

Technical Data Sheet



technicoll® 9111 Plastics adhesive

Field of application

technicoll® 9111 is a multipurpose plastics adhesive for bonding small area surfaces of different thermoplastics to each other and to other materials.

Handling data and product data

Base	polyacrylate
Viscosity (+20 °C)	approx. 400 mPas
Density	0.9 g/cm ³
Colour	colourless
Wet bonding time	approx. 10 to 30 seconds (application on one side) maximal 1 minute (application on both sides)
Way of application	one- and two-sided
Processing temperature	+15 °C to +25 °C
Consumption	100 - 150 g/m ² (depending on temperature, substrate and quantity of adhesive)
Diluent	not necessary, possible with technicoll® 8362
Cleaning agent / material	technicoll® 8363 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 1 year when stored in sealed original packaging in cool and dry places.
Safety recommendations	refer to MSDS
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

- | | | |
|--------------------------|---------------------|---------------------------|
| ● ABS, PS, SB, ASA, PMMA | to each other or to | ● derived timber products |
| ● SAN, PVC-u, celluloid | | ● paper, paperboard |

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

Bonding surfaces must be dry and clean, especially free of oil, grease or release agents. Use technicoll® 8363 for cleaning plastic surfaces.

Application of the adhesive

Apply a thin layer of technicoll® 9111 to one or both sides. For porous surfaces a second layer of technicoll® 9111 may be necessary.

Adhesion

Join the parts right after the adhesive is applied, so both sides of the substrates are covered with wet adhesive. The wet bonding time when applying to one side is about 10 to 30 seconds, max. 1 minute when applying to both sides. Assemble the substrates under pressure until a sufficient strength for further processing is achieved (probably 5 to 10 minutes).

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

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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.