

## Flexible 1-component assembly adhesive for use in metal construction

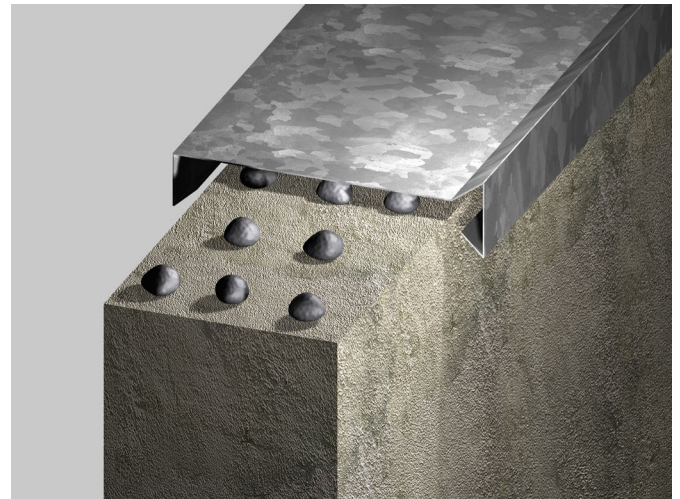
### PROPERTIES

- High initial tack
- Very rapid curing (curing rate: 3-4 mm/day)
- Suitable for indoor and outdoor use
- Good gap-bridging ability
- Weather- and aging-resistant
- Can be painted over and sanded
- Solvent-free
- Good adhesion e.g. to wood, metal, ceramics, stone, concrete, glass, polystyrene and surfaces coated with textured paint
- EMI CODE EC 1 Plus certified
- Product and manufacturer's declarations according to DGNB, LEED, BREEM



### POSSIBLE USES

For the economical bonding of building materials, indoors and outdoors, on wood, metal and mineral surfaces. Special adhesive for use in window and facade installation as well as metal construction. After pretreatment with adhesion promoter TEROSON SB 450, TEROSON AD MS 2100 is particularly suitable for bonding on top of textured paint surfaces. Even difficult applications, e.g. bonding on sealing strip TEROSON FO SD150 M+S, are now possible. Also in this case, the surface of the sealing strip must be pretreated with TEROSON SB 450. Make sure to avoid direct contact between the assembly adhesive and the adhesive compound of the strip.



### SUBSTRATE PREPARATION

The surfaces to be bonded must be clean, dry and free of grease. In order to ensure a strong bond, it may be necessary – depending on the substrate – to mechanically roughen the surface or to apply a primer. After proper pretreatment with TEROSON SB 450, it is possible to use TEROSON AD MS 2100 for bonding on top of many different special surfaces such as textured paint surfaces.

Release agents are often used in metal production. These need to be removed before the application of TEROSON AD MS 2100.

### APPLICATION

TEROSON AD MS 2100 assembly adhesive is a gun-applied, 1-component adhesive that cures on contact with atmospheric moisture. By increasing temperature and air humidity, it is possible to accelerate the processes of curing and skin formation.

Apply the adhesive in strands (recommended strand diameter 6-8 mm, distance between the strands approx. 10 cm) to the workpiece or to the substrate (depending on the load to which the bond will be exposed to).

When bonding on vapor-impermeable substrates like glass, metal or GRP, the strands must be interrupted every 50 cm by 10 cm in order to avoid trapping condensate. Afterwards, press the materials to be bonded together, but make sure – especially with non-absorbent materials – that the strands do not run into each other and coalesce. Ensure proper ventilation between the strands. After assembly, the thickness of the adhesive strand must be > 2 mm. If necessary, use spacers. The application temperature must be within a range of -5 °C to +40 °C. Heavy workpieces or pieces under tension must be supported or fixed if necessary.

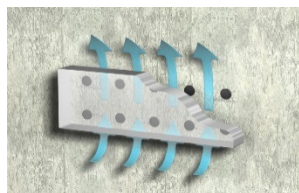
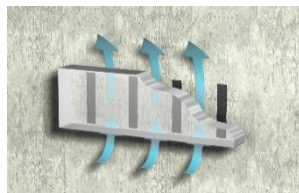
When bonding on powder-coated substrates, please note that there may be adhesion problems caused by paraffins in the surfaces of the new powder paints and textured paints. After pretreatment with TEROSON primer SB 450, however, it is possible to use TEROSON AD MS 2100 for bonding on top of many of these surfaces.

