Technical Data Sheet

TEROSON® PU 9225

October 2017

Product description

TEROSON® PU 9225 provides the following product characteristics:

Technology	Polyurethane
Product type	For the repair of plastic parts
Additional information	2-Component

TEROSON® PU 9225 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 9225 can be painted with standard commercial car repair refinishing paints. When applying TEROSON® PU 9225 to plastics the use of an approved Henkel primer is absolutely necessary. Detailed information see directions of use.

Application areas

TEROSON® PU 9225 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	~1.4 g/cm³
Solids	>98%
Component B	
Colour	black
Density	~1.7 g/cm³
Solids	>98%
Mixing Ratio A:B, by volume	1 : 1

Mixture (Component A + B)	
Colour	dark grey
Potlife (23°C)	~10 min(s).
Tack-free time (23 °C, 50% rh)	~30 min(s).
Curing time at 23 °C	~5 hr(s).
Layer thickness	3 mm
Solid to hand pressure	
at 23 °C	~2 hr(s).
at 80 °C	~30 min(s).
Shore A hardness	~90
Grindability	5 hr(s). at 23 °C 15 min(s). at 60 to 70 °C
Shear strength	
After 2 d (23 °C, 50 % rh)	13 MPa
Layer thickness	0.3 mm
Cross head speed	10 mm/min.
Paintability	good
Application temperature	15 to 30°C
In service temperature	-40 to 80°C

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. Please also refer to the local safety instructions and contact Henkel for analytical support.

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 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 fiberglass mat is recommended for reinforcing,

Curing

Curing occurs at room temperature. To get a faster grindability the parts bonded with TEROSON® PU 9225 can be warmed up to 60 to 70 °C for minimum 15 minutes.

Reinforcing
In case of simple cracks TEROSON® PU 9225 can be applied in one step to rear and front 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 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 , keep the mixer tip within the material to avoid air inclusions. Apply an excess of TEROSON® PU 9225 in the same way to the front side.

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

Storage

Frost sensitive	no
Recommended storage temperature, °C	10 to 25

Classification
Please refer to the corresponding **Safety Data Sheet** for details on:
Hazardous Information
Transport Regulations
Regulatory information

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