Product Information
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Información del producto

Henkel

Teroson

Teromix-6700

Two-Component Adhesive
in a Twin Cartridge
for Bonding Customising and Body Parts

Basis: Polyurethane

Status: 1992-11-02

Product Description

Teromix-6700 is a polyurethane-based two-component adhesive which cures at room temperature. Curing can be accelerated by increasing the temperature (e.g. IR radiator). The product is supplied in a convenient twin cartridge and is rapid-curing. Teromix-6700 can be painted with normal commercial car paints.

Application Areas

Teromix-6700 is used in motor vehicle body repair shops for bonding customising and body parts.

Examples of possible applications include:

- antiflutter/stiffening (motor hood with strut, roof skin and framing), wing and wheel housing
- bonding of plastic components such as glass fibre reinforced duromers (SMC, BMC/ZMC) to each other and to metals
- corrosion protection on hem flange joints.

Technical Data

	Component A	Component B
Colour:	beige	black
Density:	approx. 1.4 g/cm^3	approx. 1.7 g/cm^3
Solids (3 h at 100°C):	> 98 %	> 98 %
Mixing ratio by volume:	100 :	100

	Mixture (components A + B)	
Colour:	dark grey	
Pot life (100 g, 23°C):	ca. 10 mins	
Tack-free time:	ca. 30 mins	
Solid to hand pressure:	at 23°C	ca. 2 hrs
	at 80°C	ca. 10 mins
Curing time at 23°C:	ca. 6 hours (85 % of final strength)	
Shore A hardness:	ca. 90	
Shear Strength:	approx. 23 MPa on	
(measured after 2 d at 23°C):	ca.13 MPa	
Cross head speed:	100 mm/minute	
Paintability:	good	
In service temperature range:	-40°C to 80°C	
Short exposure (up to1 hour):	140°C	

Preliminary remark

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 labelling, the relevant precautions should always be observed.

Pretreatment of the adhesion surfaces

The parts to be joined must be free from oil, grease, moisture, dirt and release agents.

One proven method of preparing the bonding faces of plastics is mechanical roughening of the surface (brushing, abrasive rubbing, sandblasting). Such mechanical treatment removes adhesion-inhibiting surface layers (e.g. release agents). Metals may either be primed (e.g. cathodic EC, 2-component epoxy resin primer) or they should be grinded.

The Teromix system

The Teromix system consists of the Teromix hand gun, the efficient Teromix-6700 double cartridge and a mixer nozzle (static mixer). Precise instructions are included with every pack.

Inserting the cartridge

Push the lock on the Teromix hand gun upwards and draw the piston bar back as far as the stop. Place the Teromix cartridge in the cartridge guide, unscrew the cap from the cartridge and screw on the mixer nozzle. Cut the end of the mixer nozzle to produce the desired size of bead.

Applying Teromix-6700

When the gun lever is operated, the material is forced through the mixer nozzle and the two components are automatically mixed. (Do not use the first 2 cm of extruded adhesive bead, for these might not be perfectly mixed.) Teromix-6700 is applied directly onto the substrate without the need for any chemical primer. Any excess material should be removed immediately after application.

If all the contents of the cartridge are not used, then the mixer nozzle should not be removed. The cured adhesive within the mixer will seal the cartridge. A new mixer nozzle will have to be used if the cartridge is re-used.

Curing

The bonded joint can be worked mechanically after 2 hours at room temperature; a waiting period of 15 minutes is sufficient if an infra-red radiator is used with a tempearture of 60°C. The infra-red radiator should be placed at a distance of ca. 30 cm from the bond. Object temperature 60°C.

Cleaning

Fresh, non-cured material (e. g. for cleaning tools, cleaning contaminations on the substrates etc.) may first be removed dry and then cleaned off with a suitable solvent (e.g. acetone, ethyl acetate, Cleaner-A, Cleaner-D). Cured adhesive can only be removed mechanically.

Important Note

Joints may become visible if repairs are performed on sections of panels.

Storage

Frost-sensitive	no
Recommended storage temp.	10°C to 25°C
Shelf-life	12 months

Packaging

Bag with twin cartridge	2 x 25 ml	Art.-No. 170.34 Q (D/GB/F/NL)
Teromix-Hand Gun		Art.-No. 117.16 K
Static Mixer		Art.-No. 117.55 C

Hazard Indications/ Safety Recommendations/ Transport Regulations	see Safety Data Sheet

Important
The above data, particularly the recommendations for application and use of our products are based on our knowledge and experience. Due to different materials and conditions of application which are beyond our k-nowledge and control we recommend strongly to carry out sufficient tests in order to ensure that our products are suitable for the intended processes and applications. Except for wilful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

This Technical Data Sheet supersedes all previous editions.

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