

# LOCTITE®

# Teroson

## Solutions for Vehicle Repair & Maintenance



Henkel



# Introduction

## Solutions for all repairs

**With this solution guide you can easily select the best Loctite® and Teroson product from the Henkel portfolio to solve maintenance or repair problems for all types of vehicles: The same products that automotive manufacturers use to build the cars you repair. The same products that are used on race cars around the world.**

### **Find solutions from different starting points:**

- Loctite® and Teroson product categories within the Henkel portfolio
- The application guide section
- A product list including ordering information

### **The Henkel portfolio covers all automotive maintenance and repair needs**

#### **• For Mechanical Repair:**

Henkel's Loctite® brand offers a comprehensive range of products to ensure the reliability of mechanical assemblies. Service technicians rely on the consistent quality and ready availability of these products which have been specially designed to suit the needs of automotive repair professionals.

#### **• For Body and Automotive Glass Repair:**

Henkel's Teroson brand offers a full line of window repair solutions which meet the majority of existing OEM/OES requirements regarding shear modulus, conductivity and radio frequency performance, and achieve extremely fast drive-away times.

#### **• For Body Repair and Protection:**

Henkel has solutions ranging from bonding and sealing to underbody and anti chip protection, plastic repair and sound deadening.

The Henkel offer includes the required application tools and equipment specially designed for applying these products from bottles, cans, cartridges, and barrels.

## Go online and discover more!

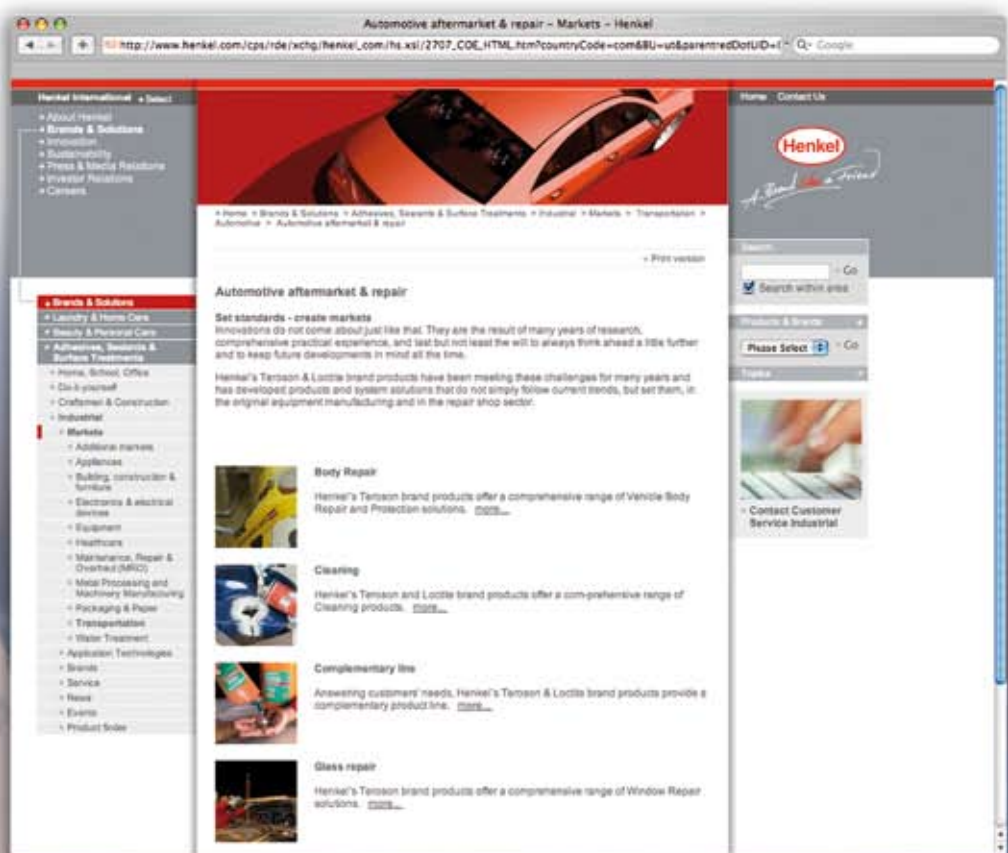
For more information on our products or the Henkel company just visit our website

[www.loctite.com](http://www.loctite.com)

[www.teroson.com](http://www.teroson.com)

and find:

- Detailed product information
- Application case histories
- Online product trainings
- Videos, photos and games
- Professional advice
- Your contact



# Henkel's Dakar proven products

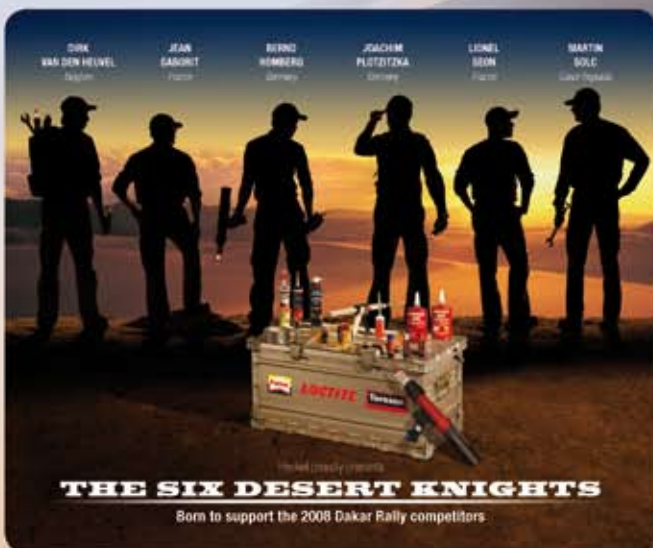
**Henkel, as Official Partner to the Dakar Rally and Dakar Series, provides the competitors not only with its superior products but also with dedicated support and hands-on technical assistance.**

Henkel's Partner status reflects the company's goal of highlighting its competencies as a leading supplier of industrial adhesives and sealants, pushing the limits further in pursuit of reliability, performance and innovation. The event provides an ideal testing arena for new product developments and confirms the superior quality of Henkel products even under the most extreme racing conditions.

