

# Terokal-transparent

Contact Adhesive  
for PVC-Foils and Artificial Leather

Basis: Nitrile Rubber

Status: 1999-01-04

## Product Description

Terokal-transparent is a solvent containing contact adhesive based on nitrile rubber. Bonds with Terokal-transparent demonstrate high separation resistance and good light-fastness. Due to resistance against contact discoloration the bonding of light colored PVC foil qualities is possible. Terokal-transparent is resistant against water, aging and plasticizers (ester plasticizers).

## Application Areas

Terokal-transparent is used for bonding PVC foils and artificial leather to themselves, as well as to metal (raw, phosphated, primed, stove painted and anodized), wood materials, rigid PVC, ABS, reinforced fibre glass and cardboard.

In the automotive industry and in garages Terokal-transparent is used for bonding PVC finishing and trim items, e. g. head lining, door inner panels or side panels.

## Technical Data

Colour:	yellowish transparent to dull
Odour:	of esters and ketones
Consistency:	liquid, brushable
Density:	approx. 0.9 g/cm <sup>3</sup>
Solid Content:	approx. 28 %
Viscosity:	ca. 2.500 mPa.s (at the day of production)
Equipment:	Brookfield RVT
Spindle:	No. 3
Speed:	10 rpm
Temperature:	20°C
Thinner/Cleaner:	Cleaner-D (max. 20 %)
Consumption:	200–300 g/cm <sup>2</sup> in the case of application to both bonding surfaces, depending on the substrates concerned and method of application
In service temperature range:	-30°C to 80°C
Short exposure (up to 1 hour):	100°C

## 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 labeling, the relevant precautions should always be observed.

## Preparation for bonding

The bonding surfaces must be dry and free of oil, grease, dust and anti-adhesive constituents.

## Adhesive application and bonding

The adhesive is applied uniformly to both bonding surfaces with a brush or spatula.

Depending on application method, layer thickness, temperature, room ventilation and humidity the parts coated with adhesive must be allowed an open time of ca. 10–15 minutes. (The so-called "fin-

ger test" has proven itself a more reliable judgement of the open time than the time data. The adhesive must be dry but slightly tacky.) Taking exact care of the open time is important, for the bonding results can be influenced by a too short as well as a too long waiting period.

When the open time is over the parts must be matched exactly for a later correction is hardly possible. Finally the parts are bonded, using a short but firm pressure, e. g. a hand rolling device. Immediately after bonding a good initial strength is obtained.

## Storage

Frost-sensitive	no
Recommended storage temp.	15°C to 25°C
Shelf-life	12 months

## Packaging

Blisterpack	58 g (PVC Adhesive)	Art.-No. 128.99 W (D/GB/F/NL)
Tin	680 g	Art.-No. 197.16 F (D/GB/F/NL)

## 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.**

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