

## TEROSON PU 8690 N/MT

June 2015

### Direct Glazing adhesive with medium viscosity and high shear modulus

#### PRODUCT DESCRIPTION

<b>Technology</b>	<b>1c Polyurethan Adhesive</b> free from PVC and solvents
<b>Product Type</b>	<b>Direct Glazing</b> for industrial use
<b>Additional Function</b>	High shear modulus Primerless on paint

TEROSON PU 8690 N/MT is outstanding for the following properties:

- very good sag resistance
- high shear modulus
- excellent adhesion to glass, glass with ceramic coating and to painted surfaces, in connection with primer/activator
- high UV resistance

#### APPLICATION AREAS

TEROSON PU 8690 N/MT is used for the bonding of front, rear and side screens to the body of motor vehicles (car, truck, bus). Primerless on paint adhesion needs to be checked prior to use.

#### TECHNICAL DATA (Typical Test Results)

Colour	black
Odour	imperceptible
Consistency	pasty
Density	1.27 g/cm <sup>3</sup>
Viscosity at 23 °C	3,000 to 4,000 Pas
Solids	100 %
Curing mechanism	moisture curing, accelerable
Cure rate (23 °C, 50 % rh)	approx. 3 mm / 24 h
Skin formation time (23 °C, 50 % rh)	approx. 30 min
Shore A hardness	approx. 75
Tensile strength	approx. 10 MPa
Elongation at break	approx. 250 %
Shear modulus G10	>2.5 MPa (5 mm adhesive thickness)
Shear strength	approx. 5 MPa
In service temperature range	-40 to 90 °C
Recommended application temperature	15 to 40 °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.

#### 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 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.

#### STORAGE

Frost sensitive	no
Recommended storage temperature	15 to 25 °C
Shelf life	6 to 12 months depending on packaging

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