

Technical Data Sheet

technicoll® 9430-1 Transparent, colourless 2-component PUR adhesive



Field of application

technicoll® 9430-1 is a fast curing adhesive for metal, thermoplastics, glass, painted and coated surfaces. technicoll® 9430-1 is highly transparent, flexible and UV-resistant.

Verarbeitungs-/Produktdaten

	technicoll® 9430-1 A	technicoll® 9430-1 B	product
Base	polyol	diisocyanate	
Mixing ratio (volume)	100	100	
Density	1.1 g/cm ³	1.1 g/cm ³	1.1 g/cm ³
Viscosity (+23 °C)	approx. 3.8 Pas	approx. 9.5 Pas	highly viscous
Colour	transparent	transparent	transparent
Pot life (+23 °C)	8 minutes		
Temperature resistance	approx. -40 °C to +80 °C (depending on substrate and construction)		
Time to handling strength	45 minutes		
Processing temperature	+15 °C to +25 °C		
Solid content	100 %		
Way of application	one-sided		
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 shelf life	At least 1 year when stored in sealed original packaging in cool and dry places.		
Preferred storage temperature	+15 °C to + 25 °C		

Favoured substrates

- metal (aluminium, steel, stainless steel)
- thermoplastics (e.g. ABS, PMMA, PC, PVC-unplasticised, PS)
- glass
- derived timber products

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, 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. In many cases grinding the surface prior to bonding improves strength of a bonded joint.

Adhesion

technicoll® 9430-1 is available in cartridges and applied by using a mixing nozzle. The cartridge is placed into a certain gun, the cap is removed, and a small amount of adhesive is expelled to make sure that both components flow freely.

Attach the mixing nozzle properly and discard the first 3 cm of the adhesive to ensure the right mixing ratio of both components. The adhesive is applied as bead or thin layer and the areas to be bonded are adhered during pot life. Joints of approx. 1 mm or more can be filled. Solid adhesive can only be removed mechanically. While curing adherents must be fixed. When finished remove the mixing nozzle, clean the tip, and replace the cap. Use another mixing nozzle when time-limit of pot life is exceeded.

Curing

technicoll® 9430-1 cures at room temperature within 7 days. After 45 minutes at room temperature handling strength is reached. Curing time can be lowered by increase of temperature.

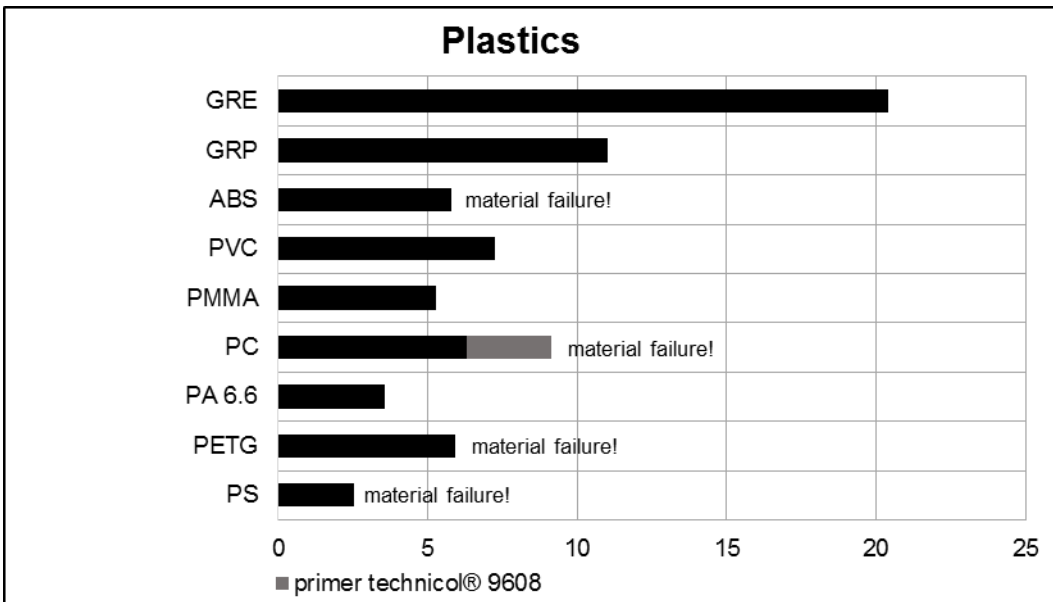
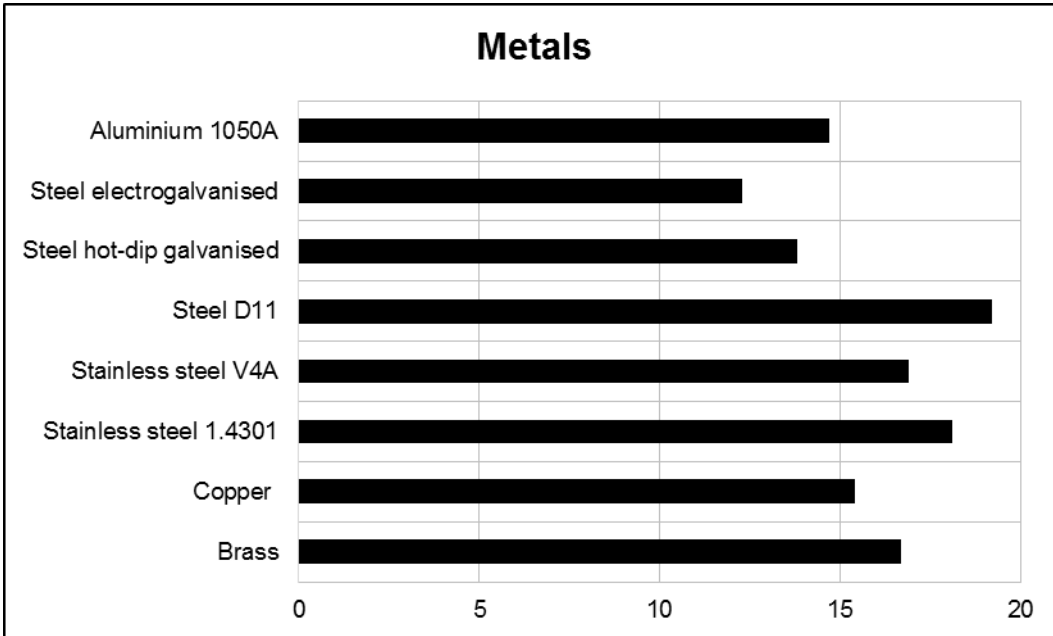
Primer technicoll® 9608

Using primer technicoll® 9608 (on polycarbonate substrates) bonding strength will be increased.



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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

page 3/3

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.