

## Teroson SB 2444

February 2015

### PRODUCT DESCRIPTION

Teroson SB 2444 provides the following product characteristics:

<b>Technology</b>	Natural Rubber
Product Type	Solventbased adhesive
<b>Application</b>	Assembly
Appearance	beige

Teroson SB 2444 is a contact adhesive based on Polychloroprene with excellent characteristics for brush and spatula application. It is used for bonding rubber to rubber and rubber to metal. The adhesive demonstrates high initial bonding power and contact ability. The bond is flexible and heat resistant.

### Application Areas:

Teroson SB 2444 is used to bond solid and foam rubber types, as well as soft foam materials (e.g. polyether and polyester foams), felt or sound-deadening materials to rubber, metal (raw, phosphated, stove finished primer and paint, anodized), wood materials, polyester, cardboard, rigid PVC and leather.

Teroson SB 2444 is successfully used in automotive workshops for bonding rubber profiles and mats into vehicles. It is also used for bonding door seals, insulating materials and especially sound-deadening foils and sheets to wood materials or steel.

### TECHNICAL DATA

Density, g/cm <sup>3</sup> :	~0.89
Consistency:	liquid, brushable of solvents
Odour:	
Solids, %:	~30
Viscosity, mPa.s:	~3,000
Equipment:	Brookfield RVT
Spindle, No.:	4
Speed, rpm:	20
Temperature, °C	20
Diluent / Cleaner:	Cleaner-R, Cleaner-D
Consumption, g/m <sup>2</sup> : (depending on substrates)	250 to 300
In service temperature range, °C:	-40 to 80
Short exposure (up to 1 h):	100° C

### 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 bonding surfaces must be dry and free of oil, grease, dust and anti-adhesive constituents. Rubber parts must be free of talcum and other gliding agents.

#### Application:

Stir Teroson SB 2444 before use. The adhesive is then applied uniformly to both bonding surfaces with a brush or spatula (smooth or fine notched).

Depending on application method, layer thickness, temperature, room ventilation and humidity the parts coated with adhesive must be allowed an open time of approx. 5 to 15 minutes. (The so-called "finger test" has proven itself a more reliable judgement of the open time than the time data. The adhesive must be dry but slightly tacky). Taking exact care of the open time is important, for the bonding results can be influenced by a too short as well as too long waiting period.

Match the parts exactly and press them quickly but firmly. One sided application in the case of rubber to sheet metal is possible when Teroson SB 2444 is applied to the rubber, and the parts are bonded in partially wet condition. The prerequisite is that the bonding meets the practical requirements.

Frost-sensitive: conditionally, Teroson SB 2444 tends to gel at temperatures below 5°C, but can be rendered suitable for application by reheating slowly to 20°C with repeated strong stirring.

#### Cleaning:

Adhesive residues/stains can be removed before curing - including application equipment and containers - with Teroson VR 40 or Teroson VR 50 (precheck compatibility with the substrates).

### STORAGE

Recommended Storage Temperature, °C      15 to 25  
Shelf-life (in unopened original packaging), 12 months

## ADDITIONAL INFORMATION

### 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.

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## Reference 0.0