

TEROSON® RB 3216

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Product description

TEROSON® RB 3216 provides the following product characteristics:

Technology	Rubber
Product type	Antiflutter adhesive
Application	Adhesive and sealant

TEROSON® RB 3216 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 3216 adheres well to oily steel sheets, aluminum and zinc coated surfaces. The material is flexible and little dependent of changes in temperature. TEROSON® RB 3216 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 3216 can be painted after curing.

Application areas:

TEROSON® RB 3216 is used as antiflutter in the automotive body shop and shows good adhesion on oily surfaces. It is specially designed as stiff antiflutter material to bond parts like engine hoods or trunk lids. 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	
Color	black
Density, g/cm³	approx. 1.5
Consistency	pasty
Solids, %	>98
Viscosity, (DIN 54458), Pa.s	350
Equipment	P/P 25 mm
Frequency, Hz	10
Deformation, %	10
Temperature, °C	45
Sag resistance	
10 min at 23 °C	no sagging
30 min at 180 °C	no sagging
Cured (25 min. at 175 °C)	
Expansion rate, %	approx. 10

Shear strength, (DIN EN 1465), MPa	> 1.4
Bonding area, mm	25 x 20
Layer thickness, mm	2
Substrate	HDG / EGS 0.75 mm
Shore A hardness, (DIN 53505)	approx. 60
Temperature resistance, °C	
short exposure (up to 1h)	200
In service temperature range, °C	-40 to 80
Glass transition temperature, (Tg), °C	-17
DMTA 10 Hz, 2 K/min	

Directions for use

Preliminary statement:

Prior to use it is necessary to read the **Material 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 3216 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 3216 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	25 to 35
Temperature at nozzle, °C	35 to 60

Curing:

TEROSON® RB 3216 is cured while passing the EC oven, e.g. 25 min at 175°C. The minimum curing cycle is 25 min 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 **Material Safety Data Sheets** for details on:

- Transport Regulations**
- Hazardous Information**
- Safety Regulations**

Storage:

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

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