

TECHNICAL DATASHEET

2206

(Adhesive for laminated rotor/stator - stacks – low viscosity – heat curing)

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.

2206 is a low viscous 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.

For curing it is necessary to heat the parts, at high temperatures short cycle times are achievable.

Advantages

- Curable by heat (90°C – 150°C) within ~ 60 seconds, depending on the coating
- May be applied either via dosing tips or screen-printing process
- Due to the low viscosity, very tiny drops (< 1 mg) applicable
- Good adhesion to C5 – coatings
- Excellent resistance against ATF and other synthetic oils

Physical properties (liquid product)

Chemical base	Modified urethane acrylate
Curing System	Mono-component, heat curing adhesive
Shelf-life standard packaging (≤ 250 g)	3 months at room temperature
Viscosity at 25°C (cone-plate system, cone 75 mm, shear rate 1000 s ⁻¹)	55 – 85 mPa•s
Density	~ 1.08g/cm ³
Colour	light yellow (blue fluorescent at 365nm)

Curing properties

Final strength ~ 12 hours

Compression shear strength on steel pins and collars acc. to DIN EN ISO 10123

Collar preheated to the mentioned temperature and immediately joined with a pin to which adhesive has previously been applied.

Parts joined at	Stored and measured at 23 °C; after			
	60 seconds	120 seconds	10 minutes	Final strength
100 °C	~ 0.2 N/mm ²	≥ 0.5 N/mm ²	≥ 4 N/mm ²	≥ 22 N/mm ²
130 °C	~ 0.5 N/mm ²	≥ 2 N/mm ²	≥ 6 N/mm ²	≥ 22 N/mm ²
160 °C	~ 1.5 N/mm ²	≥ 2.5 N/mm ²	≥ 8 N/mm ²	≥ 22 N/mm ²

Physical properties (cured product)

Thermal range - 55 °C up to 175 °C

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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