Technical Data Sheet

technicoll® 9118
Contact adhesive

Field of application

technicoll® 9118 is a one component adhesive for laminating leather, textiles and synthetic materials.

Handling data and product data

Base	natural rubber
Viscosity (+20 °C)	approx. 6000 mPas
Density	approx. 0.7 g/cm^3
Colour	light yellow
Contact life	approx. 2 hours
Maximum time of storage	At least 6 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

Due to the large variety of possible materials and differences in adhesion behavior 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. In many cases, surface roughening prior to bonding improves strength of bonded joint. It is recommended when working with rubber and metals.

Adhesion

Apply a thin layer of technicoll® 9118 equally to both sides of the bonding surface of the substrates. 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.

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