Due to the different application methods and bonding conditions that do not comply with standard climatic conditions, it is always necessary to carry out a trial application (adhesion test). When bonding metal sheets, it may be necessary to sand them down before applying the adhesive. They should always be cleaned and degreased.

## PLEASE NOTE

The position of the workpieces bonded with TEROSON AD MS 2100 assembly adhesive can be adjusted for some minutes. The bonding process must start immediately after application of the adhesive strand. The open time is max. 10 minutes. The curing process can be accelerated by rubbing one of the surfaces to be bonded with a slightly damp cloth (moistened with water).

If the bonded workpiece is exposed to the weather or if moisture is caused by condensation, we recommend applying the adhesive in vertical strands or, with light-weight components, to use the spot application method.



If the adhesive is applied either in spots or vertical strands (see figures), **no moisture** can accumulate underneath and the curing process is accelerated by the so-called "stack effect".

After curing, TEROSON AD MS 2100 can be painted over, especially with water-based acrylic paints.

## Please note:

We recommend carrying out your own tests. Since the structural conditions may vary from site to site, the correct and successful use of our products is beyond our control. In case of questions, please contact us for advice.

## CLEANING

Immediately remove excess adhesive with suitable wipes or tissues, e.g. Tangit cleaning wipes. After curing, the adhesive can only be removed mechanically. TEROSON AD MS 2100 is free of solvents and almost odorless. Where appropriate, the necessary precautions must be taken.

## SUSTAINABLE BUILDING

Product declarations and manufacturer's declarations can be issued upon request for this product.

These correspond to the requirements of common certification and rating systems, such as e.g. DGNB, LEED, BREAM... and are used in the evaluation of sustainable buildings.

## TECHNICAL DATA

### TEROSON AD MS 2100

Material base:	silane-curing polymer
Consistency:	paste-like
Odor:	odorless
Color:	grey, white
Density acc. to DIN 53217-2:	1.5 g/cm <sup>3</sup> (color white)
Shore A hardness:	approx. 56
ISO 868	
Skin formation time:	approx. 10 to 15 min. at +20 °C
Application temperature:	-5 °C to +40 °C
Curing rate:	3-4 mm/24 hrs. at 23 °C / 50 % rel. humidity
Temperature resistance:	-40 °C to +100 °C

### TEROSON SB 450

Product type:	cleaner
Formulation:	1-component alcoholic solution
Odor:	odorless
Color:	colorless, clear
Flash-off time:	10 to 60 min.

## STORAGE / SHELF LIFE

TEROSON AD MS 2100 can be stored for 12 months in the original packaging in a cool and dry place, preferably between +10 °C and +25 °C. Use up opened cans as soon as possible.

TEROSON SB 450 can be stored for 12 months in the original packaging in a cool and dry place, preferably between +10 °C and +25 °C.

## PACKAGING

TEROSON AD MS 2100

Carton with 12 cartridges of 290 ml each

TEROSON SB 450

Carton with 8 bottles of 1000 ml each

## DISPOSAL

Only return the completely emptied packaging to a waste recycling center.

Dispose of hardened product residues as household-type industrial waste or construction site waste.

Non-hardened product residues must be taken to a collection point for hazardous waste.

European Waste Codes (EWC):

TEROSON AD MS 2100 080409

TEROSON SB 450 140603

## CERTIFICATES



Apart from the information given in this Technical Data Sheet it is also important to observe the relevant guidelines and regulations of various organizations and trade associations as well as the applicable national standards. All data given were obtained at an ambient and material temperature of +23°C and 50% relative humidity unless specified otherwise. Please note that in other climatic conditions hardening may be accelerated or delayed and take the resulting consequences into account.

The above information, in particular proposals for the handling, application and use of our products, is based on our knowledge and experience. As materials and conditions may vary with each intended application and thus are beyond our influence, we strongly recommend that in each case the user conducts sufficient tests to ensure our products are suitable for the intended application method and use. Legal liability cannot be accepted, either based on the content of this data sheet or any verbal advice given, unless there is evidence of carelessness or gross negligence on the manufacturer's part.

This Technical Data Sheet supersedes all previous issues. Please refer to our Safety Data Sheet for hazard warnings, safety advice and information on transport labelling.

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