## **A true service to the competitors**

Henkel specialists are travelling with the rally. Known as the Teroson and Loctite® „Charlies“ to a number of international rally participants and their mechanics, they provide advice and hands-on support. Over the years, close contacts have developed into a strong relation of mutual trust and understanding, built on the competent service and the high-quality products offered for fast and efficient repairs which have helped many drivers to make it to the finish line.

Many products have earned their „Dakar-proven“ stamp of approval in the previous years' events. Used by almost all the drivers competing on bikes, cars and trucks, Loctite® anaerobic products exemplify those small yet very important items that can make the difference between victory and defeat.



## Superior quality even under the most extreme conditions

During the hardest rally in the world, Henkel products and technicians were highly appreciated – and helped many drivers to reach the finish line!



These are only few examples:

### Threadlocking

BMW and Nissan Cars

**Problem:**  
Loose bolts



**Solution:**

Loctite® 243 Threadlocker

**Benefit:**

- Threaded fasteners are locked against vibration loosening
- Threads are protected against corrosion

### Plastic Repair

KTM, Honda, Yamaha, BMW motorbikes

**Problem:** Cracked, broken plastic shells and fairings



**Solution:**

Plastic repair with **Terokal 9225 (SF)**, **Terokal Plastic Primer** and **Teroson FL Cleaner**

**Benefit:**

- Parts are reliably fixed to withstand extreme challenges in the desert – up to the finish line!

### Direct Glazing

MAN trucks

**Problem:**  
Broken windscreens



**Solution:**

Direct Glazing with **Terostat 8630 2C** – 2 component adhesive

**Benefit:**

- Quick restart into the race  
⇒ Safe drive away time of only five hours!

### Direct Glazing

Landrover Car

**Problem:**  
Broken windscreens



**Solution:**

Direct Glazing with **Terostat 9000 PL** – primerless and isocyanate-free adhesive

**Benefit:**

- Almost no time lag  
⇒ Safe drive away time of only 2 hours!

# Mechanical and Body Repair solutions for all vehicles



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### Threadlocking | Page 10

**Loctite® 248 Stick or Loctite® 243**  
Oil Pan Bolts

### Threadlocking | Page 10

**Loctite® 248 Stick or Loctite® 243**  
Transmission Fluid Pan Bolts

Here are some examples of the wide range of Loctite® product applications for automobile repairs. Most of these applications would also apply to heavy-duty vehicle or motorcycle repairs. Log on to [www.myteroson.com](http://www.myteroson.com) and explore this application chart via our “Virtual Engine”.

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Loctite® 248 Stick or Loctite® 243  
Rear Differential Housing Bolts

## Threadlocking

- Invented by Loctite® to lock and seal threaded fasteners
- Specified by Automotive OEMs
- Work by filling the spaces between threads
- Provide a secure, one-piece assembly that will not loosen under stress

<b>Description</b>	Blue – liquid
<b>Strength</b>	Medium
<b>Size of thread</b>	Up to M36
<b>Temperature resistance</b>	+150 °C

### Practical Hints:

- Clean parts with Loctite® 7063 before applying the adhesive
- If the threadlocker will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)
- If the parts were in contact with aqueous washing solutions or cutting fluids which leave a protective layer on the surface, wash with hot water before use

### Loctite® 243



### Loctite® 243

#### Medium Strength Threadlocker

- Locks and seals bolts, nuts and studs to prevent loosening from vibration
- Allows disassembly with normal tools
- Effective on all types of metal threaded fasteners

#### Applications:

Flywheel bolts, crown wheel bolts, crankshaft nuts and threaded fasteners on covers, oil drain plugs.

Pack sizes	IDH No.
Bottle 10 ml	135279
Bottle 50 ml	135278
Bottle 250 ml	135357

## Loctite® 248



Blue – semi solid

Medium

Up to M50

+150 °C

## Loctite® 271/2701



Red – liquid

High

Up to M20

+150 °C

## Loctite® 268



Red – semi solid

High

Up to M50

+150 °C



2005 Dakar Rally



### Loctite® 248 Stick Medium Strength Threadlocker

- Non-liquid, semi solid stick version, medium strength threadlocker
- For all types of metal threaded fasteners
- Allows disassembly with normal tools
- Certified to ANSI/NSF Standard 61

#### Applications:

Where disassembly is required – machine tools and presses, pumps and compressors, mounting bolts, gear boxes.

### Loctite® 271/2701 High Strength Threadlocker

- For maximum threadlocking strength of bolts, nuts and studs
- For permanently locking assemblies which must not come loose
- Seal fasteners
- Can be disassembled by heating to 300 °C

#### Applications:

Locking studs in gear boxes, cylinder blocks etc.

### Loctite® 268 Stick High Strength Threadlocker

- Non-liquid, semi solid stick, high strength threadlocker
- Prevents vibration loosening of nuts and studs
- Effective on all types of metal threaded fasteners

#### Applications:

Where regular removal for maintenance is not required: suspension bolts, motor transmission and pump mounts, bearing cap bolts and studs.

Pack sizes	IDH No.
Blister card Stick 9g	540498
Stick 19g	540491

Pack sizes	IDH No.
Blister card 3ml	223807
Bottle 10ml	195827
Bottle 50ml	234853

Pack sizes	IDH No.
Blister card Stick 9g	540900
Stick 19g	540907

# Mechanical Repair

## Pipe Sealing / Retaining

### Loctite® Thread Sealants

- Provide an instant, low pressure seal for metal pipes and fittings
- Will not creep, shrink or block systems by shredding

### Loctite® Retaining Compounds

- Bond non-threaded, cylindrical metal assemblies

Description	Paste	Semi solid
Strength	Medium	Low
Size of thread	Up to 3"	Up to 3"
Temperature resistance	+150 °C	+150 °C

### Practical Hints:

- All parts must be clean & dry before sealing – use Loctite® 7063
- If the sealant/retainer will be applied below 5 °C, pre-treat with Loctite® 7240 (Activator)
- If the parts have been in contact with washes or cutting fluids containing nitrites, wash parts with hot water



### Loctite® 577 – Pipe Sealant

- General purpose liquid thread sealant for sealing metal threads
- Suitable for metal threads only
- Instant low pressure seal
- Resistant to fuel, oil, coolants and hydraulic fluids
- Prevents vibration loosening

### Applications:

Ideal for hydraulic and pneumatic circuits. Replaces hemp, pastes, PTFE tapes.

