

Teroson SB 412

July 2014

PRODUCT DESCRIPTION

Teroson SB 412 provides the following product characteristics:

Technology	Natural Rubber
Product Type	Adhesive/Sealant
Application	Assembly
Appearance	Black

Teroson SB 412 is a solvent containing, high viscosity adhesive/sealant based on natural rubber which is self-leveling and thus forms a smooth surface. After complete drying the material can be painted. Accelerated oven drying is not recommended because of the danger of creating blisters. Due to its excellent adhesive properties, Teroson SB 412 can also be used as an adhesive where certain bridging properties are required. Teroson SB 412 demonstrates good adhesion to rubber, glass, steel and aluminium (raw, treated or painted), sound dampening sheets, felt and derived timber products.

Application Areas:

Teroson SB 412 is used as a sealant for joints, seams, cable lead-throughs, butt joints, overlaps, especially in cases where a certain degree of leveling is desired. Teroson SB 412 is particularly used as an adhesive when larger tolerances have to be bridged over and elasticity is required.

Main application areas for Teroson SB 412 are the automotive industry, vehicle body manufacture, vehicle repair, sheet metal fabricating industry, crafts and DIY.

TECHNICAL DATA

Density, g/cm ³ :	approx. 1.21
Consistency:	thick liquid
Solids, %:	approx. 69
Viscosity, mPa.s:	approx. 65.000
Equipment:	Epprecht Rheomat STV
Rotor:	ZD5
Speed, rpm:	200
Open time, min*:	approx. 5 to 10
Application temperature, °C:	15 to 20
In service temperature range, °C:	-20 to 80
Short exposure (up to 1 h):	100° C

DIRECTIONS OF USE

Preliminary statement:

Prior to application it is necessary to read the **Material 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.

Pre-Treatment:

The contact surfaces must be dry and free of oil, grease and dirt. Rubber parts must be free of talcum and release agents. For cleaning we recommend Teroson A or FL.

Application:

Use as sealant

Teroson SB 412 is applied from tubes or cartridges as a bead into or onto the seam or joint to be sealed.

When applying Teroson SB 412 from nozzle cartridges, the cartridge nipple should be cut off above the thread and the nozzle should be screwed on and cut at an angle to the required opening size. The cartridge is placed in the Teroson gun (manual, Staku or Telescopic Gun Power-Line) and the nozzle is passed along the joint at close proximity so that the sealant is injected/applied under contact pressure. Cartridges which are not completely used can be kept for a certain period of time with the nozzle fit, if:

- a bead of approx. 10 mm length is pressed out and allowed to solidify. For re-use, the solidified material is simply pulled off and discarded - fresh sealant will then be pressed out

or

- the nozzle hole is blocked off with a plug made of Teroson RB II, VII or IX

Any necessary smoothing or wiping with a brush or trowel should preferably be performed before the end of the skinning period.

Use as adhesive

The parts to be bonded are uniformly coated with a brush or trowel. On porous materials one-sided application is conducted. The parts are positioned together immediately, re-positioning is possible. On non-porous substrates two-sided application is necessary. After an open time of 5-10 minutes, the parts should be positioned correctly together, re-positioning is not possible. Finally the parts are briefly, but strongly pressed together.

Cleaning:

Adhesive residues/contaminations can be removed before drying with cleaner Teroson FL.

STORAGE

Frost-Sensitive No
Recommended Storage Temperature, °C 15 to 25
Shelf-life (in unopened original packaging), 12 months

ADDITIONAL INFORMATION

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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