

Technical Data Sheet

technicoll® 9145 + technicoll® 9964 2-component PUR contact adhesive, sprayable



Field of application

Use technicoll® 9145 for contact bonding of many kinds of plastics to each other and to other substrates. The adhesive is suitable for plasticised materials. technicoll® 9145 is used with cross linking agent technicoll® 9964. Using the cross linking agent, the resistance of technicoll® 9145 to plasticisers, ageing, water and heat can be increased.

Handling data and product data

Base	polyurethane
Viscosity (+20 °C)	approx. 700 mPas
Density	approx. 0.9 g/cm ³
Colour	transparent, yellowish
Cross linking agent	technicoll® 9964
Mixing ratio	100:10 (wt/wt)
Pot life	approx. 12 hours
Drying time	approx. 5 minutes
Contact life	approx. 15 minutes
Temperature resistance	approx. +120 °C with cross linking agent technicoll® 9964 (depending on substrate and mechanical pressure)
Way of application	two-sided
Processing temperature	+15 °C to +25 °C
Consumption	150 - 250 g/m ² (two-sided application)
Diluent	not necessary, possible with technicoll® 9668
Cleaning agent / material	technicoll® 8363 technicoll® 9902 (plastics cleaning spray)
Cleaning agent / tool	technicoll® 9668, 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.
Preferred storage temperature	+10 °C to +25 °C
Behaviour at low temperature	technicoll® 9145: Not susceptible to frost. Densification at low temperature. Once adjusted to processing temperature: fully employable. technicoll® 9964: crystals may be generated when storing under +10 °C, after tempering to room temperature by warming adhesive, crystals will be dissolved.

Favoured substrates

- ABS, SAN, PVC-unplasticised
- PVC-plasticised, faux leather
- thermosets (CRP, GRP)
- metals (primed, coated)
- elastomers (PUR and nitrile rubber)
- cellulose ester
- derived timber products
- PUR, PUR-foam
- poly ethylene terephthalate films
- textiles
- leather
- surfaces (primed, coated)

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, PS-rigid foam (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

Joint surfaces must be dry and clean, especially free of oil, grease or release agents. In order to clean surfaces, technicoll® 8363 is recommended. In many cases, surface roughening prior to bonding improves strength of bonded joint. This is especially recommended when bonding elastomers.

Addition of cross linking agent

technicoll® 9145 can be used with cross linking agent technicoll® 8355. technicoll® 8355 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® 9145 equally to both sides of the bonding surface of the substrates with a spraying gun (1.5 mm rotating nozzle, atomizer pressure approx. 5 bars). Then the 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. A second layer of technicoll® 9145 might be necessary for porous and rough surfaces.

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.