Teroson

Technical Data Sheet

Terostat-8630 2-K HMLC

High-modulus, low-conductive
direct glazing adhesive/sealant
for repair of
a) passenger car
b) bus, trucks and special-purppose vehicles

Base: Polyurethane

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Product Description

The product is a pasty 2-component sealant /adhesive for direct glazing. It is based on polyurethane. After processing it cures to a rubber-elastic material. The cured material has a high shear modulus and very low conductivity.

The product cures extremely fast. Curing does not depend on the atmospheric moisture and is relatively independent of the surrounding temperature.

The direct glazing adhesive/sealant is outstanding for the following properties:

- Drive away time passenger cars (NCAP): 2 hrs.
- Final strength after approx. 5 h
- Very good sag resistance
- High elasticity and shear modulus
- Excellent adhesion to glass, glass with a ceramic coating and to painted surfaces, in connection with primer Terostat-8517 H
- Good adhesion to remaining PUR material - Extremely fast curing
- High UV resistance in connection with primer Terostat-8517 H
- High tensile shear strength, even after ageing
- Very low electrical conductivity
- Easy to use

Application Areas

Bonding of front, rear and side windows into the body of motor vehicles (passenger cars, bus, trucks, driver cabins of tractors/fork lift trucks and special-purpose vehicles). Bonding of screens by construction of bus and waggon.

Technical Data

1. Terostat-8630 2-K HMLC

Colour:	black
Consistency:	paste
Density:	approx. 1.2 g/cm^3
Solids:	100 %
Glazing time:	max. 30 min. *
Shore-A-hardness (DIN 53505):	approx. 60
Tensile strength (DIN 53504):	approx. 10 MPa
Stress (DIN 53504):	approx. 5,7 MPa at 100 % elongation
Shear modulus (according to DIN 54451):	approx. 3 MPa
Elongation to break (DIN 53504):	approx. 370 %
Shear strength (based on DIN EN 1465):	approx. 3,9 MPa (layer thickness 5 mm)
Volume change (DIN 52451):	<1 %
Warm up time in warming Box:	30 min. in Henkel cartridge pre-heating box (IDH

	211556) resp. 60 min. in Henkel Pre-heating box for DK + SP (IDH 796993)
In service temperature range:	-40°C bis 90°C
Short exposure (up to 1 h):	120°C

* period of time from starting material application up to installing the screen

1. Terostat-Primer-8517 H

Colour:	black
Density:	approx. 0,98 g/cm^3
Solids:	approx. 36 %
Optimum layer thickness:	50 µm wet
Drying time:	approx. 30 min.
Primer open time:	up to 8 h after application

Preliminary statement

Prior to application it is necessary to read the **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labelling, the relevant precautions should always be observed.

1. Cleaning

The substrates to be bonded must be dry and free from oil, dust, grease and other dirt. Glass or ceramic coating are cleaned with Cleaner FL, the same applies to painted surfaces. The PUR layer remaining in the window cut-out need not be cleaned. If, however, cleaning of this remaining layer is indispensable, an evaporation time of at **least 30 minutes** has to be observed before the adhesive/sealant can be applied, since the adhesive surfaces must have fully dried.

2. Priming

By means of an applicator, a thin layer of primer Terostat-8517 H is eve nly applied to the cleaned substrates (glass, ceramic-coated or painted surfaces). The thickness of the wet film should be approx. 0.05 mm. Let the primed surface evaporate for at least 30 minutes before the direct glazing adhesive/sealant is applied. If a fresh bonding is made directly on the remaining material layer (left in the window cut-out of the body), this layer must not be primed. Provided that it is not contaminated with dust or grease, the remaining layer is the best adhesive surface, if Terostat-8630 2-K HMLC is used for the new bond.

3. Activation of precoated windows

If windows are bonded which have been precoated with a PUR–based adhesive/sealant by the glass supplier, the activator Terostat-8525 must be used in order to ensure the correct adherence of Terostat-8630 2-K HMLC to the precoating.

By means of a wool applicator, a thin layer of Terostat-8525 is applied to the precoating. Following this, an evaporation time of approx. 15 minutes has to be observed. Subsequently, Terostat-8630 2-K HMLC is applied as usual, but taking into consideration the layer thickness (approx. 2 mm) of the precoating.

4. Processing

Prior to its use, the cartridge containing the A-component of Terostat-8630 2-K HMLC must be warmed in the cartridge warming box (IDH 211556) for at least 30 minutes, resp. 60 minutes in the pre-heating box for DK + SP (IDH 796993). Immediately before the application, the B-component is fully screwed onto the opened cartridge. Then processing is carried out using the COX Sherborne HP compressed-air pistol at a pressure of 5 - 6 bar and should be applied in one step.

5. Filling of gaps (for trucks, commercial and special-purpose vehicles)

Terostat-8591 HMLC is ideal for the filling of large gaps due to its perfect smoothness characteristics. Please observe the corresponding Technical Data sheet.

Storage

Frost-sensitive	yes
Recommended storage temperature	10°C to 25°C
Shelf-live	12 months in original packaging

Packaging

Repair set	
Cartridge, 310 ml + B-component	
Cartridge preheating box (2 cartridges)	Art.-No. 131.17 H IDH 211556
Cartridge preheating box (for 5 cartridges)	Art-No. 172.15 M IDH 796993

Hazard Indications/ Safety Recommendations/ Transport Regulations	see Safety Data Sheet

Important

The data above, particularly the recommendations for application and use of our products is based on our knowledge and experience. Due to different materials and conditions of application which are beyond our knowledge and control we strongly recommend carrying out sufficient tests in order to ensure that our products are suitable for the intended process and applications. Except for wilful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

This Technical Data Sheet supersedes all previous editions.

Germany:
Henkel KGaA
Location Heidelberg
D-69112 Heidelberg Germany
Phone +49-6221-704-0
Fax +49-6221-704-698

UK:
Henkel Loctite Adhesives Ltd.
Technologies House,
Wood Lane End
Hemel Hempstead
Hertfordshire HP2 4 RQ
Telephone (01442) 278000