

Technical Data Sheet



technicoll® 9411

Viscoplastic 2-component MMA adhesive, fast curing

Field of application

technicoll® 9411 is a high viscous and fast curing 2-component adhesive for bonding many different substrates like composites, many thermoplastics, thermosets, metals and coated surfaces.

Special characteristics

- Fast curing and handling strength
- Very high resistance to temperature and ageing
- Gap filling up to 10 mm
- Little surface preparation necessary
- High flexibility and high peel strength
- No sagging on vertical surfaces
- Viscoplastic, high resistance to mechanical load

Handling data and product data

Mixing ratio (volume)	technicoll® 9411 A	technicoll® 9411 B	adhesive
Mixing ratio (weight)	10	1	
Base	8.7	1	
Density	acrylate	acrylate	
Viscosity	1.0 g/cm ³	1.1 g/cm ³	1.00 g/cm ³
Colour	approx. 400 mPas	approx. 150 mPas	thixotrope
Pot life (+20 °C)	creamy	black	black
Initial strength	6 minutes		
Way of application	after approx. 20 minutes		
Gap filling	one-sided		
Processing temperature	up to max. 10 mm		
Cleaning agent / material	+15 °C to +25 °C		
Cleaning agent / tool	technicoll® 8363		
Cleaning	technicoll® 9901 (metal cleaning spray)		
Maximum time of storage (+4 °C)	technicoll® 9902 (plastics cleaning spray)		
Preferred storage temperature	technicoll® 8362, technicoll® 9901 (spray)		
	Cured adhesive can only be removed mechanically.		
	At least 9 months when stored in sealed original packaging in cool and dry places.		
	approx. +4 °C		

Favoured substrates

- metals (aluminium, steel, stainless steel)
- painted and coated surfaces
- stone, ceramic, concrete
- rubber
- thermosets (GRP, CRP, SMC)
- thermoplastics like: ABS, PA, PMMA, PET, PC, PVC, PS
- PUR, polyester, epoxy resin

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, PVC-p (faux leather), wood

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 many cases surface roughening prior to bonding improves strength of a bonded joint.

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. 24 hours at room temperature.

Physical properties of cured adhesive

Shear strength	21 - 24 MPa
Elongation at rupture	80 - 120 %
E-module	620 MPa
Resistance to temperature	approx. -40 °C to +120 °C
Max. resistance to temperature	+210 °C for 1 hour

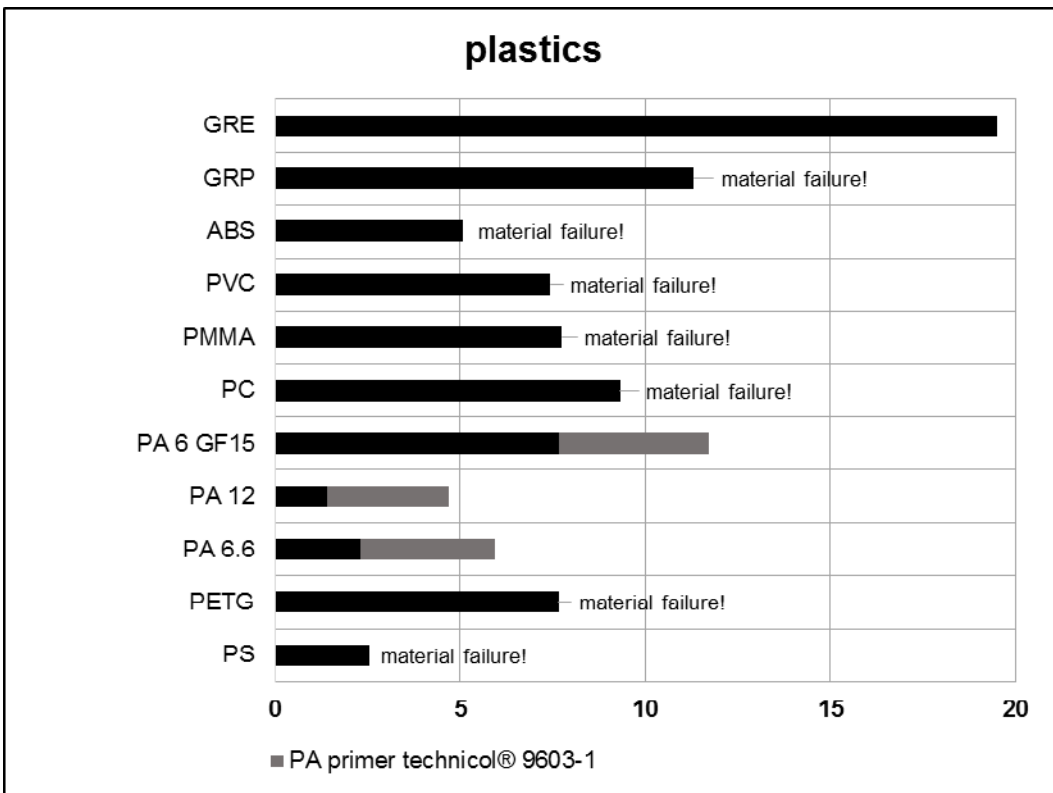
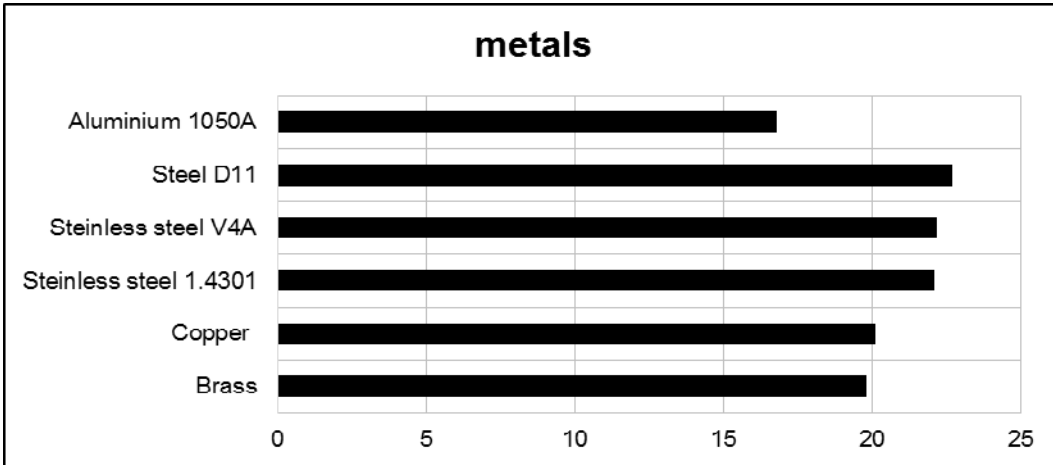
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Lap shear strengths [N/mm²] according to DIN 1465 (average value)



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.