

# TEROSON RB 3211 VT03

July 2013

## PRODUCT DESCRIPTION

<b>Technology</b>	Synthetic Rubber
<b>Product Type</b>	Antiflutter Adhesive
<b>Additional Information</b>	Expandable Flexible

TEROSON RB 3211 VT03 is a heat curing, solvent free, one component adhesive, based on Rubbers. The high viscosity of the product leads to an excellent sag resistance and makes it wash-off resistant without pregelling or precuring against aqueous cleaning and pretreatment agents. TEROSON RB 3211 VT03 adheres well to oily steel sheets, aluminum and zinc coated surfaces. The material is flexible and little dependent of changes in temperature. TEROSON RB 3211 VT03 chemically cross-links at temperatures above 160 °C. Due to the good compatibility to E-coat paint it offers a safe corrosion protection, even at boundary areas. TEROSON RB 3211 VT03 can be painted after curing.

## APPLICATION AREAS

TEROSON RB 3211 VT03 is used in the automotive body shop and shows good adhesion on oily surfaces. 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. Low hardness prevents read-through effects.

## TECHNICAL DATA

(Typical Test Results)

### Uncured

Colour	black
Density	approx. 1.45 g/cm <sup>3</sup>
Consistency	pasty
Solids	≥ 99 %
Viscosity (Penetration)	218 1/10 mm
Needle	ASTM D5, 5 s, 20 g
Temperature	20 °C
Viscosity (DIN 54458)	approx. 300 Pa.s
Equipment	P/P 25 mm
Frequency	10 Hz
Deformation	10 %
Temperature	45 °C

### Cured (30 min. at 180 °C)

Expansion rate	approx. 85 %
Shear strength (DIN 53283)	approx. 0.42 MPa
bonding area	25 x 12 mm
layer thickness	2 mm
substrate	HDG / EGS 0.80 mm

Corrosion resistance

no loss of adhesion,  
no corrosionResistance to aging  
in Cataplasmano loss of adhesion,  
no corrosion

## PRELIMINARY STATEMENT

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.

## APPLICATION

TEROSON RB 3211 VT03 is applied from pails or drums using high pressure pumps with a compression ratio minimum 50:1 and fitted up with following plate. For 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 of heating during a shutdown of more than 1 hour. 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 3211 VT03 should be applied at elevated temperatures. If required, we will provide you with the additional information on suitable application equipment.

### Recommended material temperature:

Follower plate and pump:	25 to 35 °C
Temperature at nozzle:	35 to 60 °C

## CURING

TEROSON RB 3211 VT03 is cured while passing the EC oven, e.g. 15 minutes at 180 °C. Minimum curing conditions are 15 minutes at 175 °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.

## STORAGE

Frost sensitive	no
Recommended storage temperature	5 to 25 °C
Shelf life	6 months



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## 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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