

TEROSON PU 6015

October 2016

PRODUCT DESCRIPTION

Technology	Polyurethane
Product Type	Structural Adhesive
Additional Information	2-Component

TEROSON PU 6015 is a two-component adhesive based on polyurethane, which usually cures at room temperature. An acceleration of curing is possible by increased temperatures (e.g. infra-red radiator, heated fixing equipment).

APPLICATION AREAS

TEROSON PU 6015 is used in the car manufacturing industry and at suppliers of car parts as well as in car repair workshops.

Application areas are the bonding of fibre-glass reinforced duromers (SMC, BMC/ZMC) to one another or to metals. In car repair workshops, TEROSON PU 6015 is also used for the bonding of sheet metal in conjunction with spot welding and for the repair of plastic parts.

TECHNICAL DATA

(Typical Test Results)

COMPONENT A	TEROSON PU 6015 PART A
Colour	grey
Density	approx. 1.78 g/cm ³
Solids (3h, at 100°C)	>98%
Consistency	paste
Viscosity, (Brookfield RVT, spindle 7, 20 rpm, 23°C)	approx. 185 Pas
COMPONENT B	TEROSON PU 700 Hardener
Colour	dark brown
Density	approx. 1.2 g/cm ³
Solids (3h, at 100°C)	>99%
Consistency	fluid
Viscosity, (Brookfield RVT, spindle 7, 20 rpm, 23°C)	approx. 0.2 Pas
Mixing ratio A : B	
by weight	100 : 12
by volume	100 : 17.8
MIXTURE (Component A + B)	
Colour	grey
Potlife (23°C)	approx. 20 min(s).
Shore A hardness	approx. 85 to 90

Curing time at 23 °C	approx. 6 hr(s) (85% of final strength)
Shear strength at 23°C, (measured after 2d at 23°C)	approx. 10 MPa
Layer thickness	1 mm
Substrates	electro coated steel sheet
Cross head speed	100 mm/min.
Paintability	good
In service temperature	-40 to 80 °C
Short exposure (up to 1 h)	140 °C

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 labeling, the relevant precautions should always be observed.

PRETREATMENT

The substrates must be free of oil, grease, humidity, dirt and release agents.

A mechanical roughening procedure (brushing, grinding, sandblasting) has shown itself to be a suitable method of pretreatment for plastics.

These mechanical processes remove surface layers which would negatively influence bonding e.g. release agents. Clean plastic surfaces do not require mechanical pretreatment.

Metals must be primed (e.g. electro coated, two-component epoxy resin primer).

APPLICATION

TEROSON PU 6015 is generally applied with suitable two-component mixing and dosing equipment because of relatively short pot life, necessitated by cycle times (manufacturers' addresses are available on request).

Application can be conducted manually with a thread pistol or automatically using robots.

CURING

Curing at room temperature is possible. However hot curing at 80 - 100°C is preferable using heated fixing equipment. It results in improved adhesion thanks to better wetting, higher final strength, faster setting, and therefore a reduction of the cycle time, e.g. 8 minutes at 80°C.

CLEANING

Fresh, uncured material (cleaning application equipment, substrate contamination, etc.) can first be removed drily and thereafter with the aid of suitable solvent (e.g. acetone, ethyl acetate, isopropyl alcohol).

Cured adhesive can only be removed mechanically.

STORAGE

Frost sensitive	no
Recommended storage temperature	10 to 25 °C
Shelf life	12 months in original packaging

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