

Technical Data Sheet



technicoll® 9403 **2-component high-performance structural adhesive,** **very fast curing**

Field of application

technicoll® 9403 is a flexible, fast curing 2-component adhesive with high temperature resistance.

Handling data and product data

technicoll® 9403	resin	activator	adhesive
Mixing ratio	100 volume	100 volume	
Colour	red	green	translucent
Viscosity			approx. 5.000 mPas
Density			1.0 (g/cm ³)
Base	acrylate		
Pot life (+20 °C)	3 minutes		
Initial strength	after approx. 15 minutes		
Curing strength	after approx. 6 hours		
Way of application	one-sided with mixing nozzle, bead on bead or no-mix-process		
Processing temperature	+15 °C to +25 °C		
Temperature resistance	approx. -30 °C to +130 °C (depending on substrate and mechanical pressure)		
Diluent	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	Cured adhesive can only be removed mechanically.		
Maximum time of storage (+4 °C)	At least 9 months when stored in sealed original packaging in cool and dry places. technicoll® 9403 can also be stored when cartridge has already been used.		
Preferred storage temperature	approx. +4 °C		

Favoured substrates

- metals (aluminium, steel, stainless steel, copper, brass)
- painted and coated surfaces
- thermoplastics like: ABS, PVC, PC-u, PC
- glass, nickel, chrome, polyester, epoxy resin, zinc, etc.
- derived timber products
- stone, ceramics, concrete
- thermosets (GRP, GRE, CRP)

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 solvents. In many cases, surface roughening prior to bonding improves strength of bonded joint.

Note

Bring the cartridge with the peak facing up in vertical position for about 3 minutes. This ensures that enclosed air can ascend from the cartridge.

Adhesion

Position cartridge into the bracket of an adequate dispensing gun, lock it and remove cap. Expel a small amount of the adhesive to make sure that both components flow freely. Attach mixing nozzle and lock it. Apply adhesive in a thin bead, drop or film on the surfaces to be bonded. The joint components should be assembled and clamped within the pot time.



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Possible applications

Nr.: 1

Working with mixing nozzle (micro static mixer):

Apply mixing jet, apply adhesive with a micro static mixer in a thin bead, drop or film on the surface to be bonded and join objects within the pot life. When using a micro static mixer, an almost transparent glued joint can be achieved.



Nr.: 2

Working with bead on bead process:

Apply both components in a bead on top of each other, not next to each other, on one side of the substrate and join immediately.



