

## TEROSON SB 914

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### PRODUCT DESCRIPTION

TEROSON SB 914 provides the following product characteristics:

<b>Technology</b>	Nitrile Rubber
<b>Product Type</b>	Solventbased adhesive
<b>Application</b>	Assembly
<b>Appearance</b>	light brown

TEROSON SB 914 is a solvent containing contact adhesive based on nitrile rubber. Bonds with TEROSON SB 914 demonstrate high strength and good light-fastness. Due to its non-staining properties the bonding of light colored PVC foil qualities is possible. Only with needlepunched (perforated) qualities, as used in the manufacture of passenger cars, local staining can occur due to presenting through of adhesive through the holes. TEROSON SB 914 demonstrates good aging resistance and is resistant against water and plasticizers (ester plasticizers).

### Application Areas:

TEROSON SB 914 is used for bonding soft PVC foils (artificial leather) to themselves, as well as to metal (bare, phosphated, primed, painted and anodized), wood materials GRP and cardboard. Soft PVC roofing membranes can be bonded with TEROSON SB 914 to steep resp. heavily slanting surfaces, concrete, cement fibre boards, Polyester, rigid PVC, wood materials, metals. In the industrial area TEROSON SB 914 is used as a general purpose adhesive for PVC materials (soft PVC). In the automotive industry and in garages TEROSON SB 914 is used for bonding PVC finishing and trim items.

### TECHNICAL DATA

Density, g/cm <sup>3</sup> :	~0.92
Consistency:	liquid, brushable
Odour:	of solvents
Solids, %:	~28
Viscosity, mPa.s:	~2,300
Equipment:	Brookfield RVT
Spindle, No.:	3
Speed, rpm:	10
Temperature, °C	20
Diluent / Cleaner:	TEROSON VR 40
Consumption, g/m <sup>2</sup> : (depending on substrates)	200 to 300
In service temperature range, °C:	-30 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 914 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 914 is applied to the rubber, and the parts are bonded in partially wet condition. The prerequisite is that the bonding meets the practical requirements.

Due to its consistency TEROSON SB 914 can also be applied by spraying. Depending on the desired appearance of the spray application TEROSON SB 914 may be diluted with up to 20 % of TEROSON VR 40.

### Cleaning:

Adhesive residues/stains can be removed before curing - including application equipment and containers - with Teroson VR 40 (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 1