

## Product Type

Pumpable, high temperature sealant, heat curing, PVC free, polyacrylate plastisol based

## Substrate Type

Electrocoat or clean bare steel

## Application

Clean metal or electrocoat prior to powder coat

## Product Technology

TEROSON AL 6302 (known as TEROSOL 6302) is a heat curing, solvent free sealant based on a polyacrylic plastisol. It can be applied to clean, bare steel or electrocoat and accepts powder paint either cured or wet on wet.

TEROSON AL 6302 (known as TEROSOL 6302) is used in high heat applications (200°C) where resistance to heat degradation and color change is important.

## Typical Properties

Property	Typical Results
Color	White
Odor	Slight, mild
Solids	>99%
Specific Gravity	1.45 ± 0.05
Severs Viscosity 0.104" orifice, 40 psi, 25°C – s/20g	7 – 20 s/20g
Adhesion to Ecoat and bare steel 30 minutes @ 175°F	Excellent
Heat Resistance 1 hour @ 200°C	Excellent
Application Temperature	15°C – 25°C

## Operating Summary

- It is recommended that testing is completed on substrates to be used to validate this material prior to use.
- Deviations from cure cycle may result in deviations from the shear strength which may interfere with material performance.

## General Information

- Shutdown** - For extended shutdown periods, greater than 8 hours, it is recommended that pressure be removed from the system to reduce possibility of caking in lines.
- Material Purge** - Regular purge and cleaning of the application system is recommended, please contact your sales representative for material requirements and instructions.
- As with all materials, it is recommended that to ensure consistent material, this product is used in a First In - First Out

## Equipment

- TEROSON AL 6302 (known as TEROSOL 6302) can be applied with standard piston, gear or rotary pumps. It can also be applied out of cartridge tubes.
- The material is homogeneous and contains no abrasives that will affect pumping equipment.
- This material can be dispensed using a pumping system. This should include a high pressure ratio pump, with a follower plate and flow guns with tips appropriate to the bead size needed. Care should be taken in system design to insure that flow restrictions are minimized. Flow restrictions occur when headers, hoses, and/or nozzles are too small for the application.

## Metal Surface Preparation

- This material has been developed to adhere to metals which have been cleaned, treated, and primed.
- This material will not adhere to untreated metal.
- For best performance, substrate should be free of contamination before material is applied.

## Product Removal

- Fresh, uncured material can be removed with the aid of Isopropyl Alcohol. Large amounts of material can be removed using towels or rags and then cleaned with Isopropyl Alcohol.
- Cured material can only be removed mechanically

## Health and Safety

- For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**
- Prior to application it is necessary to read the Safety Data Sheet for information about precautionary measures and safety recommendations.
- For chemicals exempt from compulsory labeling, the relevant precautions should always be observed.

## Product Control Test Method

- No specific test methods are recommended to be used by customer.
- Additional information on product testing is available upon request.

stock rotation system.

## Storage Requirements

- Store product in the unopened container in a dry location
- **Keep away from heat and direct sunlight.**
- **Store between 5°C and 25°C (41°F and 77°F)**
- **Material is frost sensitive.**
- **Shelf life of product is 365 days.**
- Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

## Waste Disposal

- Refer to MSDS for further information

## Order Information

- Bulk IDH Number **882425**
- Please call for available packaging

**Creation Date** 13 March 2006

13 February

**Revision Date** 2014 **Revision Number** 3

## Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

mm / 25.4 = inches

$\mu\text{m} / 25.4 = \text{mil}$

N x 0.225 = lb

N/mm x 5.71 = lb/in

$\text{N/mm}^2 \times 145 = \text{psi}$

MPa x 145 = psi

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## REVISION HISTORY

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| 03.13.09 | New format   |
| 05.23.13 | Updated storage conditions and temperatures.<br>Updated name due to rebranding. Updated Typical Properties table |
| 02.13.14 | Updated storage temps and shelf life from 90 to 365 days   |