TEROSON

Technical Data Sheet

TEROSON PU 6800

February 2021

Micro Emission

PRODUCT DESCRIPTION

Technology	Polyurethane, Micro Emission
Product Type	For bonding customising and body parts
Additional Information	2-Component

TEROSON PU 6800 is a polyurethane based two-component adhesive which cures at room temperature. For accelerated curing it is recommended to increase the temperature up to 60 to 70 °C. The product is supplied in a convenient twin cartridge. TEROSON PU 6800 can be painted with standard commercial car repair refinishing paints.

Application Areas:
TEROSON PU 6800 is used in the automotive industry for bonding of plastic parts and repair of PVC-plastisol cosmetic seams.

TECHNICAL DATA
(Typical Test Results)

COMPONENT A	
Colour	grey
Density	approx. 1.6 g/cm³
COMPONENT B	
Colour	white
Density	approx. 1.3 g/cm³
Mixing ratio A : B	
by volume	1 : 1
MIXTURE (Component A + B)	
Colour	grey
Pot life Daimler brushing method	23°C, appr. 14 to 18 min.
Tack-free time (23 °C, 50 % rh)	approx. 40 min(s).
Curing time at 23 °C	approx. 5 hr(s).
Layer thickness	3 mm
Solid to hand pressure	
at 23 °C	approx. 2 hr(s).
at 80 °C	approx. 10 min(s).
Shore A hardness	approx. 80 to 100
Shear strength	
After 2 d (23 °C, 50 % rh)	approx. 10 MPa
Layer thickness	0.3 mm
Cross head speed	10 mm/min.
Paintability	good
In service temperature	-40 to 80 °C

DIRECTIONS FOR 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.

Pretreatment:
The parts to be bonded must be free from oil, grease, moisture, dirt and release agents. Metals may either be primed (e.g. cathodic EC) or they should be grinded. Finally the sanded parts should be cleaned and pretreated with TEROSON VR 20.

Application:
Apply pressure to the cartridge(s) to ensure a simultaneous and homogeneous flow of both components. Thereafter, attach the static mixer and cut the tip to provide for the desired bead size. Discard the first 2 cm of extruded adhesive bead. TEROSON PU 6800 is applied directly to the substrates. Any excess material should be removed immediately after application. If material is left in the cartridge leave the static mixer attached. For further use of the product, simply remove the mixer and install a new one. TEROSON PU 6800 can pass after initial cure the primer and paint ovens in OEM plants.

Curing:
Curing occurs at room temperature. For accelerated curing it is recommended to warm up TEROSON PU 6800 to 60 to 70 °C for minimum 15 minutes.

Cleaning:
Freshly applied and uncured material should be removed with a dry cloth and then cleaned off with a suitable solvent. Cured adhesive can only be removed with a machine.

Classification:
Please refer to the corresponding **Material Safety Data Sheets** for details on:
- **Hazards identification**
- **Transport information**
- **Regulatory information**

Storage:

Frost sensitive	no
Recommended storage temperature, °C	10 to 25
Shelf- life, months	12

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ADDITIONAL INFORMATION

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