

# Technical Datasheet

## Structalite® 8926



### Product Description

Panacol Structalite® adhesives are solvent free single or two-component adhesives. They are mostly based on epoxy resin and can be cured at room temperature or by exposure of heat. Structalite® products are designed for bonding, casting and protecting components in electronic and automotive industry.

Structalite® 8926 is a universal one-component epoxy adhesive which can also be used as a potting compound. Structalite® 8926 is particularly suitable for the bonding of materials with similar thermal expansion coefficients, such as metal / metal, glass / glass or plastic / plastic.

The mean viscosity setting allows a wide range of applications. The processing temperatures should be above 20 ° C to simplify the application.

### Curing Properties

The product is a one-component adhesive and cures under exposure to heat. Possible curing temperatures are listed in the table below.

Thermal curing	
Time at 80°C	3 h
Time at 100°C	15 min
Time at 130°C	5 min
Time at 150°C	2 min
Time at 180°C	1 min

The curing times given are guidelines. They refer to the curing of 2 g of adhesive. The heating up of the joining members are not taken into account.

The final strength of the adhesive is reached at the earliest after 24 h.

### Technical Data

Resin	epoxy
Appearance	beige
Filler	chalk
Filler – weight [%]	30
Particle size D95 [µm]	12,5

### Uncured material

Viscosity [mPas] (Brookfield LVT, 25°C, Sp 4, 6rpm) <i>PE-Norm 001</i>	30 000 - 45 000
Density [g/cm <sup>3</sup> ] <i>PE-Norm 004</i>	1,4
Flash point [°C] <i>PE-Norm 050</i>	>100

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### Cured material

Hardness shore D <i>PE-Norm 006</i>	75 - 90
Temperature resistance [°C]	-40 - 200
Shrinkage [%] <i>PE-Norm 031</i>	<2
Water absorption [mass %] <i>PE-Norm 016</i>	<1

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	116
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	27
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	159

Dielectric constant [20kHz] <i>IEC 60250-1969</i>	4
Volume resistivity [Ohm*cm] <i>IEC 60093-1980</i>	1,18E+14
Surface resistance [Ohm*cm] <i>IEC 60093-1980</i>	6,77E+12
Surface insulation resistance [Ohm*cm] <i>GB/T 10064-2006</i>	1,98E+14

Young's modulus E [MPa] <i>PE-Norm 056</i>	4 593
Tensile strength [MPa] <i>PE-Norm 014</i>	13
Elongation at break [%] <i>PE-Norm 014</i>	0,3

### Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	0°C - 10°C	0°C - 10°C	at delivery min. 3 months max. 6 months
Other packages			

**\*Store in original, unopened containers!**

### Instructions for Use

#### Surface preparation

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP® Panacol. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

#### Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

For safety information refer to our safety data sheet.

### Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2017/2102/EU "RoHS III".

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### **Contact**

**Panacol-Elosol GmbH**  
Daimlerstr. 8  
61449 Steinbach  
Germany  
Phone.: +49 6171 6202-0  
Mail: [info@panacol.de](mailto:info@panacol.de)  
[www.panacol.com](http://www.panacol.com)

**Panacol-USA, Inc.**  
142 Industrial Lane  
Torrington CT 06790  
USA  
Phone: +1 860-738-7449  
Mail: [info@panacol-usa.com](mailto:info@panacol-usa.com)  
[www.panacol-usa.com](http://www.panacol-usa.com)

**Panacol-Korea Co., Ltd.**  
#707, Kranz Techno, 388 Dunchon-daero  
Junwon-gu, Seongnam  
Gyeonggi-do, 13403 KOREA  
Phone: +82 31 749 1701  
Mail: [info@panacol-korea.com](mailto:info@panacol-korea.com)  
[www.panacol-korea.com](http://www.panacol-korea.com)

**Eleco Panacol – EFD**  
125, av Louis Roche  
Z.A. des Basses Noëls  
92238 Gennevilliers Cdx FRANCE  
Tél.: +33 (0)1 47 92 41 80  
Mail: [eleco@eleco-panacol.fr](mailto:eleco@eleco-panacol.fr)  
[www.eleco-panacol.fr](http://www.eleco-panacol.fr)