



Technical Data Sheet

Terokal-4310

Macroplast UK 8210



Solvent free, two component adhesive
castable

Base: Polyurethane

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Product Description

Terokal-4310 is a high quality, solvent free, two component adhesive, based on polyurethane. It is pourable, reaches high strength and has proven to be an excellent product in outdoor use, e.g. sandwich systems for facade elements, for many years. The fully cured adhesive film is hard.

Application Areas

Materials

Terokal-4310 is used to bond PVC rigid foam, polyurethane rigid foam, phenolic resin foam, mineral fibres and other insulation materials to painted and primed metals, wood and wooden materials and plaster board.

Sectors of industry

Terokal-4310 is mainly used in the manufacture of sandwich systems (facade elements, partitioning walls) and as a potting material with adhesive properties in the electronics industry.

In addition, the adhesive is used for bonding of acrylic glass to one another and to light alloys (bubble levels made of acrylic glass).

Technical Data

	Component A		Hardener 700 Macroplast UK 5480
Colour:	light beige		brown
Density:	approx. 1.4 g/cm ³		approx. 1.2 g/cm ³
Solids:	> 99 %		> 99 %
Consistency:	thick liquid		thin liquid
Viscosity:	approx. 12.000 mPa.s		approx. 200 mPa.s
Equipment:	Brookfield RVT		Brookfield RVT
Spindle:	7		7
Speed:	20 rpm		20 rpm
Temperature:	20°C		20°C
Mixing ratio:			
by weight:	3.5	:	1
by volume:	3	:	1
	Mixture (Component A + B)		
Colour:	beige-brown		
Odour:	practically odourless		
Density:	approx. 1.35 g/cm ³		
Consistency:	liquid		
Solids:	approx. 100 %		
Viscosity:	approx. 3.700 mPa.s		
Equipment:	Brookfield RVT		
Spindle:	7		
Speed:	20 rpm		
Temperature:	20°C		

Potlife:	approx. 45 mins
Mixture:	100 g
Temperature:	23°C
Application temperature:	5°C to 30°C
Consumption:	150 - 300 g/cm ² in the case of application to both bonding surfaces, depending on the substrates concerned and method of application
In service temperature range:	- 30°C to 100°C
Short exposure (up to 1 h):	150°C

Preliminary statement

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

The substrates must be free of oil, grease, humidity and excess dirt. For cleaning Cleaner-A, Cleaner-D and Cleaner-FL from the Teroson range can be used.

Application

Component A and Hardener-700 are mixed in the recommended mixing ratio of 3.5 : 1 until a homogeneous, stripe free colour tone is achieved. Mixing can be done by hand, or in the case of larger quantities by means of an electric drill equipped with a mixing spiral. We recommend a mixing speed of approx. 200 rpm for 3 minutes.

After mixing, the adhesive is ready to use and can be applied with a spatula, roller or by spraying to one substrate surface. When spraying, the safety precautions for isocyanate containing products must be observed.

At a room temperature of 23°C the potlife of a 100-g- batch is approx. 45 min. During the first 20 minutes of this period, the material exhibits very good pourability.

Application with special automatic dosing, mixing and application equipment is also possible. (Further information is available on request.)

Cleaning

Fresh, uncured material (cleaning application equipment, substrate contamination) can first be removed drily and thereafter with the aid of solvents, like Cleaner-A, Cleaner-D. Cured adhesive can only be removed mechanically.

Storage

Frost-sensitive	no
Recommended storage temperature	10°C to 20°C
Shelf-live	12 months (both components in original packaging)

Packaging

Pail	5 kg (component A)
Tin	1 kg (Hardener-700)

**Hazard Indications/
Safety Recommendations/
Transport Regulations**

see Safety Data Sheet

Important

The data above, particularly the recommendations for application and use of our products is based on our knowledge and experience. Due to different materials and conditions of application which are beyond our knowledge and control we strongly recommend carrying out sufficient tests in order to ensure that our products are suitable for the intended process 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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