



technicoll® 9410-1 2-component adhesive for plastics (especially for PE, PP and POM)

Field of application

technicoll® 9410-1 is a structural, solvent-free 2-component adhesive and specially developed for bonding low surface energy plastics (e.g. PE, PP, POM). technicoll® 9410-1 is characterised by fast curing and a high resistance to moisture and ageing.

Handling data and product data

technicoll® 9410-1	technicoll® 9410-1 A	technicoll® 9410-1 B
Colour	white	transparent
Viscosity (+20 °C)	thixotropic	25 000 mPas
Base	methacrylate	amine
Mixing ratio	1:1	
Pot life (+23 °C)	4 minutes	
Initial strength	after approx. 40 minutes	
Final bonding strength	after approx. 36 hours	
Density	approx. 1.0 g/cm ³	
Temperature resistance	approx. -40 °C to +110 °C (depending on substrate and mechanical load)	
Way of application	one side	
Application temperature	+15 °C to +25 °C	
Dilution	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 6 months when stored in sealed original packaging in cool and dry places. technicoll® 9410-1 can also be stored when cartridge has already been used.	
Preferred storage temperature	approx. +4 °C	

Favoured substances

- PE, PP, POM
- PC, PMMA
- derived timber products
- steel, stainless steel
- stone, concrete, ceramics
- rubber, EPDM, fluororubber
- Teflon®
- PVC-unplasticised, ABS, PS, PA
- fibre reinforced plastics (CFRP, GFRP, GRP)
- aluminium, copper, brass
- silicone (preliminary tests necessary)

Not suitable for: PVC-plasticised (faux leather)

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

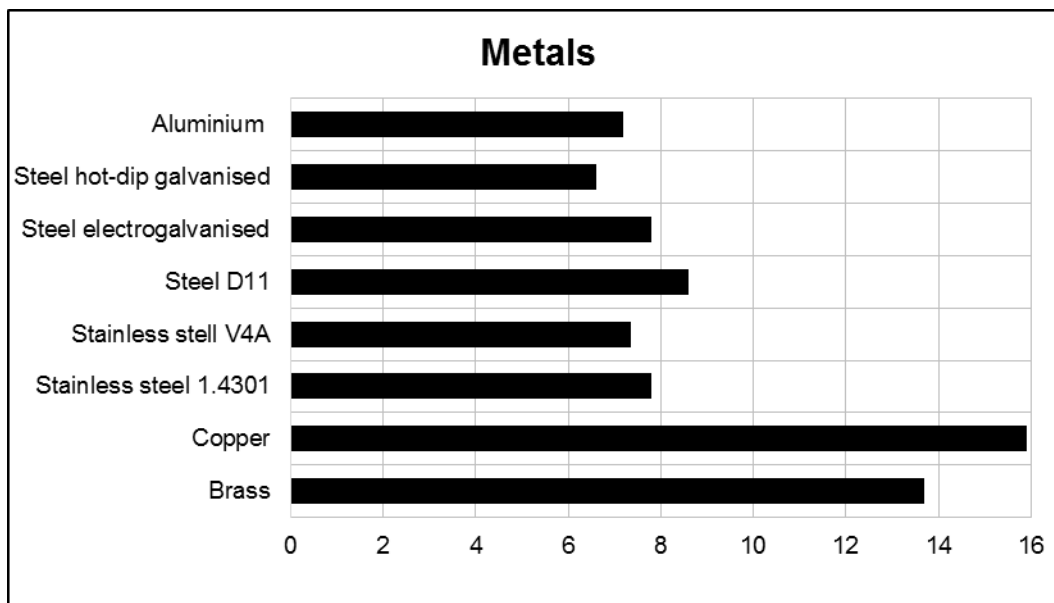
Joint surfaces must be dry and clean, especially free of oil, grease or release agents. For cleaning plastic surfaces technicoll® 8363 is recommended. In many cases surface roughening prior to bonding improves strength of a bonded joint. It is recommended when bonding rubber or metal.

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.

The final bonding strength will be achieved after approx. 36 hours at room temperature.

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

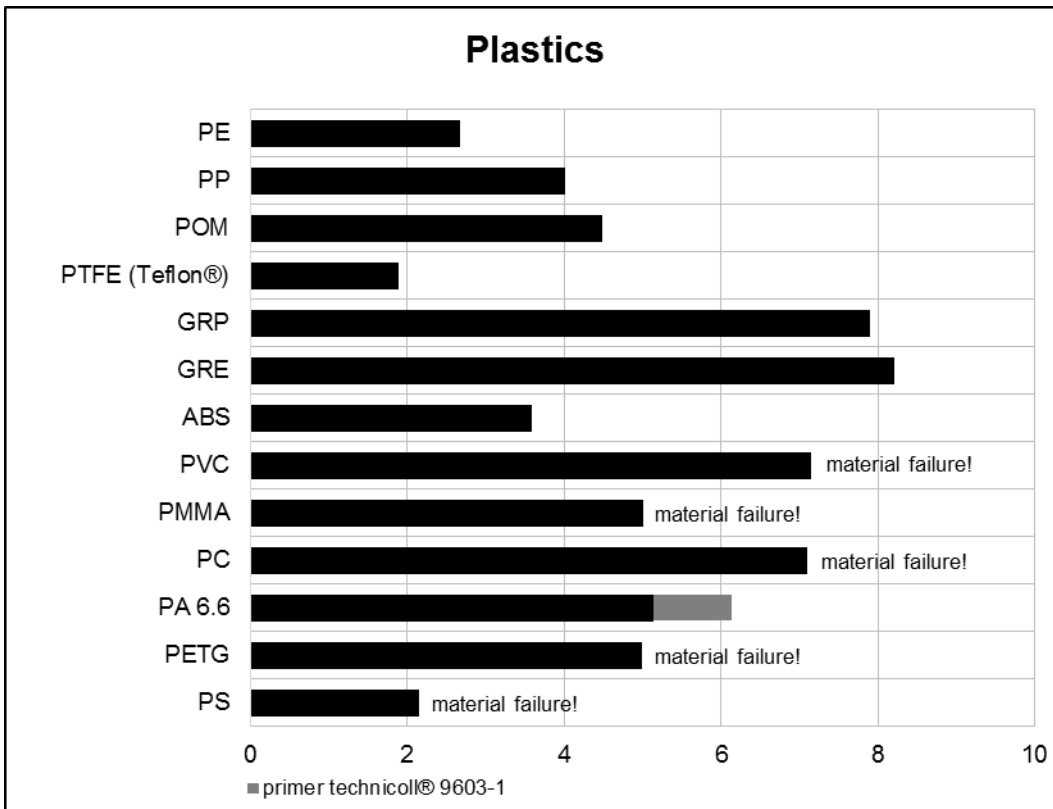


Pre-treatment: test specimens cleaned, metals sand blasted. Plastics and galvanised metals lightly roughened
Tested at room temperature.



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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.