

## TECHNICAL DATASHEET

### 2124

(Adhesive for laminated rotor/stator - stacks – medium viscosity)

#### Description

Special grade for quick bonding of flat single metal sheets to stacks of sheets, as required for stators or rotors in electric motor construction.

2124 is a low to medium viscous anaerobic adhesive, suitable for all applications where good long-term resistance to impact, peel forces and vibration is required. The product achieves excellent strength on metals and withstands a wide range of climatic conditions.

The fast curing at room temperature can be accelerated considerably by using the 4900, 4901, 4910 or 4920 activators, allowing production cycle times between 10 and 20 seconds.

#### Advantages

- Curable either with activators at 25°C within ~ 10 seconds or by heat (90°C – 130°C) within 60 seconds, depending on the coating
- May be applied either via dosing tips or screen-printing process
- Good adhesion to C5 – coatings
- Excellent resistance against ATF and other synthetic oils

#### Physical properties (liquid product)

Chemical base	Modified urethane acrylate
Curing System	Anaerobic curing adhesive
Shelf-life standard packaging (≤ 250 g)	12 months at room temperature
Viscosity at 25°C (cone-plate system, cone 50mm, shear rate 35s <sup>-1</sup> )	300 – 500 mPa•s
Density	~ 1.08 g/cm <sup>3</sup>
Colour	Slightly amber (blue fluorescent at 365nm)

### Anaerobic curing properties

Loose-break torque	
measured acc. to EN 15865 on M10 x 20 bolt – grade 8.8 zinc-phosphatized – nut 0.8d (no on-torque)	
Initial strength	15 – 30 minutes
Initial strength in combination with pre-activated surface	~ 10 seconds
Functional strength	1 – 3 hours
Final strength	6 – 12 hours

### Physical properties (cured product)

Thermal range	- 55 °C up to 175 °C
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### Tests on M10 x 20 bolt – grade 8.8 black-phosphatized – blank steel nut 0.8d

Measured according to DIN EN 15865 (On-torque = 5 Nm)	
Loose-break torque after 24 h at 23 °C	> 25 Nm
Prevailing torque after 24 h at 23 °C	> 10 Nm

### Compression shear strength on steel pin and collar

measured acc. to EN ISO 10123	
after 1 h at 23 °C	15 – 20 N/mm <sup>2</sup>
after 24 h at 23 °C	> 21 N/mm <sup>2</sup>

### Tensile shear strength on steel stripes

Measured according to EN 1465

> 13 N/mm<sup>2</sup>

### Precautions

For your own safety, please refer to the information of the concerned MSDS and for the correct handling the “user instructions”.

The information in this data sheet is based on the results of our research and experience. However, the suggestions herein concerning the use, application, and processing of the products (collectively, „the methods“) **are non-binding recommendations only**. It is the user’s sole responsibility to determine the suitability and safety of these methods, based on the user’s particular purpose in using the products. Before relying on the reliability and safety of any parts that are bonded using the products, it is extremely important that the user test the reliability and safety of the parts that are bonded. Failure to do so could result in serious personal injury. Because of the use of the products are within the purchaser’s sole control, Kisling Corporation specifically disclaims all warranties, express or implied, including warranties of merchantability or fitness for a particular purpose, arising from the sale or use of the products described herein. Kisling Corporation specifically disclaims any liability for consequential, incidental, or other damages of any kind, including lost profits. Kisling Corporation’s liability for damages shall not exceed the purchase price of the products used.

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