

## Technical Data Sheet



### technicoll® 8278/8279

### 2-component epoxy adhesive, for sandwich adhesion of large area surfaces

#### Field of application

technicoll® 8278/8279 is a non-sagging 2-component adhesive for bonding metals, ceramics, thermosets, rubber, derived timber products and rigid foams.

#### Handling data and product data

Mixing ratio	technicoll® 8278	technicoll® 8279	adhesive
Volume	100	100	
Mass	100	100	
Density	1.6 g/cm <sup>3</sup>	1.6 g/cm <sup>3</sup>	1.6 g/cm <sup>3</sup>
Viscosity (+25 °C)	approx. 80 Pas	approx. 90 Pas	non-sagging
Colour	light pink	ivory	light purple
Pot life (+20 °C)	(100 g) 90 minutes (500 g) 70 minutes		
Curing time	approx. 12 hours		
Solid content	100 %		
Processing temperature	+15 °C to +25 °C		
Consumption	200 - 250 g/m <sup>2</sup>		
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	Solid adhesive can only be removed mechanically.		
Maximum time of storage	At least 2 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

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

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, PVC-p (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.

## Surface preparation

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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. When working with rubber and thermosets, it is generally advised.

## Adhesion

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Mix technicoll® 8278/8267 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

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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
+75 °C	to approx.	2 hours
+100 °C	to approx.	60 minutes
+125 °C	to approx.	20 minutes
+150 °C	to approx.	15 minutes

The mentioned temperatures are valid for the gap. If the adhesive is only supposed to tack cure, half of the mentioned times are sufficient when the temperature is between +50 °C to +150 °C. Final curing happens at room temperature. Final curing at room temperature is achieved after approximately 7 days.

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

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Lag shear strength (DIN 53283)	17 N/mm <sup>2</sup> (after curing 7d/+23 °C)
E-modulus	ca. 520 N/mm <sup>2</sup> (after curing 7d/+23 °C)

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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.