Pack sizes	IDH No.
Accordion 50 ml	229342
Bottle 250 ml	234573



### Loctite® Stick 561 – Pipe Sealant

- Non-liquid, semi solid stick for metal threads only
- Immediate low pressure sealing
- Certified to ANSI/NSF Standard 61

### Applications:

Recommended for all coarse metal threads (hydraulic and pneumatic circuits).

Pack sizes	IDH No.
Stick 19g	540920

## Loctite® 648



Green – liquid

High

Up to 0.15 mm

+175 °C



### Loctite® 648 – Retaining Compound

- For high-strength assemblies
- Fills clearance in repaired parts
- Seals assemblies and prevents fretting corrosion
- Difficult to disassemble with normal tools

#### Applications:

Retaining of splined shafts, bearings, steering system components, gearings and all cylindrical parts, e.g. sleeves, bushes and inserts, etc.

Pack sizes	IDH No.
Bottle 50 ml	135525

## Loctite® 668



Green – Semi solid

Medium

Up to 0.15 mm

+ 150 °C



### Loctite® 668 – Retaining Compound

- Non-liquid, semi solid stick for retaining parts
- Carries loads and eliminates fretting
- Bonds cylindrical assemblies (slip-, press- and shrink fit)
- Suitable where product application access is difficult

#### Applications:

Overhead, under or around machinery – on components that cannot be moved

Pack sizes	IDH No.
Blister card Stick 9 g	705002
Stick 19 g	705053

## Loctite® 660



Silver – paste

High

Up to 0.5 mm (with activator)

+150 °C



### Loctite® 660 – Quick Metal

- For easy restoration of worn shafts, bushes and bearings
- Prevents corrosion of mated surfaces
- Specially suited for filling large gaps
- Ideal for restoring worn fits of parallel keys, splines and tapers

#### Applications:

Filling gaps between worn metal parts, e.g. shafts, housings, keys, bearings, bushes and on drive train components, e.g. camshaft drives, clutches, flywheels and crankshafts.

Pack sizes	IDH No.
Accordion 50 ml	229232

# Mechanical Repair

## Gasketing

- Meet a broad range of complex gasketing and sealing needs
- Fill all voids with excellent fluid and temperature resistances
- Parts can be disassembled easily even after extended service

### Loctite® 510



### Loctite® 518



### Loctite® 548



Flange Type	Rigid	Rigid	Rigid
Gap	Up to 0.25 mm	Up to 0.25 mm	Up to 0.2 mm
Temperature resistance	Up to 200 °C	Up to 150 °C	Up to 150 °C
Oil resistance	Excellent	Excellent	Good
Water / glycol resistance	Excellent	Excellent	Good

#### Practical Hints:

- If there are traces of old gasket left on the parts to be sealed, clean with Loctite® 7200 gasket remover
- All parts must be clean and dry before sealing – use Loctite® 7063
- Anaerobic products cure between metal surfaces in the absence of air



#### Loctite® 510 – Flange Sealant

- High temperature resistant flange gasket
- For metal flanges
- Adapts to flange surfaces and scratches up to 0.25 mm
- Increase torque capacity of assembled flanges

#### Applications:

For sealing rigid flange faces on transmissions and engine casings. Seals instantly against low pressures.

Pack sizes	IDH No.
Accordion 50 ml	142608
Bottle 250 ml	135477
Cartridge 300 ml	135325

#### Loctite® 518 – Flange Sealant

- Medium strength anaerobic flange gasket
- For metal flanges
- Adapts to flange surfaces and scratches up to 0.25 mm
- Gel-type consistency
- Ideal for overhead application and for vertical faces (no dripping)
- Seals instantly against low pressures

#### Applications:

For sealing rigid flange faces, e.g. water pump flanges, engine, differential and timing covers.

Pack sizes	IDH No.
Syringe 25 ml	142286
Syringe 50 ml	229875
Cartridge 300 ml	435566

#### Loctite® 548 Stick Flange Sealant

- Non-liquid, semi solid flange sealant stick
- For metal flanges only

#### Applications:

Air compressors, gearboxes, engine casings.

Pack sizes	IDH No.
Blister card Stick 9 g	705097
Stick 18 g	704920

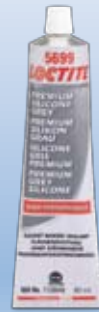
## Loctite® 5926



## Loctite® 5910



## Loctite® 5699



## Loctite® 5920



Flexible

Flexible

Flexible

Flexible

Up to 1 mm

Up to 1 mm

Up to 1 mm

Up to 1 mm

-55 °C to 250 °C (intermittent)

-55 °C to 250 °C (intermittent)

-55 °C to 250 °C (intermittent)

-55 °C to 350 °C (intermittent)

Good

Excellent

Very good

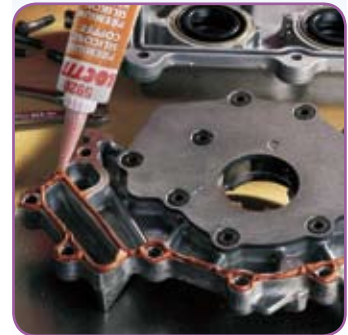
Very good

Good

Good

Excellent

Good



### Loctite® 5926 Silicone Blue Gasket Maker / Sealant

- Multi purpose flexible silicone sealant
- For flanges of any size or shape
- Can be used for metal, plastic and painted parts

#### Typical uses:

Oil sump, valve cover, inlet manifold, timing chain cover, transmission cover, transmission pan, differential cover, water pump, thermostat etc.

