BONDING +
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ENCAPSULATION

Kisling

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^{-1})	300 – 500 mPa•s
Density	~ 1.08 g/cm³
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

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/mm²
after 24 h at 23 °C	> 21 N/mm^2

Tensile shear strength on steel stripes	> 13 N/mm^2

Measured according to EN 1465

Precautions

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

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