

LOCTITE TW 610

Known as EMRALON TW 610

April 2017

PRODUCT DESCRIPTION

LOCTITE TW 610 provides the following product characteristics:

Technology	Waterbased
Product Type	Coating / 1K Low Particulated
Application	EPDM and TPE
Features	<ul style="list-style-type: none"> • Micro Structured Waterborne Coating • One Component System • NMP free product • Performs over a range of coating thicknesses • Flexible curing cycles
Benefits	<ul style="list-style-type: none"> • Environmental friendly • Ease of use • Safer handling: reduced health risks • Economical coating thickness can be selected for each application • Versatil in many application conditions
Application Areas	<ul style="list-style-type: none"> • Rubber and TPE* extrusions - door, trunk and sunroof gaskets • Rubber and TPE* moulded parts - weather-strip • *For TPE a primer (e.g. LOCTITE TP 650 or LOCTITE TP 665) is needed

LOCTITE TW 610 is one of Henkel's new generation, NMP free weather-strip coatings.

It is a resin bonded coating designed to provide dry film lubrication and release properties in a variety of industrial and automotive applications.

It is a one component and water based coating which contains special lubricants.

It is designed to be applied to rubber, hot extruded as well as on-moulded parts.

LOCTITE TW 610 has been found to be an effective product in applications requiring squeak supression and provides freeze-release characteristics when applied on primary door seals. It reduces the friction between rubber and glass or painted surfaces.

The product contains a UV-tracer to make it visible under UV light (for checking presence of the coating).

The cured coating is matt black in appearance, flexible, shows good wear resistance and is not abrasive to painted surfaces.

TECHNICAL DATA

of wet product

Solids content	31.0 to 35.0 %
Viscosity	100 to 300 mPas
Measuring system	Brookfield
Temperature	20 °C
Speed	20 rpm

Time	15 min
Flashpoint	>100 °C
Density	approx. 1,035 kg/m ³
pH	8.0 to 9.5
Theoretical Coverage	approx. 30 m ² /kg at 10 µm dry coatings thickness

as cured

Colour	Black
Gloss level (60° angle)	<4 at recommended coating thickness
Static coefficient of friction	<0.2
Service temperature	
-continuous	135°C
-intermittent	190°C

PRELIMINARY STATEMENT

Prior to application it is necessary to read the Safety Data Sheet for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labelling, the relevant precautions should always be observed.

METHOD OF USE

Stirring

First homogenise the product properly by stirring and always use closed containers (lid with a hole):

- 1) Short stirring for 10 min @ 200 rpm.
- 2) Reduced stirring speed (approx. 40 to 60 rpm) during usage of LOCTITE TW 610.

Application

LOCTITE TW 610 is designed to be spray applied in-line or off-line to rubber extrusions or moulded parts with a surface temperature of 50 to 120°C.

Pre-treatment

A primer (e.g. LOCTITE® TP 650 or LOCTITE® TP 665) or another suitable surface pre-treatment is always required to obtain good adhesion properties.

Recommended coating thickness

• Squeak-supression:

A dry coating thickness of 10 µm is required to obtain proper squeak supression.

• Freeze-release:

Good freeze release properties are already obtained with a dry coating thickness of 10 to 15 µm.

Cure

Advised schedule:

- 20 minutes @ 70 °C
 - 10 minutes @ 100 °C
 - 2 minutes @ 180 °C
- (substrate temperature)

Test for Cure

MEK wipe test: at least 20 rubs.

APPLICATION ASSISTANCE

Henkel's Application Specialists are available to assist you in production start-up with **LOCTITE TW 610**.

For more information, contact Henkel Netherlands +31 30 607 39 11 or visit our website at <http://www.henkel.com/adhesives/industrial-12131.htm> for the Henkel global location nearest you.

STORAGE

LOCTITE TW 610 is frost-sensitive.

Recommended storage temperature:

5 to 30 °C under original seal. Return to room temperature and stir gently before using. Do not freeze.

Recommended transportation temperature:

5 to 50 °C for short term.

Transit and interim storage situations (i.e. receiving) are not encompassed by Henkel's storage requirements. It should be noted however that all efforts should be made to store material as required, as soon as possible. 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.

Shelf life:

9 months from date of qualification under original seal.

PACKAGING

18 kg.

ADDITIONAL INFORMATION**Disclaimer****Note:**

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Reference 0.1