

# Technical data sheet



Product: 6700

Manufacturer: HENKEL KGAA

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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## TEROSON PU 6700 ME

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# TEROSON PU 6700 ME

October 2013

## Micro Emission

### PRODUCT DESCRIPTION

<b>Technology</b>	Polyurethane, Micro Emission
<b>Product Type</b>	For bonding customising and body parts
<b>Additional Information</b>	2-Component

TEROSON PU 6700 ME 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. TEROSON PU 6700 ME can be painted with normal commercial car repair refinishing paints.

### APPLICATION AREAS

TEROSON PU 6700 ME is used in the automotive industry and in motor vehicle body repair shops mainly for bonding customising body parts.

### TECHNICAL DATA (Typical Test Results)

#### COMPONENT A

Colour	grey
Density	approx. 1.6 g/cm³

#### COMPONENT B

Colour	white
Density	approx. 1.3 g/cm³

#### Mixing ratio A : B

By volume	1 : 1
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#### MIXTURE (Component A + B)

Colour	grey
Potlife (25 g, 23 °C)	approx. 5 min(s)
Tack-free time (23 °C, 50 % rh)	approx. 40 min(s).
Curing time at 23 °C	approx. 5 hr(s).
Layer thickness	3 mm
Solid to hand pressure	
at 23 °C	approx. 2 hr(s).
at 80 °C	approx. 10 min(s).
Shore A hardness	approx. 95
Shear strength	
After 2 d (23 °C, 50 % rh)	approx. 10 MPa
Layer thickness	0.3 mm
Cross head speed	10 mm/min.
Paintability	good
In service temperature	-40 to 80 °C

## 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.

## DIRECTIONS OF USE

### Pretreatment

The parts to be bonded must be free from oil, grease, moisture, dirt and release agents. Metals may either be primed (e.g. cathodic EC) or they should be grinded. Finally the sanded parts should be cleaned with Teroson FL+.

### Application

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 6700 ME 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.

### Curing

Curing occurs at room temperature. For accelerated curing it is recommended to warm up TEROSON PU 6700 ME to 60 to 70 °C for minimum 15 minutes.

### 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 the use of a machine.

## STORAGE

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

**TEROSON PU 6700 ME**

October 2013

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