Process Comparison: Traditional Tin Soldering Versus cold rebuilding with TEROSON EP 5020 TR

Traditional Tin Soldering	Cold rebuilding with TEROSON EP 5020 TR
	
Process is limited to steel surfaces	Process works on steel and aluminium surfaces
Applied with an open flame	No open flame needed (safer working process)
Solder paste still contains lead (officially banned). Lead-free solder paste is more difficult to apply and grind.	Lead-free, easy to apply and easy to grind
More process stages: Prior to the repair, all interior parts have to be dismantled from the rear face (adjacent areas) of the repair area After the repair, all parts on the rear face of the repair area have to be protected against corrosion (due to heat damage impairing the original protection)	**Less dismantling work:** Less working time as no dismantling of parts on the reverse of the repair area Original corrosion protection will not be damaged
All dismantled parts have to be re-installed	No additional re-installation work at rear face

BONDERITE M-NT 1455 W are ready-to-use wipes that accelerate your metal pre-treatment process compared to traditional sprayable primers.

APPLICATION
STEP BY STEP

Training courses & online tutorials
www.vehicle-repair-solutions.com

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Metal Repair

Step-by-step work instructions

Metal Repair

Step-by-step work instructions

Specially developed for body rework and to substitute traditional tin soldering

TEROSON EP 5020 TR stands for an innovative fast rebuilding method designed to replace the traditional tin soldering process. It enables you to work on aluminium as well as steel without using an open flame. It is designed for the final rebuilding of the original shape. The lead-free product is compliant with the EU legislation.

TEROSON EP 5020 TR
Tin solder replacement for the rebuilding of car body metal surfaces

- Perfect rebuilding 2C epoxy
- Processing time: approx. 10mins
- Good sag resistance
- No shrinkage
- Excellent for grinding after only 2,5 hours without heat.
- Cold-applied product

Application Info:

- Lead and tin-free alternative to tin soldering
- For rebuilding metal surfaces
- Can be used on steel and aluminum
- Cold rebuilding, no open flame required
- No need for removal of interior parts if welding is not necessary
- Pack size: Cartridge 50ml & 175ml

Additional products

TEROSON VR 10
Pre-treatment of bonding surfaces

TEROSON BATTERY GUN
Application gun for 175ml cartridge. For low to very high viscosity material. Cordless

LOCTITE HAND GUN
Application gun for 50ml cartridge. For low to very high viscosity material. Cordless

Metal Repair – Rebuild

1

SURFACE PREPARATION I
Grind and rebuild the surface mechanically.

2

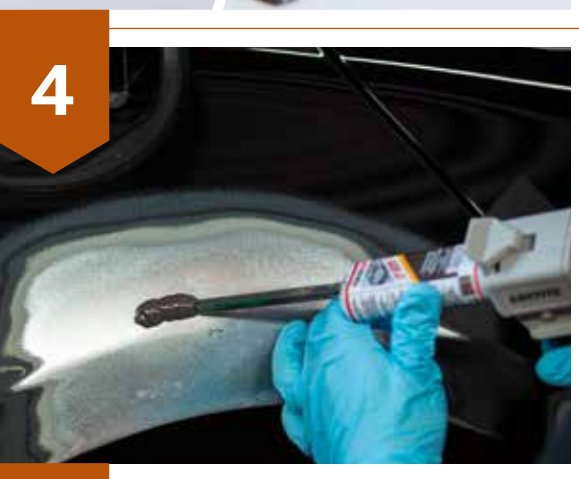
SURFACE PREPARATION II
Clean and pre-treat repair area with TEROSON VR 10 and a lint-free cloth.

3

PREPARATION OF THE CARTRIDGE
Open the TEROSON EP 5020 TR cartridge and squeeze out a small amount of material until both adhesive components run equally.

Apply the mixing nozzle and discard the first 5 cm of the adhesive.

4



APPLICATION
Apply TEROSON EP 5020 TR to the rebuilt area in a way that the area is sufficiently filled with excessive material

(between 3 and max. 5mm).

Keep the nozzle tip inside the material to avoid air bubbles.

5

SMOOTHING
Spread TEROSON EP 5020 TR with a spreader to rebuild the original shape.

6

CURING
TEROSON EP 5020 TR is sandable after ~2.5 hours at 23°C. Warm cure at 60 °C object temperature for 15 minutes is recommended to accelerate curing by infrared heater. Do not use a hot air gun for heating.

7

SANDING
Sand the material with P120 paper to achieve a smooth surface contour and restore original shape.

8

SURFACE PREPARATION III
Remove abrasive dust with a lint free cloth soaked with TEROSON VR 10.

9

Optional:
CORROSION PROTECTION
Before applying bodyfiller: Apply BONDERITE M-NT 1455 W to bare metal as a corrosion protection before applying bodyfiller.

10

BODYFILLER APPLICATION
The use of bodyfiller e.g TEROSON UP 210 is required.

Apply and spread TEROSON UP 210 to re-shape the repair area.

BEFORE PAINT REFINISH
Apply BONDERITE M-NT 1455 W for metal conversion and corrosion protection. Only use as a step before paint work.

Always follow car manufacturer's instructions.

For further product information see technical data sheets and safety data sheets.
Visit www.vehicle-repair-solutions.com

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