

TEROSON PU A235 W

October 2019

PRODUCT DESCRIPTION

Technology	Polyurethane
Type of Adhesive	Aqueous dispersion
Application	Vehicle interior trim

TEROSON PU A235 W is a water-based adhesive for the lamination of PVC- or TPO-foil to ABS, ABS-blends, pretreated PP and natural fibre substrates. It can also be used for thermoforming of carpet or felt to ABS.

TECHNICAL DATA

(Typical Test Results)

Color	white
Dry extract, %	48 to 50
Density, g/cm ³	1.02 to 1.1
pH	7 to 8
Viscosity, mPa.s (Brookfield RVT, spindle 3, 20 rpm @ 20°C)	2,500 to 3,500

PRELIMINARY STATEMENT

Prior to use 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.

Instructions for use:

The product must be homogenized before use, taking care to avoid air inclusions.

Application by spraying or roll coating with a smooth or engraved roll.

Recommended application weight: 80 to 120 g/m² wet (depending on the type of substrate).

For less absorbent substrates an one-sided application of the adhesive is sufficient.

The substrates must be clean and dust-free.

Materials with low surface energy (< 42 mN/m) must be pretreated.

Before assembly, the dried adhesive film needs to be reactivated at 70°C minimum.

Drying can be done at ambient conditions and can be accelerated by elevated temperature up to 60°C.

Properties:

After drying, TEROSON PU A235 W forms a white, tack-free film.

The thermal resistance of TEROSON PU A235 W alone is limited to 80 to 90°C.

The addition of a hardener increases the thermal resistance to 120 to 140°C.

Recommended hardener: AQUENCE CATALYST R397

Recommended mixing ratio of TEROSON PU A235 W and AQUENCE CATALYST R397 is 100 : 5 by weight.

The adhesive is completely cured after 72 hours.

Pot life of the mixture: 8 hours.

Open time of the dried adhesive film:

- 24 hours for TEROSON PU A235 W

- 8 hours for the mixture of TEROSON PU A235 W and AQUENCE CATALYST R397

Cleaning:

Mixing and dispensing equipment should be cleaned as follows:

- Wet product: wash with warm water

- Dry product: clean by soaking with an organic solvent-type cleaner (TEROSON VR 40); the residues must be removed mechanically.

Storage:

Frost sensitive	yes
Recommended storage temperature	5 to 35 °C
Shelf life	6 months in original packaging

Classification:

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

Hazards identification

Transport information

Regulatory information

Disclaimer

Note:

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.

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