

# Collano RS 6400

## 2C silane adhesive, elastic and high-strength, flowable

### Characteristics

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**Base**

Silan-terminated polymer/Epoxy resin

**Colour**

Comp. A: yellowish, Comp. B: white,  
Mixture Comp. A+B: white

**Density**

Comp. A: 1.01 g/ml, Comp. B: 1.13 g/ml  
Mixture Comp. A+B: 1.05 g/ml

**Solids content**

100%

**Fluidity**

Flowing

**Viscosity** (Brookfield)

Comp. A: approx 15'000 mPa·s  
Comp. B: approx 2'000 mPa·s

**Form**

Liquid

**Storage**

2C double cartridge:

12 months in unopened original  
packaging at 15–25 °C  
(frost susceptible)

Steel barrel:

15 months in unopened original  
packaging at 15–25 °C  
(frost susceptible)

### Application area and materials

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For the large-area bonding of absorbent and non-absorbent joined components such as HPL, glass, various metals and plastics; for use in metal construction, vehicle manufacturing, boat and shipbuilding, and timber construction. Not suitable for use with bituminous substrates, PE, PP or Teflon.

### Performance | Material properties

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Information derives from tests carried out by Collano. For calculations and design etc., the processing personnel should carry out appropriate practical tests. Collano reserves the right to adapt or complete the values.

**Tensile shear strength**

9 N/mm<sup>2</sup> on aluminium, DIN EN 1465

Subsequent tempering to 80 °C improves tensile shear strength

**Elongation at break**

250%, DIN EN ISO 527

**Hardness**

Shore A 80, DIN EN ISO 868

**Temperature resistance**

-50 °C to +150 °C, at short-term temperature stability 180 °C

**Water resistance**

Very good

**Resistance**

Short-term contact with Ethanol, gasoline lead-free 95, Ethyle acetate, Toluene, MEK, engine oil at 23 °C and 50 °C

### Packaging

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2C double cartridge 400 ml (Comp. A+B)

On request: Steel barrel 22 kg

## Application data

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The curing behaviour of 2C silane adhesives requires optimal mixing quality. The specified figures are guideline values and are based on results of tests on precision bonds made under standard climatic conditions (20°C and 65% relative humidity). Different conditions may lead to deviations from the said specifications.

### Mixing ratio

Parts by weight A:B = 2:1

### Adhesive application quantity

> 120 g/m<sup>2</sup>

### Application temperature

5–40 °C

### Maximum open assembly time

< 40 minutes

### Pot life

< 60 minutes

### Fixing time

20 °C: > 8.5 hours

40 °C: > 4.0 hours

60 °C: > 1.5 hours

until 1 MPa tensile shear strength is reached

### Conditioning time

48 hours

### Final strength

21 days

## Application

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Press and dose from a double cartridge using the 2C cartridge applicator gun. Mix the two components homogeneously using the mixing nozzle supplied. Discard the first 10 g. Apply the adhesive to the surface of the components to be joined and spread it as needed using a spatula. When processing using separate containers, mix the two components A and B in a proportion of 2:1 by weight. Make sure that the mixture is homogenous. Degrease the components using Collano HP 3100 or ethanol. It is crucial that the surfaces are clean and grease-free in order to provide for optimal wetting.

### Additional details

Clean and activate any slightly soiled metal surfaces with Collano HP 1000 adhesive cleaner. Can be overcoated with acrylic emulsion paints and baking varnish. For industrial application the manufacturing process and corresponding contract plant are to be specified in advance.

### Clean-up

Non-cured adhesive residues with ethanol. Cured adhesive by mechanical processing.

## Safety

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The wearing of protective gloves and safety goggles is recommended while handling the liquid product. Follow the instructions on the Safety Data Sheet.

### Guarantee

We guarantee the consistency and faultless quality of this product, manufactured in accordance with ISO quality standards, which has been developed on the basis of our long standing experience with the recommended applications under the specified conditions. Material, processing, and application conditions may significantly influence product properties. Pre-application tests by the user are therefore essential. For non-specified applications or deviations in application conditions, we recommend that Collano's technical support service be consulted first. Collano's general sales and delivery terms and conditions shall apply.

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