

TEROSON PU 8590

March 2017

PRODUCT DESCRIPTION

TEROSON PU 8590 provides the following product characteristics:

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| Technology | 1K- Polyurethane adhesive free from PVC and solvents |
| Product Type | Direct Glazing for repair |
| In driving condition with airbag | 8 hours after the window has been bonded (Crash-Norm: FMVSS 208/212) |

Application Areas:

TEROSON PU 8590 is used for the bonding of front, rear and side screens to the body of motor-, utility-, special- and rail vehicles.

TECHNICAL DATA

(Typical Test Results)

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| Colour | black |
| Odour | weak |
| Consistency | smooth, pasty, sag-resistant |
| Density g/cm ³ : | approx. 1.24 |
| Solids | 100 % |
| Curing mechanism: | humidity curing |
| Cure rate: (DIN 50014; 23°C, 50% rh) | approx. 3 to 4 mm / 24 h |
| Shore-A-hardness: (DIN 53505) | approx. 55 |
| Tensile strength: (DIN 53504) | approx. 8.5 MPa |
| Stress: (DIN 53504) | approx. 2.5 MPa at 100 % elongation |
| Shear modulus: (according to DIN 54451) | approx. 1.2 MPa |
| Elongation at break: (DIN 53504) | approx. 400 % |
| Shear strength: after 24 h (DIN 54451) | 2 MPa |
| Layer thickness 5mm based on DIN 54451 | 5 to 6 MPa (fully cured) |
| Specific forward resistance: (ASTM D 257-99 / DIN IEC 60093) | approx. 1×10 ⁵ Ω cm |
| Volume change: (DIN 52451) | < 1 % |
| Glazing time*: | max. 25 min |
| Material application temperature, °C: | 5 to 35 |
| Environmental temperature at application, °C: | -10 to 45 |

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| In service temperature range, °C: | -40 to 90 |
| Short exposure (up to 1 h), °C | 120 |

* period of time between beginning of material application until inserting of the pane

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use 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.

Surface Preparation:

The substrates to be bonded must be dry and free from oil, dust, grease and other contaminations.

Clean new glass thoroughly with TEROSON VR 100.

Check new glass if it is correct and free of any damage.

To obtain an optimal adhesion we recommend abrading the windscreen's bond line with the TEROSON ET Cleaning sponge in order to have a clean surface.

Clean and pretreat the bonding surfaces with TEROSON VR 20 after abrading and allow to dry for 2 minutes.

The layer remaining in the window cut-out need not to be cleaned. If, however, cleaning of this remaining layer is indispensable, an evaporation time of at least 5 minutes has to be observed before the sealant can be applied, since the adhesive surfaces must have fully dried.

Priming:

With the use of an applicator apply a thin layer of All-in-one primer TEROSON PU 8519P to the cleaned substrate surface.

Ensure the wet film should be 0.025 mm.

Let the primed surface evaporate for approx. 2 minutes before the direct glazing sealant is applied.

If a fresh bonding is made directly on the remaining material layer (left in the window cut-out of the body), this layer should not be primed within the first 2 hours after cutting back. But if the remaining layer is not used within the first 2 hours, it has to be activated with TEROSON PU 8519P. Provided that it is not contaminated with dust or grease, the remaining layer is the best adhesive surface, if TEROSON PU 8590 is used for the new bond.

If windows are bonded which have been pre-coated with a

primer or PUR-based adhesive/sealant by the glass supplier, the primer TEROSON PU 8519P is also suitable to ensure the correct adherence of TEROSON PU 8590 to the pre-coating.

By means of an applicator, a thin layer of TEROSON PU 8519P is applied to the pre-coating. Following this, an evaporation time of approx. 15 minutes has to be observed. Subsequently, TEROSON PU 8590 is applied as usual, but taking into consideration the layer thickness of the pre-coating.

Processing:

The direct glazing sealant TEROSON PU 8590 is processed from the cartridge or foil pack using commercial equipment such as hand, battery driven or air-pressure guns with a piston rod.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

- Hazards identification**
- Transport information**
- Regulatory information**

Storage:

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| Frost sensitive | no |
| Recommended storage temperature, °C | 5 to 25 |
| Shelf- life | 12 months foil pack 18 months aluminum cartridge |

ADDITIONAL INFORMATION

Disclaimer

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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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