

Teroson SI 65

June 2017

PRODUCT DESCRIPTION

Teroson SI 65 provides the following product characteristics:

Technology	Silicone (Acetoxy)
Product Type	Sealant
Application	Assembly
Appearance	Red

Teroson SI 65 is a high modulus, one-component, high temperature resistant, ready-to-use silicone for sealing and bonding.

APPLICATION AREAS

Teroson SI 65 is recommended for all those applications where standard silicone qualities do not meet temperature requirements.

TECHNICAL DATA

(Typical Test Results)

Density g/cm ³ :	approx. 1.25
Consistency	pasty
Skin formation time*, min:	approx. 20
Cure rate (per 24 h)*, mm:	approx. 2
Shore-A-hardness (DIN 53505):	approx. 30
Modulus at 50 % Elongation (ISO 8339-A), MPa:	approx. 0.5
Elongation at break (ISO 8339-A), %:	approx. 80
Volume change (DIN 52451), %:	max. 5
Application Temperature, °C:	5 to 40
In service temperature range, °C:	-50 to 250
Short exposure (up to 1 h), °C:	300
*ISO 291 Standard climate	23° C, 50 % relative humidity

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.

PRETREATMENT

The substrates must be clean and dry, free from any dust and grease or anything which may be detrimental to correct adhesion of the sealant. Residues of old sealant or other materials as well as mould on the substrate must be removed completely (if necessary use a silicone remover). Degreasing is performed using a pad soaked in solvent (alcohol or white spirit) followed by wiping with a clean cloth. Dust should be removed using oil-free compressed air. To get best sealing results it is recommended to mask edges of the joints with a tape before application of the sealant mass.

APPLICATION

Application from 300 ml cartridges and/or from 570 ml foil cartridges is made with the Teroson Hand or Air Pressure gun. In the case of compressed air application a pressure of 2 to 5 bar is required, depending on nozzle aperture and speed of application. When applying Teroson SI 65 in closed rooms, ensure good ventilation during the curing process.

CLEANING

Uncured or not fully cured Teroson SI 65 can first be removed by a knife or a spatula. The remaining layer can be washed off with Teroson VR 40 or similar products. Fully cured sealant can only be removed mechanically by means of a suitable tool (e.g. sharp blade) or by burning off, for the product is insoluble in all common solvents.

Smoothing

If smoothing of the bead is necessary this has to be done within the skin formation time. Teroson SI 65 can be smoothed with soapy water. Where joint edges have been masked the masking tape has to be removed immediately to avoid tearing of the fresh forming skin.

STORAGE

Frost sensitive:	No
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Henkel AG & Co.KGaA



40191 Düsseldorf, Germany
Phone: +49-211-797-0
www.henkel.com

Recommended storage temperature, °C:	5 to 25
Shelf life (in unopened original packaging), months:	24

ADDITIONAL INFORMATION

Disclaimer

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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40191 Düsseldorf, Germany

Phone: +49-211-797-0

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