Technical Data Sheet

TEROSON® RB 6313

June 2024

Product description

TEROSON® RB 6313 provides the following product characteristics:

Technology	Rubber
Product type	Pumpable cavity filling
Application	Pumpable cavity filling

TEROSON® RB 6313 is a ADCA free, heat curing, solvent free, pumpable, one component cavity filler based on rubbers. Product viscosity design results in excellent sag and wash-off resistant to aqueous cleaning and pretreatment systems. TEROSON® RB 6313 adheres well to oily steel substrates. The material is extremely flexible, closed cell and watertight resulting in superior cavity sealing performance in area's of high CTE metal movement. TEROSON® RB 6313 begins to chemically cross-link at temperatures above 140°C. Due to the good compatibility to E-coat paint it offers a safe corrosion protection even at boundary areas.

Application:
TEROSON® RB 6313 is used as cavity filler in the automotive body shop and shows good adhesion on oily surfaces. It is specially designed as a pumpable cavity filler typically applied to the pillars, rocker and other sections of vehicle to prevent dust, dirt or humidity to further penetrate the cavities. It is recommended for use, when wash-off resistance must be obtained without pre-gelling or pre-curing, and where a high expansion is required over a wide temperature range.

Technical data

Uncured		
Color	Black	
Specific gravity	1.1-1.2	
Consistency	Pasty	
Solids	> 95 %	
Viscosity	800-1000 Pa.s	600-800 Pa.s
Equipment	P/P 25mm	P/P 25mm
Shear rate	20 S^{-1}	20 S^{-1}
Temperature	23 °C	40 °C

Cured	
Elongation at break, %	> 90
Volume expansion	
High bake	400% minimum
Low bake	400% minimum

Directions 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.

Application:
TEROSON® RB 6313 is applied from pails or drums using high pressure pumps with a compression ratio minimum 50:1. A fully heated dispensing system with min. 5 independent operating heating circuits is recommended. For the best application, the use of volume controlled dispensers are preferred. The heated applicator 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 6313 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, °C	35 to 45
Temperature at nozzle, °C	45 to 60

Curing:

Target cure schedule	20 minutes @ 160°C-180°C
Minimum cure conditions	10 minutes @ 150°C
Maximum cure conditions	20 minutes @ 215°C

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

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

Storage:

Frost-sensitive	no
Recommended storage temperature, °C	10 to 30
Shelf-life, months	3

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