

TEROSON RB 4199 IV

October 2013

PRODUCT DESCRIPTION

Technology	Rubber
Product Type	Antiflutter Adhesive
Additional Information	Flexible

TEROSON RB 4199 IV 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 4199 IV adheres well to oily steel sheets, aluminum and zinc coated surfaces. The material is flexible and little dependent of changes in temperature. TEROSON RB 4199 IV chemically cross-links at temperatures above 140 °C. The material is compatible with surface treatment and E-coat paint used in the automotive industry. It shows a good corrosion resistance and provides good vibration and noise damping functions. TEROSON RB 4199 IV can be painted after curing.

APPLICATION AREAS

TEROSON RB 4199 IV is used as antiflutter in the automotive body shop 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.

TECHNICAL DATA

(Typical Test Results)

Uncured

Colour	black
Density	approx. 1.5 g/cm ³
Consistency	pasty
Viscosity (Flow-Meter)	5 to 7 g/min
Nozzle	Ø 2 mm
Pressure	4 bar
Temperature	20 °C

Cured (30 min. at 160 °C)

Shear strength (DIN EN 1465)	> 7 MPa
layer thickness	0.2 mm
bonding area	25 x 12 mm
substrate	HDG / EGS 0.80 mm
Corrosion resistance	
salt spray test (35 °C, salt solution 5 %, 500 hours)	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 4199 IV is applied from pails or drums using high pressure pumps with a compression ratio minimum 50:1. For 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 of 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 4199 IV should be applied at elevated temperatures. The material is applied directly to oily sheet metal no more than 3 g/m². 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 4199 IV is cured while passing the EC oven, e.g. 30 minutes at 160 °C. The minimum curing cycle is 30 min at 150 °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	3 months

Disclaimer



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Note:

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