

## Product Type

Universal Sealer for Body Shop, 20% Expandable

## Substrate Type

CRS, GA, Aluminum, Pre-Phos, Hot Stamp

## Application

Anti-Flutter Mastic sealer, Spot Weld Sealer

## Product Technology

TEROSON RB 4931 is an elastomeric based, cold applied, pumpable rubber based mastic and spot weld sealer. The material is applied between inner and outer panels to prevent metal-to-metal contact and to reduce vibration. TEROSON RB 4931 has good adhesion on oily metal and aluminum surfaces and excellent wash off resistance.

## Typical Properties

Property	Typical Results
Color	Black
Odor	Mild
Consistency	Paste
Specific Gravity	1.49
Curing Mechanism	Heat Cure
Viscosity – Severs (sec/20g) 25C	30 - 50
Adhesion Strength, CRS, Bake at 170C, for 20 minutes	
Initial	>0.1 MPa Cohesive Failure
Heat Aging	>0.1 MPa Cohesive Failure
Hot Water Aging	>0.1 MPa Cohesive Failure
Over bake CRS, Bake at 200°C, for 60 minutes	>0.1 MPa Cohesive Failure
Under bake CRS, Bake at 160C, for 30 minutes	>0.1 MPa Cohesive Failure
Adhesion to Oily Surface	No slippage
Rubber Properties Elongation	>100%
Rust Resistance	No corrosion
Shower Resistance	No splattering
Flash Point	>104°C
Expansion	17 - 23%
Application Temperature	Ambient

## Operating Summary

- It is recommended that testing is completed on substrates to be used to validate this material prior to use.
- To obtain optimum strength the following cure conditions have proven successful:
  - >30 minutes @ 160°C metal temperature
  - <60 minutes @ 200°C metal temperature
- Deviations from cure cycle may result in deviations from the shear strength which may interfere with material performance.

## General Information

- Shutdown - For extended shutdown periods, greater than 8 hours, it is recommended that pressure be removed from the system to reduce possibility of caking in lines.
- Material Purge - Regular purge and cleaning of the application system is recommended, please contact your sales representative for material requirements and instructions.
- As with all materials, it is recommended that to ensure consistent material, this product is used in a First In - First Out stock rotation system.

## Equipment

- It is recommended that this material be dispensed using a pumping system. This should include a high pressure ratio pump, with recommended ratio of 55:1 or greater. Care should be taken in system design to insure that flow restrictions are minimized. Flow restrictions occur when headers, hoses, and/or nozzles are too small for the application. By reducing flow restriction, it is possible that lower ratio pumps can be used.

## Metal Surface Preparation

- This material has been developed to adhere to oily metals.
- For best performance, substrate should be free of dust, dirt and contamination before material is applied.

## Product Removal

- Fresh, uncured material can be removed with the aid of Isopropyl Alcohol. Large amounts of material can be removed using towels or rags and then cleaned with Isopropyl Alcohol.
- Cured material can only be removed mechanically

## Health and Safety

- For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**
- Prior to application it is necessary to read the Safety Data Sheet for information about precautionary measures and safety recommendations.
- For chemicals exempt from compulsory labeling, the relevant precautions should always be observed.

## Product Control Test Method

- No specific test methods are recommended to be used by customer.
- Additional information on product testing is available upon request.

## Storage Requirements

- Store product in the unopened container in a dry location
- **Keep away from heat and direct sunlight.**
- **Store between 10°C and 30°C (50°F and 86°F)**
- **Material is not frost sensitive.**
- **Shelf life of product is 90 days.**
- Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

## Waste Disposal

- Refer to MSDS for further information

## Order Information

- Bulk IDH Number **1953383**
- Please call for available packaging

**Creation Date** 30 April 2014

**Revision Date** 24 September 2014 **Revision Number** 1

## Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
mm / 25.4 = inches  
 $\mu\text{m} / 25.4 = \text{mil}$   
N x 0.225 = lb  
N/mm x 5.71 = lb/in  
N/mm<sup>2</sup> x 145 = psi  
MPa x 145 = psi

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## REVISION HISTORY

9.24.14 Updated product technology to show rubber based product

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