

TEROSON® RB 3208 PA-25

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Product description

TEROSON® RB 3208 PA-25 provides the following product characteristics:

Technology	Rubber
Product type	Antiflutter adhesive

TEROSON® RB 3208 PA-25 is a heat curing, solvent free, one component sealant, based on rubbers. Special viscosity of the product leads to an excellent sag resistance and makes it wash-off resistant against aqueous cleaning and pretreatment agents. Teroson® RB 3208 PA-25 adheres well to oily steel sheets, aluminum and zinc coated surfaces. The cured material shows a foamy structure, is highly flexible and little dependent of changes in temperature. Teroson® RB 3208 PA-25 chemically cross-links at temperatures above 140°C. Due to the good compatibility to E-coat paint it offers a safe corrosion protection even at boundary areas. Teroson® RB 3208 PA-25 can be painted after curing.

Application areas

TEROSON® RB 3208 PA-25 is used as antiflutter in the automotive body shop and shows good adhesion on oily surfaces. Low hardness prevents read-through effects. It is recommended for use, when wash-off resistance must be obtained without pre-gelling or pre-curing, and where a high degree of elasticity is required over a wide temperature range.

Technical data

Uncured	
Colour	black
Density, g/cm³	approx. 1.5
Consistency	pasty
Viscosity, (DIN 54458), Pa.s	180
Equipment, P/P, mm	25
Frequency, Hz	10
Deformation, %	10
Temperature, °C	45
Cured (25 min. at 175 °C)	
Material data ISO 527-3	
E-Modulus, MPa	approx. 3.5
Poisson ratio	approx. 0.36
Expansion rate, %	approx. 30
Shear strength (DIN EN 1465), MPa	approx. 0.4
Bonding area, mm	25 x 20
Layer thickness, mm	4
Substrate, HDG / EGS, mm	0.75
Temperature resistance	
Short exposure (up to 1 h), °C	200
In service temperature range, °C	- 40 to 80

Directions for use

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. Please also refer to the local safety instructions and contact Henkel for analytical support.

Application

TEROSON® RB 3208 PA-25 is applied from pails or drums using high pressure pumps with a compression ratio minimum 50:1. For the best application the use of volume controlled dispensers is preferred. The heated application pistol can be used either manually or on a fixed jig. More commonly is attached to an automatic application system (robot, CNC). It is recommended to switch off heating during a shutdown of more than 1 hour. The pressure should be switched off after 15 minutes of non-production. Independent heating circuits should have the lowest temperature at the follower plate and the highest temperature at the application nozzle. To ensure an optimal wetting to the substrate Teroson® RB 3208 PA-25 should be applied at elevated temperatures. After assembly of parts, the open time before curing is at least 4 weeks (indoor under storage conditions of maximum 30°C and 70% of humidity). The material is applied directly to oily sheet metal no more than 3 g/m². If required, we will provide you with the additional information on suitable application equipment.

Recommended material temperature

Follower plate and pump, °C	15 to 35
Temperature at nozzle, °C	35 to 60

Curing

TEROSON® RB 3208 PA-25 is cured while passing the EC oven, e.g. 15 minutes at 175°C. The minimum curing cycle is 15 minutes at 170 °C. These are effective metal temperatures.

Cleaning

Fresh, uncured material can be removed with the aid of ethylacetate or gasoline. Cured adhesive can only be removed mechanically.

Classification

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

- Hazards identification
- Transport information
- Regulatory information



Storage

Frost sensitive	No
Recommended storage temperature, °C	5 to 25
Shelf-life (in unopened original packaging), months	6

Disclaimer

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