Technical Data Sheet

technicoll® 9545
Cyanoacrylate, partially flexible

Field of application

technicoll® 9545 is suitable for bonding small area surfaces of plastics, rubber, cellular rubber (e.g. EPDM), metals, leather, textiles, etc.

Note

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

Base	ethyl ester
Viscosity (+20 °C)	approx. 500 mPas
Density	approx. 1.1 g/cm³
Temperature resistance	approx. -50 °C to +120 °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	Cured adhesive can be removed with technicoll® 9602.
Maximum time of storage	At least 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 substances

- rubber
- metals
- derived timber product
- leather, textile
- EPDM (cellular rubber)
- plastics (unplasticised)
- ceramics, porcelain
- pasteboard, paper
- PE, PP, POM, TPE (incl. pretreatment with primer technicoll® 9605-1)

Not suitable for: PTFE (Teflon®), silicone, 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.

Adhesion

Apply technicoll® 9545 drop by drop to one of the surfaces to be bonded. Fix the substrates while curing.

Curing time

Initial strength is normally being achieved within:

Metal (steel) / metal (steel)	approx. 30 – 75 seconds
Elastomer (EPDM) / elastomer (EPDM)	approx. 3 – 10 seconds
ABS / ABS	approx. 4 – 12 seconds
Wood (beech) / wood (beech)	> 80 seconds

Lap shear strength

Steel / steel	10 – 25 N/mm^2
NBR / NBR	material failure

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