

TEROSON® SB 1287

April 2024

Product description

TEROSON® SB 1287 provides the following product characteristics:

Technology	Contact adhesive
Chemical type	Acrylonitrile rubber
Appearance (uncured)	Brown
Odor	Characteristic
Viscosity	Semi-fluid
Cure	Air-dry
Application	Assembly
Specific benefits	<ul style="list-style-type: none">• Easy application• Good temperature resistance

TEROSON® SB 1287 is a semi-fluid, thermo setting contact adhesive based on Acrylonitrile rubbers and phenolic resins. It provides good resistance against high temperatures, plasticizers, oils and lubricants. It is used to bond metal to metal and metal to rigid plastics (ABS, PVC), as well as rubber to metal and metal plates to machinery. Suitable for all applications in which the bonded materials are subject to thermal stress and in which chemical resistance to plasticizers, lubricants and solvents are required.

Typical properties of uncured material

Specific gravity @ 23°C	0.9
Viscosity BRF 20°C (Henkel 107), mPas	3500
Temperature resistance, °C	130°C (with peaks up to 180°C)
Dry residue, %	33 +/- 1,5

Typical curing performance

Drying @23°C, 50%RH	
Open time before joining parts, minutes	3 - 15
Secondary cure at 90°C, min	90
at 150°C, min.	30

General information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet.

Direction for use:

1. The substrates must be clean, dry and grease free.
2. The adhesive is applied uniformly to both bonding surfaces.
3. Depending on normal production cycles, the parts coated with adhesive must be allowed an open time of appr. 3-15 min.
4. To anticipate and increase thermal and chemical resistance after assembling the two parts, it is advisable to subject them to a thermal cycle of 30 minutes at 150°C or 90 minutes at 90°C.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal storage: 8°C to 21°C. Storage below 8°C or greater than 28°C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Product specification

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Approval and certificate

Please contact Henkel representative for related approval or certificate of this product.

Data ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5% RH

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$



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