Technical Product Bulletin

TEROSON® SB PL 687

(KNOWN AS PLASTILOCK® 687)

June 2017

DESCRIPTION

TEROSON SB PL 687 (KNOWN AS PLASTILOCK 687) is a synthetic resin based solution, used to prevent corrosion and improve bonding of high-density friction material.

FEATURES & BENEFITS

- Excellent resistance to chemicals when cured
- High shear strength at ambient and elevated temperatures
- Cured bond withstands temperatures exceeding 600°F intermittently

USES

- Integrally molded disc pads
- Brake shoe primer
- Steel to steel
- Friction materials to steel

TYPICAL PROPERTIES

Typical technical data and performance properties given for reference only (not for specification purposes)

Typical Technical Data	TEROSON SB PL687 (known as PLASTILOCK 687)
Base:	
Color:	Black
Viscosity: (Brookfield RVF #1 @ 20 rpm)	20-50 cps
Solvent (Thinner)	isopropyl alcohol
Total Solids (weight): (volume):	28-32% 18% (calculated)
Calculated Coverage:	300 ft²/gal./mil (7.2 m²/L/0.0254mm)
Weight/Gallon	7.6 lbs/gal *(0.91 kg/L)*
Shelf Life:	18 months from date of manufacture** **When stored under appropriate conditions (See STORAGE section)**

APPLICATION METHOD

Method: Conventional or airless spray, curtain coating, brushing, dipping or roll-coating.

Surface Preparation: Clean surfaces to be bonded; metal should be degreased and grit-blasted.

Application to Part: Apply TEROSON SB PL 687 (KNOWN AS PLASTILOCK 687) to surface(s) to be bonded. Optimal dry film thickness will be determined by part configuration and end-use application. After the final coat has been applied, allow adhesive to thoroughly dry. All solvents must be removed from adhesive film before bonding. Drying conditions will vary with the applied wet film thickness of the adhesive. Heavier coatings must be dried at lower temperature for longer periods of time in order to prevent the adhesive film from blistering. The following **GUIDELINES** will provide a starting point for establishing on-line drying conditions:

< 2 mils = 200-240°F for 5 to 10 minutes
> 2 mils = 140-170°F for 10 to 20 minutes.

KEEP IN MIND:

- Adhesive patterns having the greatest surface area will the dry best.
- Humidity affects evaporation rates. High humidity during summer months may cause a drying problem. Normal drying cycles may require season adjustments to provide adequate drying.
- Should target drying to less than 5% residual solvent.

CURING CONDITIONS

TEROSON SB PL 687 (KNOWN AS PLASTILOCK 687) can be cured at 375-400°F *(190-204°C)* for 30 minutes. Constant pressure (50+ p.s.i.) must be kept on parts to achieve a good bond.

** This time/temperature/pressure profile is based on steel to steel disc shear bonding and **MAY REQUIRE ADJUSTMENTS** for your bonding process.*

CLEAN UP

Prior to cure, the adhesive can be removed with methyl ethyl ketone or acetone. Work should be done in a well-ventilated area. Following cure, the adhesive will be resistant to basically all solvents. The only practical means of cleaning a cured adhesive is with some type of abrasion.

Henkel Corporation | 32100 Stephenson Highway | Madison Heights, MI 48071
PHONE: (248) 583-9300 | FAX: (248) 583-2976 | www.henkelna.com/

STORAGE

TEROSON SB PL 687 (KNOWN AS PLASTILOCK 687), when stored in the liquid form, will meet the adhesion requirements of Henkel Corporation's specifications after 18 months of storage in the temperature range of 40-60°F *(4-15°C)*. Storage of TEROSON SB PL 687 (KNOWN AS PLASTILOCK 687) at temperatures above 60°F (15°C) may significantly reduce the product's working life.

Parts coated with TEROSON SB PL 687 (KNOWN AS PLASTILOCK 687) may be stored an additional 6 months at temperatures below 95°F *(35°C)* before bonding. Protect the adhesive surface from contamination during this storage period.

SAFETY & HANDLING

See Material Safety Data Sheet on this product before using, handling, or disposing.

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