

# TEROSON SB 8258-40

Known as Terokal 8258-40  
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## PRODUCT DESCRIPTION

TEROSON SB 8258-40 provides the following product characteristics:

<b>Technology</b>	Solvent-based adhesive
<b>Product Type</b>	Based on polyurethane
<b>Application</b>	Lamination and vacuum forming

TEROSON SB 8258-40 is a solvent containing, high quality, easily sprayable laminating adhesive based on polyurethane, which demonstrates high initial strength at a low activating temperature, high softening point and resistance against hydrolysis.

In order to achieve optimal properties the adhesive is always applied with hardener.

## APPLICATION AREAS

### Materials

TEROSON SB 8258-40 was primarily developed for the laminating of PVS foam foils, ABS foils and textile materials to shaped fibre boards (e.g. Fibrit<sup>®</sup>, Lignotock<sup>®</sup>, Peliform<sup>®</sup>, Wetaform<sup>®</sup>, Cekacell<sup>®</sup>, ...), ABS parts.

### Areas, objects

TEROSON SB 8258-40 is mainly used for the manufacture of laminated interior parts (instrument panels, door and side linings, rear shelves, pillar, prefabricated head liners, etc.) in the automotive industry.

## TECHNICAL DATA

Color:	white
Odor:	of ketones
Consistency:	liquid, sprayable
Solids:	~13%
Viscosity:	~350 mPa.s (at the day of production)

Equipment:	Brookfield RVT
Spindle:	No. 3
Speed:	50 rpm
Temperature:	20°C

Consumption:	100 to 200 g/cm <sup>2</sup> (depending on application)
Hardener:	Teroson SB 8311, 8311 blue Hardener
Diluent/ Cleaner:	Cleaner A
Application time:	8 to 12 h
In service temperature range:	-40 to 90°C *
Short exposure (up to 1 h):	130°C

\* this data is valid for laminated parts

## DIRECTIONS OF 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.

### General remarks:

In order to achieve a high softening point and resistance against hydrolysis TEROSON SB 8258-40 is always applied with TEROSON SB 8311 or TEROSON SB 8311 blue hardener, in mixing ratio of 100:5 - 10 by weight.

### Preparation for bonding:

Surfaces to be bonded must be dry and free of oil, grease, dust, release agents and other contamination.

### Mixing with the hardener:

If the complete content is not used, the adhesive is stirred before use and thoroughly mixed with the relevant quantity of hardener until a uniform color tone is attained.

The pot life (application time) of the mixture is approx. 8 to 12 hours (based on an original container with 20 kg of adhesive and 1.6 kg of hardener).

### Spray application:

The adhesive mixed with hardener is spray applied to one surface of the formed or to be formed carrier material.

When laminating carpets the adhesive can also be sprayed onto the rear side of the carpet.

Spraying can be conducted by hand or automatically (e.g. 1.8 mm nozzle, material and air pressure of 5 to 6 bar).

TEROSON SB 8258-40 can also be applied in the contact method (application to both of the materials to be bonded).

In this case an open time of 3 to 5 minutes has to be observed.

More favorable, however, is laminating in the vacuum or press process.

#### Laminating:

Before laminating the adhesive is allowed to dry (minimum 15 minutes at room temperature or significantly shorter at maximum 40°C).

Laminating should then be conducted within approx. 3 hours, because longer periods possibly necessitate higher activating temperatures and lead to lower adhesion to the substrates.

The minimum activating temperature is 57°C in the bonding joint.

Preactivation of the carrier materials at approx. 40°C and the foils at approx. 80°C has proven particularly favorable.

The edge wrap should be bonded immediately after laminating, i.e. as long as the carrier material is slightly warm.

(In practice, additional warming with a hot air dryer has proven advantageous).

Special care has to be taken that a sufficient amount of adhesive is applied to the edge wrap.

In particularly critical areas the adhesive should be applied to both sides.

#### Important:

Storage of laminated parts before complete curing of the adhesive (within 3 to 4 days after lamination) below 10°C must be avoided because this can lead to irreversible damage of the bond and to lower adhesion strength.

#### Cleaning application equipment:

Adhesive residues/ contaminations can be removed before drying - including application equipment and containers - with Cleaner A (precheck compatibility with the substrates).

#### STORAGE

Frost-Sensitive	yes, conditionally, can be thawed
Recommended Storage Temperature, °C	10 to 25
Shelf-life (in unopened original packaging)	9 months

#### Classification:

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

**Hazards identification**

**Transport information**

**Regulatory information**

#### 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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Reference **N/A**