

TEROSON PU 6800

February 2021

Micro Emission

PRODUCT DESCRIPTION

| | |
|-------------------------------|--|
| Technology | Polyurethane, Micro Emission |
| Product Type | For bonding customising and body parts |
| Additional Information | 2-Component |

TEROSON PU 6800 is a polyurethane based two-component adhesive which cures at room temperature. For accelerated curing it is recommended to increase the temperature up to 60 to 70 °C. The product is supplied in a convenient twin cartridge. TEROSON PU 6800 can be painted with standard commercial car repair refinishing paints.

Application Areas:

TEROSON PU 6800 is used in the automotive industry for bonding of plastic parts and repair of PVC-plastisol cosmetic seams.

TECHNICAL DATA

(Typical Test Results)

COMPONENT A

Colour grey
Density approx. 1.6 g/cm³

COMPONENT B

Colour white
Density approx. 1.3 g/cm³

Mixing ratio A : B

by volume 1 : 1

MIXTURE (Component A + B)

Colour grey
Pot life Daimler 23°C, appr. 14 to 18 min.
brushing method

Tack-free time (23 °C, 50 % approx. 40 min(s).
rh)

Curing time at 23 °C approx. 5 hr(s).

Layer thickness 3 mm

Solid to hand pressure

at 23 °C approx. 2 hr(s).

at 80 °C approx. 10 min(s).

Shore A hardness approx. 80 to 100

Shear strength

After 2 d (23 °C, 50 % rh) approx. 10 MPa

Layer thickness 0.3 mm

Cross head speed 10 mm/min.

Paintability good

In service temperature -40 to 80 °C

DIRECTIONS FOR USE

Preliminary Statement:

Prior to application 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.

Pretreatment:

The parts to be bonded must be free from oil, grease, moisture, dirt and release agents. Metals may either be primed (e.g. cathodic EC) or they should be grinded. Finally the sanded parts should be cleaned and pretreated with TEROSON VR 20.

Application:

Apply pressure to the cartridge(s) to ensure a simultaneous and homogeneous flow of both components. Thereafter, attach the static mixer and cut the tip to provide for the desired bead size. Discard the first 2 cm of extruded adhesive bead. TEROSON PU 6800 is applied directly to the substrates. Any excess material should be removed immediately after application. If material is left in the cartridge leave the static mixer attached. For further use of the product, simply remove the mixer and install a new one. TEROSON PU 6800 can pass after initial cure the primer and paint ovens in OEM plants.

Curing:

Curing occurs at room temperature. For accelerated curing it is recommended to warm up TEROSON PU 6800 to 60 to 70 °C for minimum 15 minutes.

Cleaning:

Freshly applied and uncured material should be removed with a dry cloth and then cleaned off with a suitable solvent. Cured adhesive can only be removed with a machine.

Classification:

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

Hazards identification
Transport information
Regulatory information

Storage:

| | |
|-------------------------------------|----------|
| Frost sensitive | no |
| Recommended storage temperature, °C | 10 to 25 |
| Shelf- life, months | 12 |

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.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

In case products are delivered by Henkel Corporation, or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 3