

**TEROSON PU 9225 SF ME**

November 2013

**Super fast curing material, Micro Emission****PRODUCT DESCRIPTION**

<b>Technology</b>	Polyurethane, Micro Emission
<b>Product Type</b>	For the repair of plastic parts
<b>Additional Information</b>	2-Component

TEROSON PU 9225 SF ME is a polyurethane based two-component adhesive which cures at room temperature. For accelerated curing it is recommended to increase the temperature up to 60 to 70 °C. The product is supplied in a convenient twin cartridge and is rapid-curing. TEROSON PU 9225 SF ME can be painted with normal commercial car repair refinishing paints. When applying TEROSON PU 9225 SF ME to plastics the use of an approved Henkel primer is absolutely necessary. Detailed information see directions of use.

**APPLICATION AREAS**

TEROSON PU 9225 SF ME is used for repair of bumpers, trim and body parts made of plastic e.g. PP / EPDM, SMC, PC, PA, ABS, and PUR.

**TECHNICAL DATA**

(Typical Test Results)

**COMPONENT A**

Colour grey  
Density approx. 1.6 g/cm<sup>3</sup>

**COMPONENT B**

Colour white  
Density approx. 1.3 g/cm<sup>3</sup>

**Mixing ratio A : B**

By volume 1 : 1

**MIXTURE (Component A + B)**

Colour grey  
Potlife (25 g, 23°C ) approx. 2 min(s)  
Tack-free time (23 °C, 50 % rh) approx. 20 min(s).  
Curing time at 23 °C approx. 1.5 hr(s).  
Layer thickness 3 mm  
Shore A hardness approx. 95  
Grindability good  
Shear strength  
After 2 d (23 °C, 50 % rh) approx. 8 MPa  
Layer thickness 0.3 mm  
Cross head speed 10 mm/min.  
Paintability good

**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.

**DIRECTIONS OF USE****Pretreatment**

The parts to be bonded must be free from oil, grease, moisture, dirt and release agents. Pre-cleaning with a high pressure injection cleaner is recommended. After drying the parts should be cleaned with Teroson FL+. Damaged plastic parts have to be sanded on the face side with a narrow belt sander (grit P 80 to 120) to grind a V-groove (1 to 2 cm). Finally the sanded parts should be cleaned with Teroson FL+. When applying TEROSON PU 9225 SF ME to plastics the use of primer Teroson 150 in a thin layer is absolutely necessary. Evaporation time is approx. 10 minutes.

**Application**

Insert the cartridge into a suitable application gun. Apply pressure to the cartridge(s) to ensure a simultaneous and homogeneous flow of both components. Thereafter, attach the static mixer and cut the tip to provide for the desired bead size. Discard the first 2 cm of extruded adhesive bead. TEROSON PU 9225 SF ME is applied directly to the substrates. Any excess material should be removed immediately after application. If material is left in the cartridge leave the static mixer attached. For further use of the product, simply remove the mixer and install a new one. In case of plastic repair the use of woven fibreglass mat is recommended for reinforcing.

**Reinforcing**

In the case of simple cracks TEROSON PU 9225 SF ME can be applied in one step to both, the face side and the rear side. For more difficult damages, the adhesive should be applied to both sides separately. Start with two continuous beads on the rear side and place them to both sides of the damaged area (bond with minimum 100 mm). For large damages e.g. holes, it is recommended to reinforce the complete damaged area with woven fibre glass mat by incorporating the mat in the beads. Reinforce initial crack areas with woven glass fibre mat in the same way. Then apply TEROSON PU 9225 SF ME on top of the reinforced matting and smooth the surface. Ensure that the adhesive is pressed through the crack and the fibre glass mat to the front side to guarantee a reliable bonding. During applying TEROSON PU 9225 SF ME, keep the mixer tip within the material to avoid air inclusions. Apply an excess of TEROSON PU 9225 SF ME in the same way to the front side.

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**Curing**

Curing occurs at room temperature. For accelerated curing it is recommended to use a heat source. To get a faster grindability the parts bonded with TEROSON PU 9225 SF ME can be warmed up to 60 to 70 °C for minimum 3 to 4 minutes.

**Pretreatment for finish**

After curing of the material these following steps are necessary:

Sanding and cleaning (P150/ P240, TEROSON FL+); priming (TEROSON 150); Further treatment e.g. filling, painting has to be carried out according to paint manufacturers directions for painting plastics.

**Cleaning**

Freshly applied and uncured material should be removed with a dry cloth and then cleaned off with a suitable solvent. Cured adhesive can only be removed with the use of a machine.

**STORAGE**

Frost sensitive	no
Recommended storage temperature	10 to 25 °C
Shelf life	12 months

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