Technical Data Sheet

technicoll® 9222-1

Contact adhesive, water based

Field of application

technicoll® 9222-1 is a water based contact adhesive with a high temperature resistance.

Handling data and product data

Base	polychloroprene
Viscosity (+20 °C)	approx. 4000 mPas
Density	approx. 1.1 g/cm³
Colour	white, after drying: translucent
Drying time	approx. 20 – 40 minutes (depending on temperature, substrate and quantity of adhesive)
Contact life	up to approx. 8 hours (depending on temperature, substrate and quantity of adhesive)
Way of application	two-sided
Processing temperature	+15 °C to +25 °C
Dilution	not necessary, possible with water
Cleaning agent / material	technicoll® 8363 technicoll® 9901 (metal cleaning spray) technicoll® 9902 (plastics cleaning spray)
Cleaning agent / tool	water or technicoll® 8362
Cleaning	Solid adhesive can only be removed mechanically.
Maximum time of storage	At least 7 months when stored in sealed original packaging in cool and dry places.
Preferred storage temperature	+10 °C to +25 °C
Behaviour at low temperature	Frost susceptible. Do not store under +5 °C!

Favoured substrates

- High pressure laminates (HPL)
- cork
- foam material (PS, PUR)
- leather
- textiles
- paperboard, paper
- derived timber products

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

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 a thin layer of technicoll® 9222-1 equally to both sides of the bonding surface of the substrates (brush, trowel, closed roller). After the application solvent needs to evaporate. The usual waiting time is approx. 20 to 40 minutes. It depends on the applied amount of adhesive and the indoor climate. The right time for the bonding has come as soon as the applied adhesive does not pull strings anymore when touching with the finger, but still feels very sticky. Join the substrates together accurately and assemble quickly under high pressure. The good bond strength that is achieved immediately, usually allows further processing with the bonded substances right away.

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