

TECHNICAL DATASHEET

STALOC 4S15

Instant bonder plastics

PRODUCT DESCRIPTION

Substrates with different thermal expansions can be bonded using STALOC 4S15 instant bonder. Due to its viscosity, the instant adhesive can also be used to bond porous materials.

PHYSICAL PROPERTIES (WHEN LIQUID)

Values refer to reaching finger tight adhesion / final cure after 24 h

ATTRIBUTE	UNIT	SPECIFICATION
colour		clear / transparent
viscosity at +25°C	mPas	900 – 1,400 mPas
density at +25°C	g/ml	1.08 g/ml DIN 51757
flashing point	°C	87°C DIN 55213
shelf life at +25°C		min. 1 year

CURING TIMES

MATERIAL	UNIT	SPECIFICATION
aluminium / aluminium	sec	55 - 80 sec
SBR / SBR	sec	6 - 10 sec
polycarbonate / polycarbonate	sec	8 - 15 sec
EPDM / EPDM	sec	6 - 10 sec

PHYSICAL PROPERTIES (WHEN CURED)

ATTRIBUTE	UNIT	SPECIFICATION
temperature resistance	°C	-30°C to +80°C
softening point	°C	165°C

MECHANICAL RESISTANCE

ATTRIBUTE	UNIT	SPECIFICATION
tensile strength steel / steel	N/mm ²	> 12 N/mm ² DIN EN 1465
tensile strength SBR / SBR	N	> 1,500 N (elastomer round cord ø 18mm)
tensile strength SBR / SBR after 10 days at 70°C	N	> 1,200 N (elastomer round cord ø 18mm)
EPDM / EPDM	N	> 190 N (elastomer round cord ø 18mm)
EPDM / EPDM after 10 days at 70°C	N	> 140 N (elastomer round cord ø 18mm)

APPLICATION

Recommended application – further information can be found in the material safety data sheet

The parts to be bonded need to be cleaned and degreased. It is recommended to use STALOC technical cleaners, in order to ensure the best results in terms of adhesion. STALOC instant adhesives obtain excellent results even when used with minimum gaps.

Remove the residues of the glue with acetone-containing cleaners (e.g. STALOC Multi Power Cleaner) after pressing the parts together.

In case you need to accelerate the curing (e.g. when gaps are higher) use the STALOC activator for instant adhesives. For all materials with low surface tension which are difficult to bond (e.g. PE, PP, etc.) use the STALOC Primer for instant adhesives for surface preparation.



STORAGE

Recommended storage for optimum shelf life

Store product at an optimum temperature between 5°C and 25°C. Keep cool and dry. Make sure that the content is not contaminated once the bottle has been opened, in order to ensure an optimum shelf life. In case you need any further information, please contact the STALOC team.

SAFETY INFORMATION

Please send your request for the latest version of the material safety data sheet (MSDS).

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