### Loctite® 5910 Premium Silicone Black Gasket Maker / Sealant

- For flanges with permanent oil contact
- Can be used for metal, plastic and painted parts
- Low odour, non corrosive

#### Typical uses:

Oil sump, valve cover, inlet manifold, timing chain cover, transmission cover, differential cover, etc.

### Loctite® 5699 Premium Silicone Grey Gasket Maker / Sealant

- For flanges with permanent water / glycol contact
- Can be used for metal, plastic and painted parts
- Low odour, non corrosive

#### Typical uses:

Water pump, thermostat, valve cover, inlet manifold, transmission pan, differential cover, etc.

### Loctite® 5920 Premium Silicone Copper Gasket Maker / Sealant

- For flanges exposed to high temperatures and high performance engines
- Can be used for metal, plastic and painted parts
- Low odour, non corrosive

#### Typical uses:

Turbo and exhaust systems, oil sump, valve cover, inlet manifold, timing chain cover, differential cover.

#### Pack sizes IDH No.

Blister card 40 ml	1123349
Tube 100 ml	1126639
Cartridge 310 ml	233862

#### Pack sizes IDH No.

Blister card 40 ml	1133305
Tube 80 ml	1126633
Quick Gasket 200 ml	728771
Cartridge 300 ml	142491

#### Pack sizes IDH No.

Blister card 40 ml	1124088
Tube 80 ml	1126648
Cartridge 300 ml	142480

#### Pack sizes IDH No.

Blister card 40 ml	1124086
Tube 80 ml	1126645
Cartridge 311 g	235479

## Gasketing

### Loctite® O-RING KIT



**Flange Type**

n.a.

**Cure Method**

n.a.

**Temperature Resistance**

n.a.

**Oil Resistance**

n.a.

**Water / Glycol Resistance**

n.a.

**Practical Hints:**

- If there are traces of old gasket left on the parts to be sealed, clean with Loctite® 7200 Gasket Remover
- All parts must be clean and dry before sealing – use Loctite® 7063
- Anaerobic products cure between metal surfaces in the absence of air



**Loctite® O-Ring Kit**

- Kit for making replacement O-rings on the spot
- Easy to handle
- Ready for use in just a few seconds
- The bond is as strong as the rubber itself

**Kit contains:**

5 different sizes of nitrile rubber cord, splicing jig, safety knife, 20 g of Loctite® 406 Adhesive.



**Pack sizes**

**IDH No.**

O-Ring Kit 1 bottle

480166

## Loctite® 534



Rigid or Flexible

Anaerobic

150 °C

Good

Good

## Loctite® 5922



Rigid or flexible

Drying

Up to 200 °C

Good

Good

## Loctite® 5923



Rigid or flexible

Drying

Up to 200 °C

Good

Good



### Loctite® 534 Stick – Gasket Positioner

- Gasket Positioner adhesive/sealant
- Hold-in-place cut gaskets

#### Applications:

Valve covers, fuel pumps, carburetor, manifold gaskets.

### Loctite® 5922 – Gasket Dresser N°3

- Improves the sealing performance of old and new pre-cut gaskets (paper, cork, felt etc.)
- Slow curing paste
- Sets to a permanently flexible, non-hardening film
- Suitable for parts which require disassembly

#### Applications:

On engine and gearbox. For sealing/dressing flanges with old and new pre-cut compression gaskets. Ideal for part assembly after repairs.

### Loctite® 5923

- For flange sealing or dressing pre-cut compression gaskets
- Ideal for part assembly after repairs
- Low-viscosity product
- Comes in brush-top can

#### Applications:

On engine and gearbox. For sealing / dressing flanges with old and new pre-cut compression gaskets.

**Pack sizes**                      **IDH No.**

Blister card Stick 9g            705070

Stick 19g                            705075

**Pack sizes**                      **IDH No.**

Tube (blister card) 60 ml      142274

**Pack sizes**                      **IDH No.**

Can 117 ml                         233849

Can 450 ml                        149302

# Mechanical Repair

## Cleaning

- Clean components prior to using Loctite® adhesives / sealants
- Clean and degrease work areas and parts
- Remove cured sealant residue

<b>Description</b>	Cleaner	Cleaner
<b>Base</b>	Solvent	Solvent
<b>Appearance</b>	Colourless, clear liquid	Colourless, clear liquid

### Brake & Clutch Cleaner



Cleaner

Solvent

Colourless, clear liquid



#### Teroson / Loctite® Brake and Clutch Cleaner

- Cleans and degreases brake, clutch and transmission components
- Quick and efficient
- Removes adhesive and sealant residues
- Leaves no residue

#### Applications:

On brakes, clutch and transmission flanges and for removing grease, adhesive and sealant residues from engine, carburetor and solidified lubricants from hinges and linkages.

Pack sizes	IDH No.
Spray 500 ml	232315
Can 10l	840759
Can 50l	840771

### Loctite® 7063



Cleaner

Solvent

Colourless, clear liquid



#### Loctite® 7063 – Cleaner and Degreaser

- General-purpose product for cleaning and degreasing of surfaces before Loctite® adhesive product applications
- Evaporates quickly
- Leaves no residue

#### Applications:

Removes oil, grease and dirt. Ideal for use prior to adhesive bonding and sealing applications.

Pack sizes	IDH No.
Aerosol 400 ml	88344
Can 10l	149293

## Loctite® 7840



Cleaner

Water

Blue liquid

## Loctite® 7200



Gasket remover

Solvent

Amber liquid

## Loctite® 7100



Leak detector

Aqueous

Colourless liquid

## Loctite® 7039



Contact cleaner

Solvent

Colourless liquid



### Loctite® 7840 – Cleaner and Degreaser

- General-purpose cleaner and degreaser
- Can be diluted with water at a ratio of 1:4 to 1:128 (depending on application)
- Can be applied using high-pressure cleaners
- Biodegradable

#### Applications:

Use for cleaning parts before repair work, for engine cleaning, for shop floors and walls.



