

## TEROSON PU 9225 SF

October 2017

### PRODUCT DESCRIPTION

<b>Technology</b>	Polyurethane
<b>Product Type</b>	For the repair of plastic parts
<b>Additional Information</b>	2-Component

TEROSON PU 9225 SF is a polyurethane based two-component adhesive which cures at room temperature. For accelerated curing it is recommended to increase the temperature up to 60 to 70 °C. The product is supplied in a convenient twin cartridge and is rapid-curing. TEROSON PU 9225 SF can be painted with standard commercial car repair refinishing paints. When applying TEROSON PU 9225 SF to plastics the use of an approved Henkel primer is absolutely necessary. Detailed information see directions of use.

#### Application Areas:

TEROSON PU 9225 SF is used for repair of bumpers, trim and body parts made of plastic e.g. PP / EPDM, SMC, PC, PA, ABS, and PUR.

### TECHNICAL DATA

(Typical Test Results)

#### COMPONENT A

Colour yellow  
Density approx. 1.6 g/cm<sup>3</sup>

#### COMPONENT B

Colour black  
Density approx. 1.7 g/cm<sup>3</sup>

#### Mixing ratio A : B

by volume 1 : 1

#### MIXTURE (Component A + B)

Colour dark grey  
Potlife (25 g, 23 °C) approx. 2 min(s)  
Tack-free time (23 °C, 50 % rh) approx. 6 min(s).  
Curing time at 23 °C approx. 1.5 hr(s).  
Layer thickness 3 mm  
Shore A hardness approx. 90  
Grindability good  
Shear strength  
After 2 d (23 °C, 50 % rh) approx. 13 MPa  
Layer thickness 1 mm  
Cross head speed 10 mm/min.  
Paintability good

### 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.

### DIRECTIONS OF USE

#### Pretreatment:

The parts to be bonded must be free from oil, grease, moisture, dirt and release agents. Pre-cleaning with a high pressure injection cleaner is recommended. After drying the parts should be cleaned and pretreated with TEROSON VR 20. Damaged plastic parts have to be sanded on the face side with a narrow belt sander (grit P 80 to 120) to grind a V-groove (1 to 2 cm). Finally the sanded parts should be cleaned and pretreated with TEROSON VR 20. When applying TEROSON PU 9225 SF to plastics the use of primer TEROSON 150 in a thin layer is necessary. Evaporation time is approx. 10 minutes.

#### Application:

Insert the cartridge into a suitable application gun. Apply pressure to the cartridge(s) to ensure a simultaneous and homogeneous flow of both components.

Thereafter, attach the static mixer and cut the tip to provide for the desired bead size.

Discard the first 2 cm of extruded adhesive bead.

TEROSON PU 9225 SF is applied directly to the substrates.

Any excess material should be removed immediately after application.

If material is left in the cartridge leave the static mixer attached.

For further use of the product, simply remove the mixer and install a new one.

In case of plastic repair the use of woven fibreglass mat is recommended for reinforcing.

#### Reinforcing

In the case of simple cracks TEROSON PU 9225 SF can be applied in one step to both, the face side and the rear side. For more difficult damages, the adhesive should be applied to both sides separately. Start with two continuous beads on the rear side and place them to both sides of the damaged area (bond with minimum 100 mm). For large damages e.g. holes, it is recommended to reinforce the complete damaged area with woven fibre glass mat by incorporating the mat in the beads. Reinforce initial crack areas with woven glass fibre mat in the same way. Then apply TEROSON PU 9225 SF on top of the reinforced matting and smooth the surface. Ensure that the adhesive is pressed through the crack and the fibre glass mat to the front side to guarantee a reliable bonding. During applying TEROSON PU 9225 SF, keep the mixer tip within the material to avoid air inclusions. Apply an excess of TEROSON PU 9225 SF in the same way to the front side.

#### Curing:

Curing occurs at room temperature. For accelerated curing it is recommended to use a heat source. To get a faster grindability the parts bonded with TEROSON PU 9225 SF can be warmed up to 60 to 70 °C for minimum 3 to 4 minutes.

## Pretreatment for finish

After curing of the material these following steps are necessary:

Sanding and cleaning and pretreating (P150/ P240, TEROSON VR 20); priming (TEROSON 150); Further treatment e.g. filling, painting has to be carried out according to paint manufacturers directions for painting plastics.

## Cleaning:

Freshly applied and uncured material should be removed with a dry cloth and then cleaned off with a suitable solvent. Cured adhesive can only be removed with a machine.

## Storage

Frost sensitive	no
Recommended storage temperature	10 to 25 °C
Shelf life	12 months

## Classification

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

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

## 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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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Reference 0.1