



TEROSON

Technical Data Sheet

TEROSON PU 8599

March 2015

Direct Glazing adhesive with high position tack PRODUCT DESCRIPTION

Technology	1c Polyurethan Adhesive free from PVC and solvents
Product Type	Direct Glazing for industrial use Elastic Bonding
Additional Function	High position tack

TEROSON PU 8599 is outstanding for the following properties:

- Very good sag resistance
- High cure rate
- High shear strength and good elasticity, even after aging
- Excellent adhesion to glass, glass with ceramic coating, encapsulation and to painted surfaces, in connection with primer/activator

APPLICATION AREAS

TEROSON PU 8599 is used for the bonding of front, rear and side screens to the body of motor vehicles (car, truck, bus).

TECHNICAL DATA (Typical Test Results)

Colour	black
Odour	imperceptible
Consistency	pasty
Density	1.27 g/cm ³
Viscosity at 50 °C	6,000 to 7,500 Pas
Solids	100 %
Curing mechanism	moisture curing, accelerable
Cure rate (23 °C, 50 % rh)	approx. 4 mm / 24 h
Skin formation time (23 °C, 50 % rh)	approx. 20 min
Shore A hardness	approx. 70
Tensile strength	approx. 9 MPa
Elongation at break	approx. 400 %
Shear modulus G10	approx. 2.5 MPa
Shear strength	5 MPa
In service temperature range	-40 to 90 °C
Recommended application temperature	50 to 65 °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 labeling, the relevant precautions should always be observed.

SURFACE PRETREATMENT AND PRIMING

Ensure that the substrates to be bonded are dry and free from oil, dust, grease and other dirt. Use for glass, paint and cathaphoretic dip painting (E-coat) the approved cleaners. The approved Henkel primer has to be used according to prior agreement with Technical Customer Service.

Application

It is necessary to use a complete heated application system. To face the HPT effect the material must be heated up to minimum 60°C.

- The entire equipment, including hoses and pipes, must be moisture tight.
- The follower plate must be driven by a double ram.
- Necessity of centering the container.
- It is recommended to switch off heating during a shutdown of more than 1 hour.
- The adhesive is applied from pails or drums using high pressure piston pumps with a pneumatic ratio minimum 55:1.

Due to the various application conditions it is recommended to follow the references in the current valid application data sheet. The application data sheet also provides necessary information about suitable application equipment and conditions. For further information, please contact the responsible sales representative.

STORAGE

Frost sensitive	no
Recommended storage temperature	15 to 25 °C
Shelf life	6 to 12 months depending on packaging



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