

Terokal-2444

Abridged Version ALI

Contact Adhesive
for Rubber Profiles and Rubber Mats

Basis: Polychloroprene

Status: 2002-05-16

Product Description

Terokal-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

Materials

Terokal-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.

Fields

Terokal-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

Colour:	bright beige
Odour:	of solvents
Consistency:	liquid, brushable
Density:	approx. 0.89 g/cm ³ (aerosol)
Solid Content:	approx. 30 %
Viscosity:	approx. 3,000 mPa.s (at the day of production')
Equipment:	Brookfield RVT
Spindle:	No. 4
Speed:	20 rpm
Temperature:	20°C
Diluent / Cleaner:	Cleaner-D
Consumption:	250–300 g/cm ² in the case of application to both bonding surfaces, depending on the substrates concerned and method of application
In service temperature range:	-40°C to 80°C
Short exposure (up to 1 h):	100°C

Preliminary remark

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.

Preparation for bonding

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.

Adhesive application and bonding

Stir Terokal-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 ca. 5–15 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 a 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 Terokal-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.

Cleaning

Adhesive residues/stains can be removed before curing – including application equipment and containers – with Cleaner-D (precheck compatibility with the substrates).

Storage

Frost-sensitive	conditionally, Terokal-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
Recommended storage temp.	15°C to 25°C
Shelf-life	12 months

Packaging

Blisterpack	58 g	Art.-No.129.00 X (D/GB/F/NL)
Tin	340 g	Art.-No.197.05 T (D/GB/F/NL)
Tin	670 g	Art.-No.197.06 Y (D/GB/F/NL)

Hazard Indications/

Safety Recommendations/

Transport Regulations

see Safety Data Sheet

Important

The above data, particularly the recommendations for application and use of our products are based on our knowledge and experience. Due to different materials and conditions of application which are beyond our knowledge and control we recommend strongly to carry out sufficient tests in order to ensure that our products are suitable for the intended processes and applications. Except for wilful acts any liability based on such recommendations or any oral advice is hereby expressly excluded.

This Technical Data Sheet supersedes all previous editions.

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