



technicoll® 9467 Paste-like 2-component epoxy adhesive

Special characteristics

- Paste-like 2-component epoxy adhesive to fill irregular joints
- Pot life: 30 minutes
- Very high strength, especially on metal and thermoset substrates
- Excellent thermal performance from -40 °C up to +100 °C
- High resistance to ageing and aggressive environmental conditions
- Good electrical isolator between two substrates

Favoured substrates

- metals - blank
- ceramics, stone, concrete
- rubber
- thermosets (FRP, SMC)
- derived timber product

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

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.

Note

Indicated values, which are described as “typical characteristics” or “average value“, are only for information purposes and cannot be guaranteed.

Physical properties of cured adhesive

Shore hardness D 1	80
Shear strength	30 N/mm ²
Elongation at rupture	2 %
Glass transition temperature T _g	+70 °C
Coefficient of thermal expansion (CTE)	70 10 ⁻⁶ K ⁻¹ (from -30 °C to +60 °C)
Temperature range	approx. -40 °C to +100 °C

Handling data and product data

Mixing ratio	technicoll® 9467 A	technicoll® 9467 B	adhesive
Volume	100	100	
Weight	100	90	
Density	1.4 g/cm ³	1.2 g/cm ³	1.3 g/cm ³
Viscosity (+25 °C)	approx. 390 Pas	approx. 460 Pas	approx. 425 Pas
Colour	beige	amber	beige
Pot life (+25 °C) for 100 g	30 minutes		
Curing time (+25 °C)	1 N/mm ² shear strength 5 hours 10 N/mm ² shear strength 21 hours		
Processing temperature	+15 °C to +30 °C		
Consumption	150 - 250 g/m ²		
Way of application	one-sided		
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	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	Not susceptible to frost. Densification at low temperature. Once adjusted to processing temperature: fully employable.		

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 is achieved after approx. 7 days!



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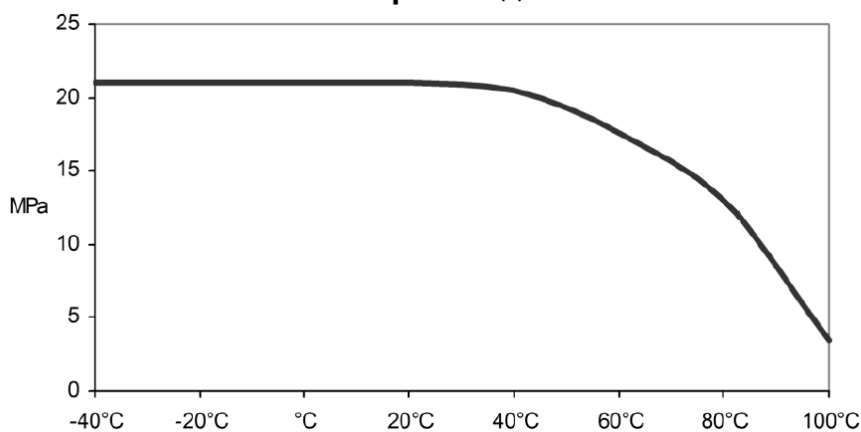
Lap shear strength (aluminium)

Aluminium	21 N/mm ²
Humidification 15 days at +80 °C	20 N/mm ²
Alternating climate test 15 cycles D3	20 N/mm ²
3 weeks thermal ageing at +100 °C	20 N/mm ²
Engine oil after ageing at +70 °C for 3 weeks	16 N/mm ²
Hydrochloric acid (0.1 N) after ageing at +23 °C for 3 weeks	17 N/mm ²
NaOH (0.1 N) after ageing at +23 °C for 3 weeks	21 N/mm ²
Sea water after ageing at +23 °C for 3 weeks	20 N/mm ²
Diesel after ageing at +23 °C for 3 weeks	18 N/mm ²
Mixture of alkanes after ageing at +23 °C for 3 weeks	20 N/mm ²

Roller peel test (aluminium)

Roller peel rest (curing 8 hours +80 °C, 48 hours at RT)	5 N/mm
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**Shear strength in dependence of the temperature
 (Curing 8 h at +80 °C and 48 h 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.