



Teromix 6700

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PRODUCT DESCRIPTION

Teromix 6700 provides the following product characteristics:

Technology	Polyurethane
Product Type	PU Adhesive
Cure	Room temperature cure
Components	Two-component
Application	Assembly
Appearance (Component A)	Beige
Appearance (Component B)	Black
Appearance (Mixture)	Dark grey

Teromix 6700 is a two-component adhesive based on polyurethane which cures at room temperature.

By increasing the temperature (e.g. IR radiator), curing can be accelerated.

The product is supplied in a convenient twin cartridge and is rapid curing.

Teromix 6700 can be painted with commercial car paints.

Application Areas:

Teromix 6700 is used in motor vehicle body repair shops for bonding body parts.

Examples of possible applications include:

- antiflutter/stiffening (motor hood with strut, roof skin and framing), wing and wheel house
- bonding of plastic components such as glass fibre reinforced duromers (SMC, BMC/ZMC) as well as onto metals
- corrosion protection on hem flange joints

TECHNICAL DATA

Component A

Density, g/cm³: approx. 1.4

Solids (3h at 100°C), %: >98

Component B

Density, g/cm³: approx. 1.7

Solids (3h at 100°C), %: >98

Mixture (Component A+B)

Mixing ratio (A : B),

by volume:

Pot life (100g, 23°C), min.: approx. 10

Tack-free time, min.: approx. 30

Solid to hand pressure:

at 23°C: 2 hours

at 80°C: 10 minutes

Curing time 23°C, h: approx. 6 h
(85% of final strength)

Shore-A-hardness: approx. 90

Tensile shear strength (measured after 2 d at 23°C), MPa: approx. 13

Layer thickness, mm.: 1

Cross head speed, mm/min.: 100

Paint compatibility: can be painted

In service temperature range, °C: -40 to 80

DIRECTIONS OF USE

Preliminary statement:

Prior to application 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.

Pre-Treatment:

The substrates must be clean, dry, oil and grease free.

One proven method of preparing the bonding faces of plastics is mechanical roughening of the surfaces (brushing, abrasive rubbing, sandblasting). Such mechanical treatment removes adhesion-inhibiting surface layers (e.g. release agents). Metals may either be primed (e.g. cathodic EC, two-component epoxy resin primer) or they should be grinded.

Application:

Teromix 6700 component A and B can be mixed by using a static mixer element. Depending on the desired process volume the suitable mixer has to be found. A dynamic mixing is also suitable. The application could be done manually and automated.

On request, we will provide you with the needed information on suitable application equipment.

Recommended material temperature:

-Follower plate, pump: >15°C

-Hoses, dosers and nozzle: 20 to 35°C

By increasing application temperature one can shorten the necessary time to reach initial strength. If production stops exceeds the products open time, purging of the static mixer is imperative.

The Teromix system:

For application in the automotive repair business the Teromix system would provide a solution. The system consists of a Teromix hand gun, the efficient Teromix 6700 double cartridge and a mixer nozzle (static mixer). Precise instructions are included with every pack.

Applying Teromix by using the "Universal Cartridge 250ml":

Application out of the "Universal Cartridge" is only possible by using pistols with a plumper (no pistonless pneumatic guns) otherwise the correct mixing ratio of both components is not guaranteed. Before mounting the static mixer, 2 cm of both components should be pressed out of the cartridge. This ensures to a filling of the static mixer with the sample ratio of adhesive.

If not all the cartridges contents are used, a new mixer nozzle will be used if the same cartridge is used again.

Curing:

The bonded joint can be worked mechanically after 2 hours at room temperature; a waiting period of 10 minutes is sufficient if an infrared radiator is used. The infrared radiator (max. 80°C object temperature) should be placed at a distance of approx. 30 cm from the bond. The cured adhesive could pass the paint - ovens used in the automotive industry.

Cleaning:

Fresh, non-cured material (e.g. for cleaning tools, cleaning contaminations on the substrates etc.) may first be removed dry and then cleaned off with suitable solvent (e.g. acetone, ethyl acetate, Cleaner A or D). Cured adhesive can only be removed mechanically.

General remarks:

Joints may become visible if repairs are performed on section of panels.

The data above especially the recommendations for application and use of our products is based on our knowledge and experience. Due to the different materials and conditions of application which are beyond our knowledge and control we strongly recommend carrying out sufficient tests in order to ensure that our products are suitable for the intended process and applications. Expect for wilful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

STORAGE:**Component A:**

Frost-Sensitive No
Recommended Storage Temperature, °C 10 to 25

Cartridges:

Shelf-life (in unopened original packaging), 12 months

Pails:

Shelf-life (in unopened original packaging), 9 months

Component B:

Frost-Sensitive No
Recommended Storage Temperature, °C 10 to 25

Cartridges:

Shelf-life (in unopened original packaging), 12 months

Pails:

Shelf-life (in unopened original packaging), 6 months

ADDITIONAL INFORMATION**Disclaimer:**

The Information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.

Reference 0.0