

TEROSON® PU 8590 UHV/TEROSON® PU 8590 BB02 M

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Ultra high viscous direct glazing adhesive

Product description

TEROSON® PU 8590 UHV/TEROSON® PU 8590 BB02 M provides the following product characteristics:

Technology	1c accelerated Polyurethan Adhesive free from PVC and solvents
Product type	Direct Glazing for industrial use
Application	Bonding and sealing
Part A	TEROSON® PU 8590 UHV
Part B	TEROSON® PU 8590 BB02 M

TEROSON® PU 8590 UHV/TEROSON® PU 8590 BB02 M is outstanding for the following properties:

- very good sag resistance
- high cure rate
- high shear strength and good elasticity, even after aging
- excellent adhesion to glass, glass with ceramic coating, encapsulation and to painted surfaces, in connection with primer/activator
- high UV resistance

Application areas:

TEROSON® PU 8590 UHV/TEROSON® PU 8590 BB02 M is used for the bonding of front, rear and side screens to the body of motor vehicles (car, truck, bus) & for sealing/bonding of battery lids to battery pack.

Technical data

(Typical test results)

Colour	Part A: black, Part B: beige
Odour	imperceptible
Consistency	pasty
Density part A, g/cm³	approx.1.28
Density part B, g/cm³	approx. 1.50
Viscosity at 23°C, (Part A), Pas	6,200 to 7,200
Solids, %	100
Curing mechanism	1c accelerated, static mixed
Open time (34 °C, 80% rh)	Approx. 20 min (Mixing ratio: 100:2,5
Curing speed (23 °C, 50% rh)	Approx. 0,5 MPa after 2 hours
Tensile strength, MPa	approx. 7
Elongation at break, %	approx. 370

Shear strength, MPa	approx. 7
In service temperature range, °C	-40 to 90
Recommended application temperature, °C	15 to 50

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.

Surface pretreatment and priming:

Ensure that the substrates to be bonded are dry and free from oil, dust, grease and other dirt. Use for glass, paint and cathaphoretic dip painting (E-coat) the approved cleaners. The approved Henkel primer has to be used according to prior agreement with Technical Customer Service.

Application:

It is recommended to use a complete heated application system. In some cases a partly heating can be sufficient.

- The entire equipment, including hoses and pipes, must be moisture tight.
- The follower plate must be driven by a double ram.
- Necessity of centering the container.
- It is recommended to switch off heating during a shutdown of more than 1 hour.
- The pressure should be switched off after 45 min of non-production.
- The adhesive is applied from pails or drums using high pressure piston pumps with a pneumatic ratio minimum 55:1. Due to the various application conditions it is recommended to follow the references in the current valid application data sheet. The application data sheet also provides necessary information about suitable application equipment and conditions. For further information, please contact the responsible sales representative.



**Classification:**

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

**Transport Regulations**  
**Hazardous Information**  
**Safety Regulations**

**Storage:**

Frost sensitive	Part A: No, Part B: Yes
Recommended storage temperature, °C	15 to 25
Shelf-life, months	6

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