

## Technical Data Sheet

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### technicoll® 9504 Cyanoacrylate, non-sagging gel



#### Field of application

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technicoll® 9504 is suitable for bonding small area surfaces like plastics, metal, ceramics, rubber (e.g. EPDM), as well as porous materials (e.g. cellular rubber, wood, fabrics).

#### Note

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Cyanoacrylates polymerise very quickly by moisture and/or alkaline substances when joining the substrates. Curing speed depends highly on the type of the surface and climatic conditions, especially moisture.

#### Handling data and product data

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Base	ethyl ester
Viscosity (+20 °C)	thixotropic
Density	approx. 1.1 g/cm <sup>3</sup>
Temperature resistance	app. -55 °C to +95 °C (depending on substrate and mechanical load)
Colour	colourless, transparent
Way of application	one-sided
Processing 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® 8363, technicoll® 9901 (spray)
Cleaning	Cured adhesive can be removed with technicoll® 9602.
Maximum time of storage	1 year when stored in sealed original packaging in cool and dry places.
Preferred storage temperature	+2 °C to +10 °C. Adhesive should be warmed up to room temperature before use.
Behaviour at low temperature	Densification at low temperature. Once adjusted to processing temperature: fully employable.

## Favoured substrates

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- rubber
- metal
- derived timber products
- plastics (unplasticised)
- primed and coated surfaces
- PE, PP, POM, TPE (incl. pretreatment with primer technicoll® 9605-1)
- EPDM (cellular rubber)
- cork
- fabrics
- ceramics

Not suitable for: PTFE (Teflon®), silicone, PVC-p (faux leather)  
PS-rigid foams (e.g. Styropor®)

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

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Joint surfaces must be dry and clean, especially free of oil, grease or release agents.

## Adhesion

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Apply technicoll® 9504 drop by drop to one of the surfaces to be bonded. The bond should not be thicker than 0.2 mm. Fix the substrates while curing.

## Curing time

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Initial strength is normally being achieved within:

Metal (steel) / metal (steel)	approx. 45 – 120 seconds
Elastomer (EPDM) / elastomer (EPDM)	approx. 10 – 14 seconds
Plastics (ABS) / plastics (ABS)	approx. 13 – 15 seconds
Wood (beech) / wood (beech)	> 80 seconds

## Lap shear strength

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Rubber (NBR)	material failure
Steel	10 – 17 N/mm <sup>2</sup>

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**Technical status: 22.12.2015**

Deviating information of earlier versions is invalid.

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### 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.