

TEROSON® PU U632 / TEROSON® PU U153

(KNOWN AS BONDMASTER® U632)

January 2014

Issued
2/2/2015

Product Type

Two-Part Polyurethane Adhesive

Application

Headlight manufacture: for bonding lens to body. For any other substrate, please ask for our technical advice.

Typical Properties

Property	Polyol TEROSON PU U632	Isocyanate TEROSON PU U153
Appearance	Viscous Paste	Thick Liquid
Colour	Black	Black
Density	Approx. 1.60 g/cm ³	Approx. 1.33 g/cm ³
Solids	>99%	>99%
Brookfield Viscosity RVT @ 23°C	Approx. 150,000 mPa-s (#7 spindle @ 20 rpm)	Approx. 22,000 mPa-s (#6 spindle @ 10 rpm)
Mix Ratio By Weight By Volume	100 100	18 21.3
Pot Life on 60 g	Approx. 3 minutes	
Shear Strength	>1.5 MPa	

Operating Summary

- It is recommended that testing is completed on substrates to be used to validate this material prior to use.
- Deviations from cure cycle may result in deviations from the shear strength which may interfere with material performance.

Equipment and Application

- Apply using a meter mix pump.
- Product is temperature sensitive with a short pot life.
- Use only static mix head.
- Extrude a bead on one of the substrates to be bonded. Position rapidly second substrate and apply a light pressure for several minutes.
- Do not mix with other products.

- Purge and rinse mix head regularly to avoid fouling.
- For any other applying condition, please ask for our technical advice.

Health and Safety

- For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).
- Prior to application it is necessary to read the Safety Data Sheet for information about precautionary measures and safety recommendations.
- For chemicals exempt from compulsory labeling, the relevant precautions should always be observed.

Cleaning

- Please contact us.

Storage Requirements

- Shelf life Teroson® PU U153: 6 months from the date of manufacture.
- If a sufficient agitation is made just before use to eliminate phase separation on top of product, the shelf life can be extended (from 6) to 8 months. To do that, we recommend to place the full closed pail during 5 minutes in a "bi-axial gyroscopic mixer" ("Galileo" for example) prior to use it. After homogenization, best is to use the product within 48 hours.
- Shelf life Teroson® PU U632: 8 months from the date of manufacture.
- Storage temperature Teroson® PU U153: between + 5°C to + 25°C, or + 5°C to + 35°C if a "bi-axial gyroscopic" agitation is made just before use (see above).
- Storage temperature Teroson® PU U632: between + 5°C to + 35°C
- Avoid moisture.
- Ensure a good rotation of stocks, using oldest material first.

Order Information

- Bulk IDH Number
- Please call for available packaging

Henkel AG & Co. KGaA

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Location Heidelberg
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Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$

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REVISION HISTORY