### Loctite® 7200 – Gasket Remover

- Removes baked on gasket and sealant residues, dried oil, tar, carbon deposits and paint
- Easy removal prevents damage to components
- Softens cured sealants and traditional gasket residue in 10–15 minutes
- Reduces need for scraping

#### Applications:

Recommended for metal sealing faces on engine, transmission, carburetor, water and fuel pumps, rear axle, etc.



### Loctite® 7100 – Leak Detector

- Allows easy detection of suspected leaks, mainly in gas or pneumatic installations except pure oxygen
- Liquid based product, which starts producing bubbles at areas where a leak is present

#### Applications:

Pipe connection, Leak detection, Seal check after repair.



### Loctite® 7039 – Contact Cleaner Spray

- For cleaning electrical contacts
- Does not affect insulating varnishes
- Displaces moisture or other contaminants
- Silicone-free

#### Applications:

For cleaning contacts, relays, fuses and terminals.

Pack sizes	IDH No.
Spray 750 ml	235330
Can 5 l	235338
Can 20 l	235341

Pack sizes	IDH No.
Aerosol 400 ml	377058

Pack sizes	IDH No.
Aerosol 400 ml	250000

Pack sizes	IDH No.
Aerosol 400 ml	303145

# Mechanical Repair

## Lubrication

- Protect metal parts from corrosion, galling, seizing
- Penetrate and free corroded assemblies
- Prevent wear and cold welding during assembly and operation

### MO Universal



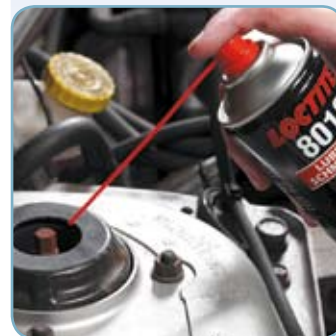
### Loctite® 8018



### Loctite® 8040



Description	Oil	Mineral oil	Mineral oil
Appearance	Colourless	Colourless	Amber
Viscosity	Liquid	Liquid	Liquid
Temperature Range	n.a.	n.a.	n.a.



#### Teroson MO Universal Lubricant and Contact Spray

- Multi-use product
- Stops moving parts from squeaking
- Protects from corrosion
- Protects ignition systems from moisture and helps engines to start readily
- Cleans and preserves metals

#### Applications:

Frees seized or corroded parts, e.g. bolts, nuts, hinges.

#### Loctite® 8018 – Rust Remover

- Multi purpose Solvo Rust
- Clear mineral oil
- Immediate penetration
- Freed parts remain lubricated and protected from corrosion

#### Applications:

Frees rusted and seized bolts, screw fittings and general metal components.

#### Loctite® 8040 – Freeze & Release

- Releases seized and corroded parts by shock freezing (-43 °C)
- Thermal contraction of the parts allows penetration of the lubricating ingredient
- Released parts remain lubricated and protected from corrosion

#### Applications:

Seized and corroded assemblies of threaded and cylindrical parts across all industries.

Pack sizes	IDH No.
Spray 400 ml	232429
Can 4.5l	841026

Pack sizes	IDH No.
Aerosol 400 ml	458647

Pack sizes	IDH No.
Aerosol 400 ml	760225

## Loctite® 8021



Silicone oil

Colourless

Liquid

-30 °C to +150 °C

## Loctite® 8101



Synthetic grease

Amber

High tack paste

-25 °C to +170 °C

## Loctite® 8060



Anti Seize

Grey

Semi solid

-30 °C to +900 °C

## Loctite® 8065



Anti Seize

Copper

Semi solid

-30 °C to +980 °C



### Loctite® 8021 – Silicone Lubricant

- Transparent lubricant for plastic to plastic and plastic to metal lubrication
- Protects, maintains and lubricates plastic and metal parts
- Does not attract dust or dirt

#### Applications:

Lubricates guides, vehicle door locks and plastic components.



### Loctite® 8101 – Chain Lubricant

- Adhesive chain lubricant with anti-filing properties
- Protects against water ingress
- Excellent wear and high pressure resistance

#### Applications:

Use on open mechanisms such as chains and gears.



### Loctite® 8060 Stick – Aluminium Anti-Seize

- Prevents galling and protects mated threaded areas from rust and corrosion
- Optimum control during application

#### Applications:

Wheel to hub connection, industrial oven hinge pins, fork lift truck lifting mechanism.



### Loctite® 8065 Stick – Copper Anti-Seize

- Exclusive C5-A® copper based Anti-Seize formula
- Protects metal parts from rust, corrosion, galling
- Resistant to temperatures up to 980 °C

#### Applications:

Exhaust bolts, brake caliper, bolts steam valve threads.

Pack sizes	IDH No.
Can 400 ml	232368

Pack sizes	IDH No.
Can 400 ml	303134

Pack sizes	IDH No.
Stick 20 g	525118

Pack sizes	IDH No.
Stick 20 g	525392

# Body Repair

With Henkel, customers have access to a full range of Teroson and Loctite® body repair and protection products to meet the needs of today's body repair shop. They include adhesives and sealants, solutions for direct glazing, noise control, corrosion protection, plastic repair and body filling. Many of these products are specified for auto market repair by leading automobile manufacturers.

