

TEROSON RB 7808

July 2013

PRODUCT DESCRIPTION

Technology	Rubber
Product Type	Antiflutter Adhesive
Additional Information	Flexible

TEROSON RB 7808 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 7808 adheres well to oily steel sheets, aluminum and zinc coated surfaces. The material is flexible and little dependent of changes in temperature. TEROSON RB 7808 chemically crosslinks at high temperatures. Due to the good compatibility to E-coat paint it offers a safe corrosion protection, even at boundary areas. TEROSON RB 7808 can be painted after curing.

APPLICATION AREAS

TEROSON RB 7808 is used 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. Low hardness prevents read-through effects.

TECHNICAL DATA
(Typical Test Results)

Uncured	
Colour	black
Density	approx. 1.4 g/cm ³
Consistency	pasty
Solids	≥ 99 %
Viscosity (Severs)	25 g / min
Nozzle	Ø 4 mm
Pressure	3 bar
Temperature	20 °C
Cured (20 min. at 180 °C)	
Expansion rate	approx. 5 %
Shear strength (DIN EN 1465)	approx. 1.18 MPa
layer thickness	3 mm
bonding area	25 x 12 mm
substrate	HDG / EGS 0.80 mm
Corrosion resistance	
salt spray test	no loss of adhesion,
(35 °C, salt solution 5 %, 720 hours)	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 7808 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 7808 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 7808 is cured while passing the EC oven, e.g. 30 minutes at 180 °C.

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

TEROSON RB 7808

July 2013

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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Henkel AG & Co. KGaA

D-40191 Düsseldorf. Germany

Phone: +49-211-797-0

www.henkel.com**Henkel Central Eastern Europe GmbH**

A-1030 Wien. Austria

Phone: +43-1711-040

www.henkel.com**Henkel & Cie AG**

CH-4133 Pratteln. Switzerland

Phone: +41-61-825-7000

www.henkel.com