C		
Consumption	150 - 250 g/m ²		
Way of application	one-sided		
Dilution	not possible		
Cleaning agent / material	technicoll® 8363 technicoll® 9901 (metal cleaning spray) technicoll® 9902 (plastics cleaning spray)		
Cleaning agent / tool	technicoll® 8362, technicoll® 9901 (spray)		
Cleaning	Cured adhesive can only be removed mechanically.		
Maximum time of storage	At least 3 years 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

- metals - blank
- ceramics, stone, concrete
- rubber
- thermosets (FRP, SMC)
- rigid foams
- derived timber products
- phenoplastics (HPL, DKS)

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

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.

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Surface preparation

Joint 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 a bonded joint.

Adhesion

Mix technicoll® 8266/8267 accurately before bonding. Apply adhesive in a thin bead, drop or film to the surfaces to be bonded. Assemble and clamp the joint components within the pot time. Wait for a couple of days before assessing the final strength.

Curing

At room temperature the bonds can be handled after 12 hours. The curing time can be shortened by heat, e.g. drying oven.

+50 °C	to approx.	4 hours
+100 °C	to approx.	60 minutes
+150 °C	to approx.	15 minutes

Properties of cured adhesive (etched aluminum at +20 °C)

Peel strength (DIN 53289)	approx. 4.5 N/mm, (Roller peel test, after curing 7 d/+20 °C)
Lap shear strength (DIN 53283)	20 - 22 N/mm ² (after curing 7 days at +22 °C) 30 - 32 N/mm ² (after curing 30 minutes at +125 °C)

Technical status: 22.12.2015

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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.