## Direct Glazing | Page 24

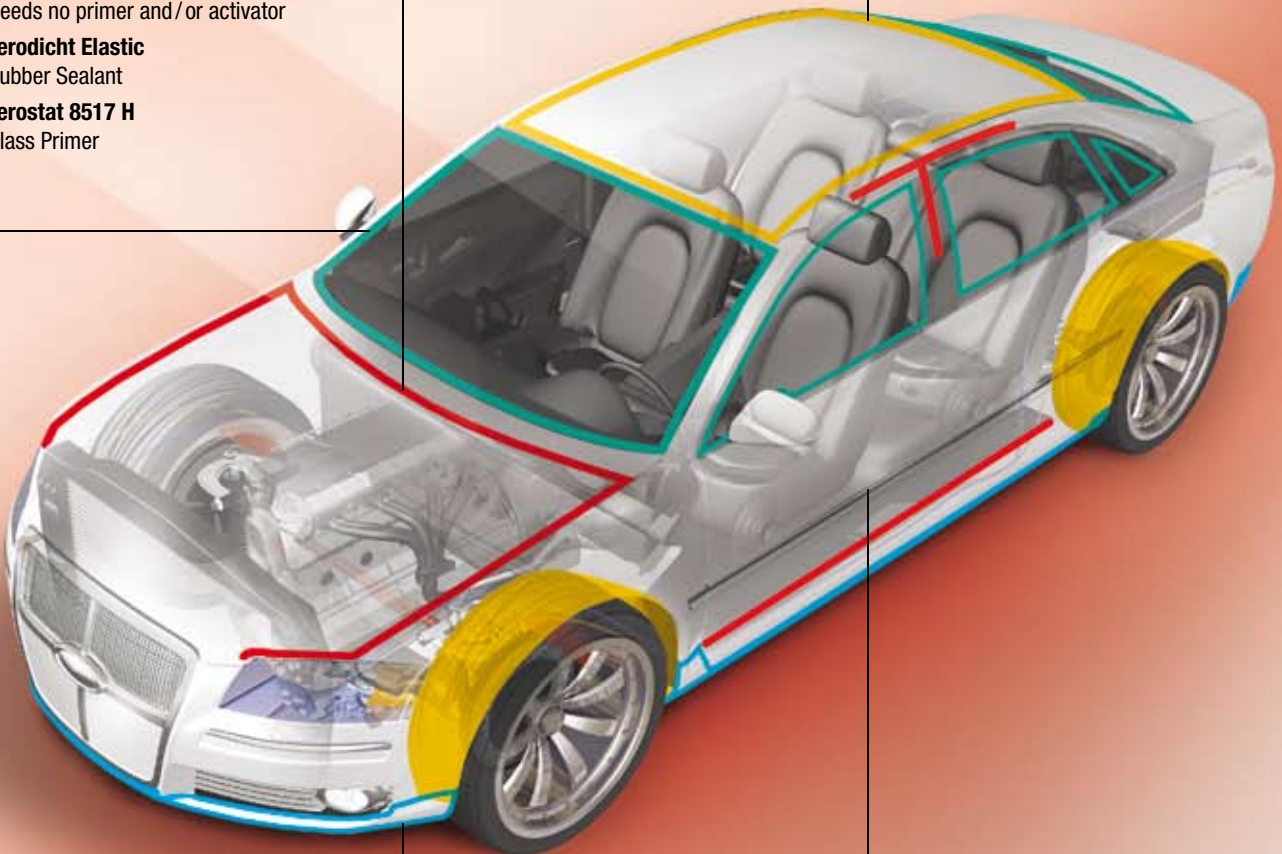
- **Terostat 8596**  
Standard Sealant
- **Terostat 8597 HMLC**  
Fast Sealant
- **Terostat 8599 HMLC**  
Very Fast Sealant
- **Terostat 8630 2C HMLC**  
Instant Sealant
- **Terostat 9000 PL HMLC**  
Needs no primer and/or activator
- **Terodicht Elastic**  
Rubber Sealant
- **Terostat 8517 H**  
Glass Primer

## Seam Sealing | Page 28

- **Terostat 9100 / 9200**  
Sealant White / Black
- **Terostat 9120**  
Multi-purpose Sealant White
- **Terostat 9320**  
4 in 1 Sealant
- **Terolan 53 Special**  
Brushable Body Sealant

## Bonding of Body & Parts | Page 33

- **Terokal 2444**  
Contact Adhesive
- **Terostat 9220**  
Power Bonder
- **Teromix 6700**  
Multi-purpose 2C Adhesive Bonder
- **Terokal 5045**  
Standard Panel Bonder



## Instant Bonding | Page 32

- **Loctite® 401**  
Instant Adhesive
- **Loctite® 454**  
Instant Adhesive Gel

## Plastic Repair | Page 36

- **Terokal 9225**  
Adhesive Standard
- **Terokal 9225 SF**  
Adhesive Super Fast
- **Terokal 150**  
Plastic Primer
- **Teroson Plastic Filler**  
Body Filler

## Body Fillers | Page 38

- **Teroson Allround Filler**  
Allround Body Filler
- **Teroson Alu / Galva Filler**  
Alu / Galva Body Filler
- **Teroson Fine Filler**  
Fine Body Filler
- **Teroson Plastic Filler**  
Body Filler

## Direct Glazing | Page 24

		Terostat 8596	Terostat 8597 HMLC	Terostat 8599 HMLC	Terostat 8630 2C HMLC	Terostat 9000 Primerless	Terostat 8517 H Primer	Terostat 8525 Activator	Terodicht Elastic	Teroson FL	Teroson Applicators
Technology	Rubber mounted								■		
	Bonded	■	■	■	■	■	■	■			
Substrate	Encapsulated windscreen	■	■	■	■	■	■	■		■	
	Glass/ceramic	■	■	■	■	■	■	■		■	
	Glass	■	■	■	■	■	■	■		■	
	Trimmed residual bead	■	■	■	■	■	■	■		■	
	Paint	■	■	■	■	■	■	■		■	
	Aluminium	■	■	■	■	■	■	■		■	
	Bare metal	■	■	■	■	■	■	■		■	
	GFC/SMC	■	■	■	■	■	■	■		■	
	E-coated metal	■	■	■	■	■	■	■		■	
	Primer	■	■	■	■	■	■	■		■	■
Activator	■	■	■	■	■	■	■		■	■	
Properties	Warm application			■	■						
	Cold application	■	■			■	■	■			
	High modulus		■	■	■	■					
	Low conductive		■	■	■	■					
	1 component	■	■	■		■	■	■			
	2 component				■						
	NCAP				■						
	FMVSS	■	■	■		■					
	Installation time in minutes*	25	25	15	30	10					
	Drive away times*	6h	2h	15min	2h	2h					

