

## TEROSON SB 2168

July 2015

### PRODUCT DESCRIPTION

TEROSON SB 2168 provides the following product characteristics:

<b>Technology</b>	Polychloroprene
<b>Product Type</b>	Solventbased adhesive
<b>Application</b>	Assembly
<b>Appearance</b>	beige

TEROSON SB 2168 is a solvent containing contact adhesive based on polychloroprene.

TEROSON SB 2168 has excellent initial adhesion and the ability to bond varying substrates to one another.

### Application Areas:

TEROSON SB 2168 can be used as a general purpose adhesive to bond various materials like wood, variable plastics, metals, felts, and many more, to themselves and to one another.

TEROSON SB 2168 can not be used for bonding of polystyrene foam, PE, PP, PTFE and soft PVC.

### TECHNICAL DATA

Colour:	beige
Odour:	of solvents
Density:	approx. 0.89 g/cm <sup>3</sup>
Solids, %	22.6
Viscosity, mPa.s:	~2,300
Diluent / Cleaner:	TEROSON VR 50, TEROSON VR 40
Consumption, g/m <sup>2</sup> :	150 to 250 g/cm <sup>2</sup>
Flash-off time, min:	15 to 20 min.
Application temperature, °C:	18 to 25
In service temperature range, °C:	-30 to 80
Short exposure (up to 1 h):	100° C

### DIRECTIONS OF USE

#### Preliminary statement:

Prior to application 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.

#### Pre-Treatment:

The bonding surfaces must be dry and free of oil, grease, dust and anti-adhesive constituents. Rubber parts must be free of talcum and other gliding agents.

#### Application:

Stir TEROSON SB 2168 before use. The adhesive is then applied uniformly to both bonding surfaces with a brush or spatula (smooth or fine notched).

Depending on application method, layer thickness, temperature, room ventilation and humidity the parts coated with adhesive must be allowed an open time of approx. 15 to 20 minutes. (The so-called "finger test" has proven itself a more reliable judgement of the open time than the time data. The adhesive must be dry but slightly tacky). Taking exact care of the open time is important, for the bonding results can be influenced by a too short as well as too long waiting period.

Match the Parts exactly and press them quickly but firmly.

#### Cleaning:

Adhesive residues/stains can be removed before curing - including application equipment and containers - with Teroson VR 40 or Teroson VR 50 (precheck compatibility with the substrates).

#### STORAGE

Recommended Storage Temperature, °C 10 to 20  
Shelf-life (in unopened original packaging), 12 months

## ADDITIONAL INFORMATION

### 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.

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