

Terostat-8596

Moisture Curing, One-Component
Direct Glazing Sealant for Repair Glazing of Vehicles
Vehicle without Airbag can be Driven after 2 Hours
with Airbag after 6 Hours
Solvents and PVC free

Basis: Polyurethane

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Technische Information
Technical Information

Henkel

Teroson

Product Description

Terostat-8596 is a one component, moisture curing Direct Glazing Sealant with excellent sag resistance based on polyurethane, which cures by reaction with moisture to a soft 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.

The Direct Glazing Sealant demonstrates the following characteristics:

- excellent adhesion with Primer Terostat-8517 H on glass, ceramic coated glass and on painted surfaces
- excellent adhesion on material residues
- high cure rate
- high UV resistance in connection with Primer Terostat-8517 H
- high shear strength, retained on ageing.

Application Areas

Bonding of front, rear and side screens to the body of passenger cars, trucks, busses, forklift and tractor cabins as well as special vehicles. Single or double pane side window glazing in the bus and railway coach industry.

Technical Data

1. Terostat-8596

Colour:	black
Odour:	weak
Consistency:	smooth, sag-resistant paste
Density:	approx. 1.2 g/cm ³
Solids:	100 %
Curing mechanism:	moisture curing
Cure rate:	approx. 5 mm/24 h
(DIN 50014 standard climate:	23°C, 50 % rh)
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 (DIN 54451):	approx. 1.2 MPa
Elongation to break (DIN 53504):	approx. 300 %
Shear strength:	approx. 2 MPa (after 24 h DIN 50014)
(thickness 5mm,	5–6 MPa (fully cured)
based on DIN EN 1465)	
Volume change (DIN 52451):	< 1 %
Glazing time:	maximum 25 mins *
Application temperature:	5°C to 35°C
In service temperature range:	-40°C to 90°C
Short exposure (up to 1 hr.):	120°C

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

2. Terostat-Primer-8517 H

Colour:	black
Density:	approx. 0.98 g/cm ³
Solids:	approx. 36 %
Optimum layer thickness:	50 µm wet
Drying time:	approx. 15 mins
Primer open time:	up to 24 h after application

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 labelling, the relevant precautions should always be observed.

1. Cleaning

The surfaces to be bonded must be dry, free of oil, dust, grease and other contaminants. Glass or ceramic coatings as well as the painted surface are cleaned with Cleaner-FL. The residual cut layer (see below) should not be cleaned. If cleaning of this layer cannot be avoided, a **drying time of a minimum of 30 minutes** prior to sealant application has to be observed, because the adherents have to be absolutely dry.

2. Priming

Surface priming is carried out by a thin (ca. 0.05 mm wet) and even coating of Primer-8517 H on the cleaned glass, ceramics or paint surface, using the applicator provided with the Repair Set. The primed area must be allowed to air dry for ca. 15 minutes before applying the Direct Glazing Sealant.

Do not use a primer when the material is applied onto a bead of cut and cured adhesive/sealant left on the body flange. The cut surface – if not contaminated by dust or grease – provides an ideal substrate for application of fresh Terostat-8596.

3. Activation of pre-coated screens

Screens which have been pre-coated by the glass manufacturer with a PUR based adhesive/sealant must be treated with Activator Terostat-8525 to ensure trouble-free adhesion of Terostat-8596 on to the pre-coated layer.

Terostat-8525 is applied with a wool applicator in a thin layer and allowed to air dry for ca. 15 minutes. Terostat-8596 can then be applied in the normal manner but care must be exercised to take into account the 2 mm thickness of the pre-coating.

Screens pre-coated with PUR based adhesive/sealant are used for instance on many types of VW/Audi vehicles.

3. Application

Terostat-8596 can be directly applied from cartridges employing standard air or hand operated guns. Teroson recommends the use of

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|--|----------------------------|
| – Teroson Telescopic Pistol Power Line IDH | Art-Nr. 141.84 S
211757 |
| – Teroson Staku manual hand gun IDH | Art-Nr. 167.65 Y
142240 |

The instructions included in the Teroson Glazing Repair Set contain a detailed description of the repair operation.

Test Certificate

Terostat-8596 is tested by the German TÜV. The respective test certificate of the TÜV-Rheinland is available:

Drive-away time

after window installation (according to the US-Norm FMVSS 208/212)

with Airbags: 6 hours

without Airbag: 2 hours

Storage

Frost-sensitive

no

Recommended storage temp.

10°C to 25°C

Shelf-life

18 months in original packaging

Packaging

Cartridge	310 ml	Art.-No. 164.75 H IDH 450 533
Direct Glazing Repair Set	Set	Art.-No. 168.83 B IDH 450 532
Applicator Set	25 pieces	Art.-No. 140.64 M IDH 142245

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.

Germany:

Henkel KGaA
D-40191 Düsseldorf
Telefon (06221) 704-0
Telefax (06221) 704-698

UK:

Henkel Loctite Adhesives Ltd.
Watchmead
Welwyn Garden City
Hertfordshire AL7 1JB
Telephone (01707) 35 88 00
Telefax (01707) 35 89 00