

TEROSON PU 6700

December 2017

PRODUCT DESCRIPTION

Technology	2-component, Polyurethane
Product Type	For bonding customising and body parts
Additional Information	Multipurpose bonder

TEROSON PU 6700 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. TEROSON PU 6700 can be painted with standard commercial car repair refinishing paints.

Application Areas:

TEROSON PU 6700 is used in the automotive industry and in motor vehicle body repair shops mainly for bonding plastic parts (e.g. customising body parts) as well as metal parts. For bonding plastic parts we recommend the use of TEROSON 150.

TECHNICAL DATA

(Typical Test Results)

COMPONENT A

Colour	beige
Density	approx. 1.4 g/cm³

COMPONENT B

Colour	black
Density	approx. 1.7 g/cm³

Mixing ratio A : B

by volume	1 : 1
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MIXTURE (Component A + B)

Colour	dark grey
Potlife (23°C)	approx. 10 min(s).
Tack-free time (23 °C, 50 % rh)	approx. 30 min(s).
Curing time at 23 °C	approx. 6 hr(s).
Layer thickness	3 mm
Solid to hand pressure	
at 23 °C	approx. 2 hr(s).
at 80 °C	approx. 10 min(s).
Shore A hardness	approx. 90
Shear strength	
After 2 d (23 °C, 50 % rh)	approx. 13 MPa
Layer thickness	0.3 mm
Cross head speed	10 mm/min.
Paintability	good
In service temperature	-40 to 80 °C
Short exposure (up to 1 h)	140 °C

PRELIMINARY STATEMENT

Prior to use 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. Metals may either be primed (e.g. cathodic EC) or they should be grinded. Finally the parts should be cleaned with TEROSON VR 20.

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 6700 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. (As described above)

Curing:

Curing occurs at room temperature. To get a faster grindability the parts bonded with TEROSON PU 6700 can be warmed up to 60 to 70 °C for minimum 15 minutes.

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 mechanically.

Storage:

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

CLASSIFICATION:

Please refer to the corresponding **Material Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

Disclaimer

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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Reference 0.1