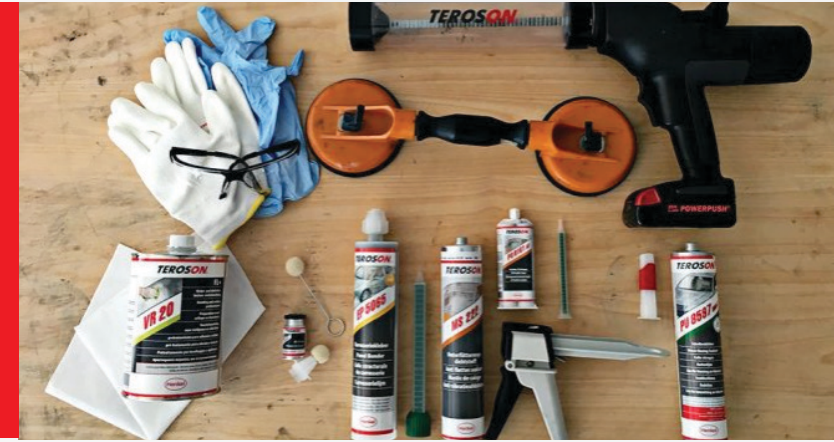


Step-by-Step Guide:

Bonding Steel & Aluminium Parts with TEROSON EP 5055

(e.g. bonding roofs, door skins and rear quarter panels)



1 Cleaning

Bonding surfaces have to be cleaned from oil, grease and dust. Clean the bonding surfaces with cleaner TEROSON VR 20 using a lint-free cloth. Allow prepared surfaces to dry approx. 2 minutes.



2 Preparing the Product

Unscrew coupling ring and remove cap of TEROSON EP 5055 cartridge. Before attaching the static mixer to the cartridge, squeeze out a small amount of material until both adhesive components run equally. This is necessary to achieve a good mix.



3 Preparing the Product

Attach the static mixer and fix it with the coupling ring. Insert the cartridge into the application gun.



4 Apply Material

TEROSON EP 5055, when mixed, is very dark grey in colour (almost black). Discard the first 5 cm of the adhesive.



5 Spread the Material

Apply and spread TEROSON EP 5055 with a spreader or brush. All bare metal areas should be covered with adhesive for corrosion protection.



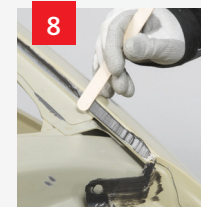
6 Working Time

The open time of the mixed adhesive, at normal room temperature (23°C), is approximately 60 minutes. It may be necessary to change the static mixer if no material has been passed through it for over 30 minutes.



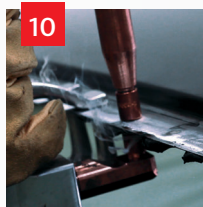
7 Anti flutter application

Apply TEROSON 222 or TEROSON PU 9161 to the strengthening bars in doors and roofs as an antilflutter sealant, this product will not cause panel distortion and dries to a spongy low viscosity sealer to eliminate panel vibration.



8 Cleaning

Remove excess adhesive immediately with a spatula or with a cloth and TEROSON VR 20. Cured adhesive can only be removed mechanically.



10 Assemble

Join and fix the components within the 60 minutes processing time. If spot welding is required, this must be carried out during this initial period. Do not subject bonded parts to stress before final cure.



10 Curing Time

The adhesive cures at room temperature. (Initial strength approx. 4h at 23°C / Final strength approx. 2d at 23°C)
The curing time can be accelerated by heat using common tools like infrared or heating pads. (Final strength 45min at 65°C or 30min at 100°C)
Within the curing phase, avoid movement or stress until the product is fully cured.



11 Painting

The bonded panel can be overcoated once the TEROSON 5055 has cured, in accordance with the automotive coating suppliers requirements.



12 Disposal of TEROSON EP 5055

Cured product and empty cartridges are disposed of as normal waste. Uncured material has to be disposed of as hazardous waste. (see Material Safety Data Sheet for more details)