## Seam Sealing | Page 28

		Terolan Light and Black	Terolan 53 Spezial	Terostat 9100 / 9200	Terostat 9120	Terostat 9320	Terostat 9140	Terostat 33	Loctite 595	Loctite 5940
Curing system	Solvent based	■	■							
	Chemically curable			■	■	■	■	■	■	■
Product base	Synthetic rubber	■	■							
	1c polyurethane			■						
	1c ms polymer				■	■				
	1c silicone						■	■	■	■
Substrates	Paint	■	■	■	■	■	■	■	■	■
	E-coated metal	■	■	■	■	■	■	■	■	■
	GFC/SMC/plastics			■	■	■	■	■	■	■
	Aluminium			■	■	■	■	■	■	■
	Bare metal	■	■	■	■	■	■	■	■	■
	Glass/ceramic			■	■	■	■	■	■	■
	Wood	■	■	■	■	■	■	■	■	■
Properties	Cold application	■	■	■	■	■	■	■	■	■
	1 component	■	■	■	■	■	■	■	■	■
	Skin over time*									
	Sealing	■	■							
	Sealing and bonding			■	■	■	■	■	■	■
	Isocyanate free			■	■	■	■	■	■	■
	Paintable	■	■	■	■	■	■	■	■	■
	Sprayable									
	Brushable	■	■	■	■	■	■	■	■	■
	Non corrosive	■	■	■	■	■	■	■	■	■

\* DIN 50014 standard climate 23 °C / 50% relative humidity

# Body Repair

## Direct Glazing

- Bond screens/windows of all types of vehicles
- Complies with car manufacturers recommendations
- Allow different drive-away times, with TÜV approval



	Terostat 8596	Terostat 8597 HMLC
<b>Product Base</b>	1C PUR	1C HMLC PUR
<b>Application method / cure through time (standard climate)</b>	Cold / 25 min.	Cold / 25 min.
<b>Drive-away time FMVSS 212/208 (airbag)</b>	6 hrs	2 hrs
<b>Drive-away time NCAP (airbag)</b>	n.a.	n.a.
<b>High Modulus / Low Conductive</b>	No	Yes

### Practical Hints:

- Refer to instructions for handling Direct Glazing sealant before application
- Use Teroson FL or cleaner tissue (sets) for surface preparation
- Use primer 8517 H for all DGX products (except with Terostat 9000)
- For pre-coating windscreen, use Terostat 8525
- For Terostat 8599 HMLC and 8630 2C HMLC use Teroson pre-heating box



### Terostat 8596 – Standard Sealant

- Good sag resistance
- No stringing

#### Applications:

For all vehicles. Use any type of professional dispensing tools for application; best with PowerLine II or Electroflow gun.



### Terostat 8597 HMLC – Fast Sealant

- Good sag resistance
- No stringing

#### Applications:

For all vehicles. Use any type of professional dispensing tools for application; best with PowerLine II or Electroflow gun.

Pack sizes	IDH No.
Cartridge 310 ml	450533
Set	450532

Pack sizes	IDH No.
Cartridge 200 ml	537186
Cartridge 310 ml	450503
Set	450438
Foil 400 ml	680347
Foil 570 ml	680348

## Terostat 8599 HMLC



1C HMLC PUR

Warm (after 15 min. heating) / 15 min

15 min.  
n.a.

Yes

## Terostat 8630 2C HMLC



2C HMLC PUR

Warm (after 30 min. heating) / 30 min.

1 hr (cars) / 2 to 5 hrs (trucks / busses)  
2 hrs (cars) / 2 to 5 hrs (trucks / busses)

Yes

## Terostat 9000 PL HMLC



1C HMLC SMP, Primerless

Cold / 15 min.

2 hrs  
n.a.

Yes



### Terostat 8599 HMLC – Very Fast Sealant

- Good sag resistance
- No stringing
- High position tack

#### Applications:

For all vehicles. Use any type of professional dispensing tools for application; best with PowerLine II or Electroflow gun.



### Terostat 8630 2C HMLC – Instant Sealant

- Good sag resistance
- No stringing
- Perfect for all weather conditions

#### Applications:

For all vehicles (best product for busses and trucks) fast drive away for 5-Star NCAP cars. Application only with PowerLine II or Electroflow gun.



### Terostat 9000 PL HMLC – Primerless Sealant

- Good sag resistance
- No stringing
- Isocyanate free

#### Applications:

For all vehicles. Use any type of professional dispensing tools for application; best with PowerLine II or Electroflow gun.

**Pack sizes**      **IDH No.**

Cartridge 310 ml      450441

Set      450434

**Pack sizes**      **IDH No.**

Cartridge 310 ml      794668

Set      867677

**Pack sizes**      **IDH No.**

Cartridge 310 ml      871912

# Body Repair

## Direct Glazing

- Complementary products for direct glazing, bond-line and surface preparation

### Terostat 8517 H



### Terostat 8525



**Product Base**

Polyurethane

Polyurethane

**Application**

For glass, metal and paint

For pre-coated screens

#### Practical Hints:

- Teroson FL can be used as surface preparation for other Teroson products
- For pre-coating windscreen, use Terostat 8525
- New primer & activator packs for longer shelf life



#### Terostat 8517 H – Glass Primer

- Adhesion promoter
- Excellent UV protection
- Corrosion protection for small flange damages

#### Applications:

For all car windows, to promote adhesion of direct glazing adhesives / sealants. Application with Teroson applicators (wool daubers).

#### Terostat 8525 – Activator

- Excellent activation of PUR / PVC pre-coatings
- Activation of old PUR beads (older than 6 hrs)

#### Applications:

For all vehicles with PUR-coated glasses. Application with Teroson applicators (wool daubers).

**Pack sizes**

**IDH No.**

Bottle 25 ml

1114779

Bottle 100 ml

425854

**Pack sizes**

**IDH No.**

Bottle 10 ml

265665

## Terodicht Elastic



Artificial resins / synthetic rubber  
For rubber mounted screens



### Terodicht Elastic – Rubber Sealant

- Good sag resistance
- Ideal for leaking windscreens even under wet conditions
- Water resistant

#### Applications:

For emergency sealing on all vehicles with rubber mounted screens. Use any type of professional dispensing tools for application; best with Staku pistol.

