

TEROSON® EP 52XX

April 2026

Product description

TEROSON® EP 52XX provides the following product characteristics:

Technology	Epoxy resin
Product Type	Structural adhesive
Additional information	High damping

TEROSON® EP 52XX is a heat curing, solvent free, one component adhesive, based on Epoxy resins. It has been specially developed to provide high damping and high modulus around room temperature range. Product viscosity design results in excellent sag and wash-off resistant in all usual automotive pre-treatment lines. TEROSON® EP 52XX performs well to the area that requires high toughness as well as improvement of noise and vibration.

Typical applications

TEROSON® EP 52XX is used in the automotive body shop for structural and hem flange bonding. It is special designed for steel, zinc coated surfaces, zinc/magnesium surfaces and aluminum alloys used in the automotive industry, where high strength and corrosion protection properties are required. TEROSON® EP 52XX is used for adhesive bonds also in combination with other joining techniques, such as spot welding, which require higher shear strength.

Technical data

Uncured

Color	Blue
Consistency	Paste
Solids	99%
Viscosity	300 - 500 Pa.s
Equipment	P/P 25 mm
Shear rate	15.5 S ⁻¹
Temperature	20 °C

Cured (20 min. at 170 °C)

Material data

E-modulus	1 GPa
Tensile strength	17 MPa
Elongation at break	22%

Shear strength	17 MPa
Layer thickness	0.15 mm
Bonding area	25 x 10 mm
Substrate	CRS 1.6 mm

Loss factor @30°C @ 1Hz >0.3

Direction for use

Preliminary statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Application

TEROSON® EP 52XX is applied from pails or drums using fully heated, high pressure pumps with a compression ratio minimum 50:1. For the best application the use of volume controlled dispensers is preferred. The heated application pistol can be used either manually or on a fixed jig. More commonly is attached to an automatic application system (robot, CNC). It is recommended to switch off heating during a shutdown of more than 1 hour. The pressure should be switched off after 15 minutes of non-production. Independent heating circuits should have the lowest temperature at the follower plate and the highest temperature at the application nozzle. To ensure an optimal wetting to the substrate TEROSON® EP 52XX should be applied at elevated temperatures. The material is applied directly to oily sheet metal no more than 3 g/m². If required, we will provide you with the additional information on suitable application equipment.

Recommended material temperature

Follower plate and pump, °C	25 to 35
Temperature at nozzle, °C	35 to 45

Curing

TEROSON® EP 52XX is cured while passing the EC oven, e.g. 20 min at 170°C. The minimum curing cycle is 20 min at 150 °C. These are effective metal temperatures.

Cleaning

Fresh, uncured material can be removed with the aid of ethylacetate or gasoline. Cured adhesive can only be removed mechanically.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Transport Regulations
Hazardous Information
Safety Regulations

Storage

Frost-sensitive	No
Recommended storage temperature, °C	10 to 30
Shelf-life (in unopened original packaging), months	3

Additional information**Disclaimer**

The information provided in this Technical data sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical data sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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