

TEROSON RB 3245

June 2023

PRODUCT DESCRIPTION

TEROSON RB 3245 provides the following product characteristics:

Technology	Rubber
Product type	Spot-weldable mastic
Cure	Heat cure
Additional information	Expandable Solvent-free

TEROSON RB 3245 is a solvent free, reactive metal to metal adhesive based on rubber. The product can be pumped at room temperature using high pressure pumps. TEROSON RB 3245 chemically cross-links at temperature above 155°C. The cured material is flexible. TEROSON RB 3245 adheres well to oily steel sheets. In general, the sealer is wash off resistant without pregelling or precuring against aqueous cleaning and pretreating agents used on the production line of the automotive industry.

Application areas

TEROSON RB 3245 was specially developed as a mastic antilflutter sealant, used for filling clearances between steel plates and for reinforcing the rigidity of steel plates against vibrations. In automobiles, TEROSON RB 3245 is used between skin panel and stiffener of hood (Bonnet or Doors). It can also be used as spot-weld sealer. TEROSON RB 3245 is recommended for use when ovens or induction equipment cannot be used for pregelling or precuring to reach wash-off resistance, and where, a high degree of elasticity is required over a wide temperature range.

Technical data

(Typical test results)

Color	Yellow
Consistency	Paste
Specific gravity	1.4 ± 0.1
Solids content, %	>95
Viscosity, Brookfield - 20 °C, mPa·s (cP) Spindle 7, speed 2 rpm	20,000 - 35,000
Sag resistance	Good
Corrosion resistance	Good
In service temperature range, °C	-40 to 80
Temperature resistance, °C	200 (short exposure up to 1 hr)
Expansion rate, %	~50

GENERAL INFORMATION

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.

Directions for use

TEROSON RB 3245 should be left in its original packaging until ready to use. The patch is applied manually by removing the release paper and applying the patch over the desired area. Hand pressure is applied over the entire area of the patch to insure good contact with the substrate.

Application

TEROSON RB 3245 is applied from pails and drums with high-pressure pumps having a compression ratio of 55:1 minimum. The material is applied to oily steel sheet. The application pistol can be used either manually, on a fixed basis, or attached to an automatic application system (robot, CNC). The applicator nozzle may be round, triangular or rectangular, according to individual requirements. If required, we will provide you with the necessary information on suitable application equipment.

Storage:

Frost-sensitive	no
Recommended storage temperature, °C	10 - 30
Shelf-life, months	3

Classification:

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

Transport Regulations
Hazardous Information
Safety Regulations

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