Pack sizes	IDH No.
Cartridge 310 ml	801161

## Teroson FL



Petroleum spirit  
Surface preparation



### Teroson FL – Surface preparation

- Very good surface preparation
- Very short evaporation time

#### Applications:

For surface preparation of windscreens and parts (glass, plastics, metal). Application with lint free cloth or brush (Teroson FL is also a diluent for many Teroson products).

Pack sizes	IDH No.
Can 1000 ml	92679
Can 10 l	63095

## Loctite® 319



Modified acrylic ester  
Bonding of rear view mirrors



### Loctite 319 – Rear-View-Mirror Bonder

- Compensates for differential thermal expansion of parts
- Cures when confined between close fitting parts with the aid of Activator Loctite® 7649

#### Applications:

Bond materials such as metals, glass, ceramic or plastics

Pack sizes	IDH No.
Kit on Blister card	
0.5 ml + 1 mesh	194088

# Body Repair

## Seam Sealing

- For all body repair sealant applications
- For bonding applications
- For different over-painting requirements

<b>Product Base</b>	<b>Synthetic rubber</b>	<b>Synthetic rubber</b>
<b>Skin-over Time</b>	<b>3 to 5 min.</b>	<b>3 to 5 min.</b>
<b>Paintable</b>	<b>After full drying</b>	<b>After full drying</b>

### Practical Hints:

- Terostat 9120/9320 can be spot welded
- For OEM finish, use Teroson butterfly nozzle
- Curing time can be accelerated by IR



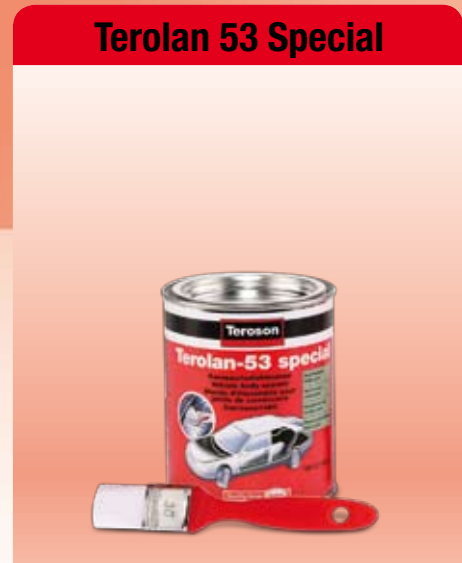
### Terolan Light and Black

- Good adhesion on oily / greasy surfaces (parts that cannot be completely cleaned)
- Excellent adhesion to bare, phosphated, primed and painted steel panels
- Easy to spread and smooth out using Teroson FL (see page 27)

### Applications:

For visible and ordinary seams. Ideal for "problem areas" on vehicles which cannot be thoroughly cleaned. Use any type of professional dispensing tools for application; best with PowerLine II or Electroflow gun.

Pack sizes	IDH No.
Cartridge Light 310 ml	799316
Cartridge Black 310 ml	726808



### Terolan 53 Special

- Good adhesion on oily / greasy surfaces (parts that cannot be completely cleaned)
- Superior adhesion to bare, primed and painted metal parts
- Matches the factory look of original car finishes (brush texture)

### Applications:

For front and rear apron, passenger compartment substructure, side panel, wheel housing, filler neck. Application with Teroson brush.

Pack sizes	IDH No.
Tin 1.2kg	799671



## Terostat 9100 / 9200



1C Polyurethane

ca. 35 min.

After skin formation time

## Terostat 9120



MS Polymer

ca. 20 min.

Wet in wet  
up to 3 days after application

## Terostat 9320



MS Polymer

ca. 10 min.

Wet in wet  
up to 3 days after application



### Terostat 9100 / 9200

- Solvent free
- Good sag resistance
- Matches the factory look of original car finishes (brush texture)

#### Applications:

For all areas where sealing, bonding and fast over painting is required. Particularly suitable for bonding performance accessories, e.g. spoilers, trim strips, etc. Best with PowerLine II or Electroflow gun.

### Terostat 9120

- Solvent free, isocyanate free
- Very good adhesion without primer
- Very good UV resistance and weathering performance
- Very good sag resistance

#### Applications:

For seam and joint sealing and bonding of plastic parts e.g. spoiler for vehicle body repairs. Best with PowerLine II or Electroflow gun.

### Terostat 9320

- Solvent free, isocyanate free
- Very good adhesion without primer
- Very good UV resistance and weathering performance
- Good sag resistance, sprayable

#### Applications:

OEM texture refinish for all vehicles. Application with Teroson MultiPress gun.

Pack sizes	IDH No.
Cartridge White 310 ml	744475
Cartridge Grey 310 ml	744474
Cartridge Black 310 ml	744662

Pack sizes	IDH No.
Cartridge White 310 ml	252257
Cartridge Grey 310 ml	274943
Cartridge Black 310 ml	267084

Pack sizes	IDH No.
Cartridge Ocre 300 ml	272232
Cartridge Grey 300 ml	211742
Cartridge Black 300 ml	211743

## Seam Sealing

- For seam sealing
- For flexible bonding
- For flexible sealing

<b>Product Base</b>	<b>1C Silicone, alkoxy</b>
<b>Temperature resistance</b>	<b>-40 °C to 150 °C</b>
<b>Colour</b>	<b>Transparent/ black</b>
<b>Odour</b>	<b>Odourless</b>
<b>Skin-over time</b>	<b>5 to 7 min.</b>

### Practical Hints:

- Silicones are not over paintable
- Very good for sealing large painted outside areas (e.g. trucks)
- Extremely high UV resistance

### Terostat 9140



### Terostat 9140

- Good adhesion to metal, glass and completely dried car paints
- Dries to form a highly flexible, solid sealant
- Transparent silicone allows mixing with solvent based paint
- Non corrosive

### Applications:

For sealing leaks without dismantling assemblies. Use any type of professional dispensing tools for application; best with PowerLine II or Electroflow gun.

Pack sizes	IDH No.
Cartridge Transp. 310 ml	105494
Cartridge Black 310 ml	267085