



Terostat-9220

One-component Power Adhesive
 with High Bonding Strength
 for Primerless Application

Basis: MS[®]-Polymer

Status: 2002-05-23

Product Description

Terostat-9220 is a one component adhesive with high sag resistance, based on MS[®]-polymer. The material cures by reaction with moisture to an elastic product. The skin formation and curing times are dependent on humidity and temperature, and the curing time also depends on joint depth. By increasing the temperature and moisture these times can be reduced; low temperature as well as low moisture retard the process.

Terostat-9220 is free of solvents, isocyanates, silicones and PVC and has only a weak odour (after curing it is odourless). It demonstrates good adhesion without primer to many substrates.

Terostat-9220 also demonstrates good UV resistance and can therefore also be used for exterior applications.

Application Areas

Terostat-9220 is used in the areas

- vehicle body manufacture
- bus manufacture
- vehicle body build-ups
- caravan
- ship and boat building

for elastic bonding without primer and high quality sealing on metallic surfaces (including galvanized metal sheets and aluminium) or painted surfaces. Terostat-9220 is also fitted for bonding glass, ceramic surfaces and most plastics, except Teflon[®], PE, PP and blends with these polymers. For this reason trials are recommended prior to bonding of plastics. After matching of the materials to be bonded a high adhesion strength is obtained.

Technical Data

Colour:	black
Odour:	odourless
Density:	approx. 1.4 g/cm ³
Consistency:	thixotropic paste
Curing mechanism:	humidity curing
Skin formation time:	10–20 mins *)
Tack free time:	20–30 mins *)
Cure rate:	approx. 3.5 mm/24 h *)
Sag resistance:	high
Shore-A-hardness (DIN 53505):	55–60 *)
Tensile strength (DIN 53504):	ca. 3.3 MPa *)
Shear strength (based on DIN EN 1465):	ca. 4,4 MPa *)
Substrates:	painted sheet metal
Layer thickness:	0.2 mm
Cross head speed:	10 mm/min
Volume change (DIN 52451):	<2 %
Application temperature:	15°C to 35°C
In service temperature range:	-40°C to 100°C *

Short exposure (up to 3 hr.): 120°C

*) tested at DIN 50014 standard climate

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 labeling, the relevant precautions should always be observed.

Pretreatment

The substrates must be clean, dry, oil and grease free. For cleaning, Cleaner-D, Cleaner-FL and Cleaner-R from the Teroson programme are suitable.

General

Low material temperatures of the sealant will lead to an increase of viscosity, resulting in a lower extrusion rate. This can be avoided by bringing the sealant up to room temperature prior to application. If substrates are too cold temperature may fall below dew point causing condensation. This can be avoided by bringing the substrates up to room temperature in time.

Application

Terostat-9220 can be directly applied from cartridges employing standard air or hand operated guns resp. the Mini-Snap Pistol. Teroson recommends the use of

- Teleskop Pistol Power-Line Art.-No. 141.84 S
- Teleskop-Pistol Multi-Press Art.-No. 195.51 B
- Teroson-Hand Pistol 340 Art. No. 121.39 V
- Staku Hand Pressure Pistol Art.-No. 167.65 Y
- Mini-Snap Pistol Art.-No. 101.55 N

In the case of compressed air application a pressure of 2–5 bar is required, depending on nozzle aperture and application speed. When applying Terostat-9220 in closed rooms, it is important to ventilate well during the curing process.

Cleaning

For cleaning application equipment contaminated with uncured Terostat-9220 we recommend the use of Cleaner-D. Cured material can only be removed mechanically. Cured material can only be removed mechanically.

Storage

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

Packaging

Cartridge	310 ml	Art.-No. 106.41 R (D/GB/F/NL)
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**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 knowledge 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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