

technicoll® 9480

Multipurpose 2-component epoxy adhesive, transparent



technicoll

Field of application

technicoll® 9480 is a transparent, fast curing 2-component epoxy adhesive for bonding small areas of different kinds of substrates.

Handling data and product data

Base	epoxy resin	
Mixing ratio	100 (volume)	100 (volume)
Viscosity	liquid, honey-like	
Colour	transparent	
Density (+20 °C)	approx. 1.1 g/cm ³	
Pot life (+20 °C)	approx. 5 minutes	
Initial strength	approx. 30 minutes	
Final curing strength	after approx. 2 days	
Temperature resistance	-40 °C to +80 °C	
Way of application	one-sided	
Processing temperature	+15 °C to +25 °C	
Cleaning agent / material	technicoll® 8363 technicoll® 9901 (metal cleaning spray) technicoll® 9902 (plastics cleaning spray)	
Cleaning agent / tool	technicoll® 8362, technicoll® 9901 (Spray)	
Cleaning	Solid adhesive can only be removed mechanically.	
Maximum time of storage	At least 24 months 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.	

Favoured substrates

- metals
- concrete, artificial stone
- stone, natural stone
- derived timber products
- thermosets (FRP, SMC)
- ceramic, glass
- rubber

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

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. It is generally advised when working with rubber and metals.

Adhesion

The right dosage is already given by the packaging. Cut both tips of the nozzle, expel the amount of both components technicoll® 9480 out of the cartridge and mix them accurately with a small spatula. Close broached cartridges immediately with the cap. A small pin on the cap shows the right position of the cap on the cartridge. Apply adhesive on the areas to be bonded and join substrates together within the pot life. A wetting all over is achieved, when a small amount of adhesive leaks from the joint. Remove spare adhesive immediately, later on cured adhesive can only be removed mechanically. While curing, adherents must be fixed in their position. Heat accelerates the curing and also provides higher strength. Wait for a couple of days before assessing the final strength.

Lap shear strength* in dependance of curing time +20 °C

Lap shear strength* in dependance of test temperature (curing 20 min/+50 °C)

4 N/mm ²		30 minutes		17 N/mm ²		-40 °C
12 N/mm ²		60 minutes		21 N/mm ²		±0 °C
18 N/mm ²	at:	120 minutes		25 N/mm ²	at:	+20 °C
25 N/mm ²		3 days		23 N/mm ²		+40 °C
				6 N/mm ²		+80 °C

*Steel/steel sand blasted

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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.