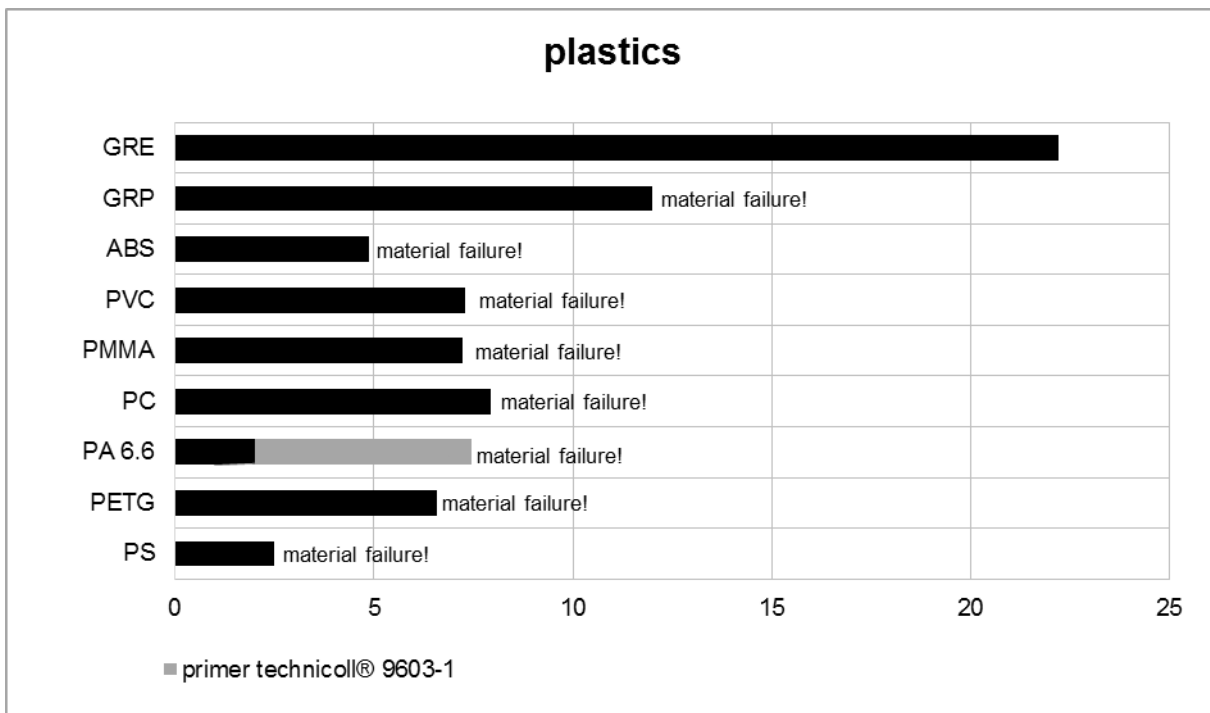
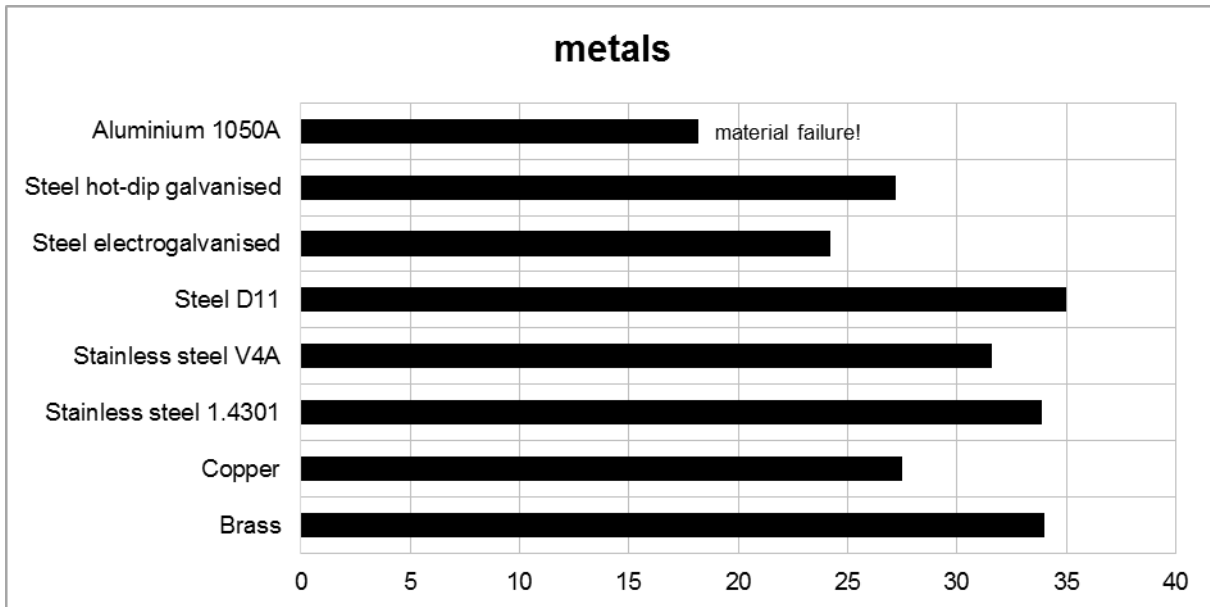
Nr.: 3

If it cannot be ensured that the adhesive is applied within 3 minutes and the parts are joint within this time, handle technicoll® 9403 separately (no-mix-process).

To this end, apply one component on each side of the parts to be bond. Curing happens after joining, when pushing both beads together.



Lap shear strengths [N/mm²] according to DIN 1465 (average value)



Pre-treatment: test specimens cleaned, metals sand blasted. Plastics and galvanised metals lightly roughened. Tested at room temperature.

Technical status: 22.12.2015

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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.