



technicoll® 9117 Transparent contact adhesive

Field of application

technicoll® 9117 is suitable for contact bonding of many different plastics and other materials, especially for plasticised materials. technicoll® 9117 can either be used with or without adding cross linking agent technicoll® 9966. When used in combination with technicoll® 9966, the resistance to plasticisers, ageing, water and heat is increased.

Handling data and product data

Base	polyurethane
Viscosity (+20 °C)	approx. 3000 mPas
Density	approx. 0.9 g/cm ³
Colour	colourless, transparent
Hardener / cross linking agent	technicoll® 9966
Mixing ratio	100:5 to 100:10 (wt/wt)
Pot life	approx. 12 hours
Drying time	approx. 5 to 10 minutes (cold bonding) > 30 minutes (heat bonding)
Contact life	approx. 15 minutes (cold bonding)
Way of application	two-sided
Processing temperature	+15 °C to +25 °C
Consumption	150 - 250 g/m ² (two-sided application)
Dilution	not necessary, possible with technicoll® 8362
Cleaning agent / material	technicoll® 8363 technicoll® 9901 (material 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 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

- ABS, SAN, PVC-u, PA
- PVC-p, faux leather
- polycarbonate (PC)
- PMMA
- elastomers (PUR and nitrile rubber)
- leather, textiles
- painted and coated surfaces
- fibre reinforced plastics (FRP)
- derived timber product
- PUR, PUR-foam
- polyester (PET)
- cellulose ester

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, EPS, XPS (e.g. Styropor®), metals

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.

Addition of cross linking agent

technicoll® 9117 can be used with cross linking agent technicoll® 9966. technicoll® 9966 increases the heat and water resistance and is recommended when adhesion requires resistance to heat > +50 °C, or is constantly exposed to weather conditions or water.

Adhesion

Apply a thin layer of technicoll® 9117 equally to both sides of the joint surfaces (brush, trowel, closed roller). The adhesive will be sprayable by adding 20 – 25 % diluting agent technicoll® 8362. Drying time and contact life of cold bonding are half as long as the above mentioned times.

Cold bonding: After applying technicoll® 9117, the solvent needs to evaporate for 5-10 minutes.

Join the substrates together accurately and assemble quickly under high pressure.

Heat bonding: After applying technicoll® 9117, the solvent needs to evaporate completely (at least 30 minutes). Join the substrates together accurately and assemble under high pressure at 80 °C.

Apply pressure until the bonding joint has cooled down.

Adhesion has a high initial strength. 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.