

# TEROSON RB 1159

February 2014

## PRODUCT DESCRIPTION

<b>Technology</b>	Rubber
<b>Product Type</b>	Antiflutter Adhesive
<b>Additional Information</b>	expandable Low density

TEROSON RB 1159 is a heat curing, solvent free, one component adhesive, based on Rubbers. The high viscosity of the product leads to an excellent sag resistance and makes it wash-off resistant without pregelling or precuring against aqueous cleaning and pretreatment agents. TEROSON RB 1159 adheres well to oily steel sheets, aluminum and zinc coated surfaces. The material is flexible and little dependent of changes in temperature. Due to the good compatibility to E-coat paint it offers a safe corrosion protection, even at boundary areas.

## APPLICATION AREAS

TEROSON RB 1159 is used as a body shop sealer and spotweld adhesive and shows good adhesion on oily surfaces. It is recommended for use, when wash-off resistance must be obtained without pre-gelling or pre-curing, and where a high degree of elasticity is required over a wide temperature range. Low hardness prevents read-through effects.

## TECHNICAL DATA

### (Typical Test Results)

#### Uncured

Colour	black
Density	approx. 1.2 g/cm <sup>3</sup>
Consistency	pasty
Solids	≥ 97 %
Viscosity	approx. 130 g/min
Equipment	Severs viscosimeter
Nozzle	Ø 5 mm
Pressure	3 bar
Temperature	35 °C

#### Cured (25 min. at 170 °C)

Expansion rate	approx. 70 %
E-Modulus (DMA 40 Hz)	approx. 10 MPa
Shear strength (DIN EN 1465)	approx. 0.4 MPa
layer thickness	2 mm
bonding area	25 x 12.5 mm
substrate	HDG / EGS 0.80 mm
Corrosion resistance	no loss of adhesion, no corrosion
Resistance to aging in Cataplasma	no loss of adhesion, no corrosion

## 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.

## APPLICATION

TEROSON RB 1159 is applied from pails or drums using high pressure pumps with a compression ratio minimum 50:1 and fitted up with following plate. For the best application the use of volume controlled dispensers is preferred. The heated application pistol can be used either manually or on a fixed jig. More commonly is attached to an automatic application system (robot, CNC). It is recommended to switch off heating during a shutdown of more than 1 hour. The pressure should be switched off after 15 minutes of non-production. Independent heating circuits should have the lowest temperature at the follower plate and the highest temperature at the application nozzle. To ensure an optimal wetting to the substrate TEROSON RB 1159 should be applied at elevated temperatures. The material is applied directly to oily sheet metal no more than 3 g/m<sup>2</sup>. If required, we will provide you with the additional information on suitable application equipment.

#### Recommended material temperature:

Follower plate and pump:	15 to 35 °C
Temperature at nozzle:	35 to 60 °C

## CURING

TEROSON RB 1159 is cured while passing the EC oven, e.g. 15 minutes at 175 °C. Minimum curing conditions are 15 minutes at 170 °C. These are effective metal temperatures.

## CLEANING

Fresh, uncured material can be removed with the aid of ethylacetate or gasoline. Cured adhesive can only be removed mechanically.

## STORAGE

Frost sensitive	no
Recommended storage temperature	5 to 25 °C
Shelf life	6 months

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