

Teroson

Solutions for Plastic Repair



Henkel



DEKRA

Complete Solution for Plastic Repair



Plastic Repair Kit

Product	Quantity	IDH No. Kit	IDH No.
Cartridges Terokal 9225	3	Kit 211680	267081
Aerosol can Terokal 150	1		267078
FL Cleaner + Thinner	1		92679
Application gun	1		150035
Reinforcement matting	1		—
Static Mixers	6		142242
Plastic spatula	1		—

Variodur Classic / Aqua

Multi-finish Mixable Coating

- **Variodur Classic:** suitable for colouring with all solvent based car paints
- **Variodur Aqua:** suitable for colouring with all water based car paints – thinnable with water up to 10 %
- For repair of the underbody, wheel houses, front and rear areas
- Spray / apply with UBC-guns, filler or paint pistols



Packaging	Contents	Quantity	IDH No.
Variodur Aqua	1 l	6	391838
Variodur Classic	1 l	6	388904
Paint pistol	1	1	485030*

Static Mixers

- Guarantee a homogeneous mixture
- Precise application, no risk of air bubbles



Packaging	Quantity	IDH No.
Mixers for 2 x 25 ml cartridge	Bag: 12 pcs	142242
Mixers for 2 x 125 ml cartridge	Bag: 10 pcs	780805

Telescopic Power Line Gun

For dispensing car body sealants, adhesive sealants and direct-glazing sealants.

- Telescopic piston does not wander, ensures smooth action, and prevents trapped air bubbles
- No run-on
- Dented cartridges will not cause any problems
- Piercing tool for aluminium cartridge seals included in supply package



Packaging	Quantity	IDH No.
Power Line Gun	1	211757

Terotex Super 3000

- For renewing and complementing factory-applied anti-chip coatings on rear aprons, front ends, door sills, etc.
- Recreate the original surface of the stone chip protection coating, once painted
- Excellent sandability after complete drying



Packaging	Contents	Quantity	IDH No.
Terotex Super 3000 black	1 l	12	767199
Terotex Super 3000 light	1 l	12	782601

Texture Spray Gun

- Texture Spray Gun – 2 valves – for Terotex Record 2000 HS / Terotex Super 3000



Packaging	Quantity	IDH No.
Texture Spray Gun	1	150036

Staku Hand Cartridge Gun

Handles all 150 ml and 310 ml cartridges.

- Steel/plastic design with enclosed-type cartridge skeleton frame
- Smooth action
- Long life
- No run-on
- Easy to maintain and clean



Packaging	Quantity	IDH No.
Staku Hand Cartridge gun	1	142240

Plastic Repair – Working procedure



1



2



3



4



5

Cleaning

1 Use high-pressure cleaner to remove major contamination. Rinse plastic part with plenty of clear water and allow to dry.

2 Thoroughly clean the plastic part with **Teroson FL Cleaner** on both sides.

Pre-treatment

3 Grind a V-groove (1–2 cm) into the frontside edges of the repair area. Best results are achieved with 150 grit sandpaper.

4 Roughen surfaces on both sides. Recommended sandpaper: 150 grit.

5 Clean work area again on both sides, using **Teroson FL Cleaner**.

Plastic Repair – New Products

Terokal 9225, 250 ml

Terokal 9225 is a polyurethane-based two-component adhesive which cures at room temperature. The product is rapid curing.

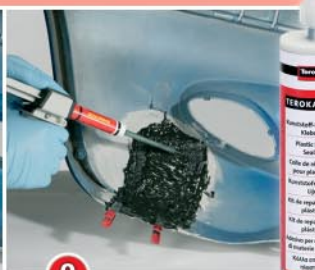
- Application areas: repair of bumpers, trim and body parts made of plastic, e.g. PP/EPDM, SMC, PC, PA, ABS and PUR
- Must be used with primer Terokal 150
- Can be coated with Terotex-Super 3000, Variodur classic or Variodur aqua



Technical Data:

	Component A	Component B
Colour:	yellow	black
Density:	approx. 1.4 g/cm ³	approx. 1.7 g/cm ³
Solids (3 h at 100 °C):	> 98 %	> 98 %
Mixing ratio by volume:	100	100
Mixture (Component A + B)		
Colour:	dark grey	
Pot life:	approx. 10 min	
Tack-free time:	approx. 30 min	
Curing time at 23 °C:	approx. 5 hrs	
Shore A hardness:	approx. 90	
Sandability:	subject to the following curing conditions: - cure for 15 min at 60 °C to 70 °C and allow to cool down to room temperature or - after 5 hrs at room temperature	
Application temperature:	15 °C to 25 °C	
Shelf life:	12 months	

Packaging	Contents	Quantity	IDH No.
Terokal 9225	Cartridge 250 ml	12	881837



Apply primer

Apply adhesive

- 6** Spray a thin coat of **Terokal 150 Plastic Primer** onto both sides. Evaporation time is about 5–10 minutes at room temperature.
- 7** Apply **Terokal 9225** or **Terokal 9225 SF** to the backside.
- 8** Span the reinforcement matting over the damaged area.
- 9** Apply adhesive on top of the reinforcement matting and smooth down using a plastic spatula or a brush.
- 10** Cure **Terokal 9225** adhesive for 15 minutes using a heater at about 60–70 °C.

Terokal 9225 super fast, 50 ml

Terokal 9225 SF is a polyurethane-based two-component adhesive which cures at room temperature. The product is rapid curing.

- Repairs small damages to bumpers, trim and body parts made of plastic, e.g. PP/EPDM, SMC, PC, PA, ABS and PUR. The product is also used for fixing broken plastic parts (e.g. plastic eyelets, plastic hangers)
- Easy to apply, even on vertical repair areas
- Must be used with primer Terokal 150
- Can be coated with Terotex-Super 3000, Variodur classic or Variodur aqua



Technical Data:

	Component A	Component B
Colour:	yellow	black
Density:	approx. 1.4 g/cm ³	approx. 1.7 g/cm ³
Solids (3 h at 100 °C):	> 98 %	> 98 %
Mixing ratio by volume:	100	100
Mixture (Component A + B)		
Colour:	dark grey	
Pot life:	approx. 2 min	
Tack-free time:	approx. 10 min	
Curing time at 23 °C:	approx. 1.5 hrs	
Shore A hardness:	approx. 90	
Sandability:	subject to the following curing conditions: - cure for 4 min at 60 °C to 70 °C and allow to cool down to room temperature afterwards or - after 15 min at room temperature	
Application temperature:	15 °C to 25 °C	
Shelf life:	12 months	

Packaging	Contents	Quantity	IDH No.
Terokal 9225 super fast	Cartridge 50 ml	6	882088



Finishing

- 11** Allow area to cool down to room temperature (if necessary, use water to accelerate cooling). Sand to remove excess adhesive and restore the original shape of the plastic part, and blow off grinding dust. Recommended sandpaper: 150 grit.
- 12** Apply a thin coat of **Terokal 150 Plastic Primer** to the repair area.
- 13** To smooth roughness and scratches on the surface apply **Teroson Plastic Filler** using a plastic spatula. Afterwards sand the repair area again. Recommended sandpaper: 240–400 grit
- 14** Textured and smooth surfaces can be rebuilt using **Terotex Super 3000** black/light or **Variodur Aqua/Classic**. Mix with two-component refinishing paint hardener.
- 15** Restore painted surfaces of plastic parts in accordance with the paint manufacturers' instructions.

Teroson Plastic Filler, 920 g



Teroson Plastic Filler is a two component polyester filler with excellent adhesion to plastic surfaces. Sets hard in minutes and does not shrink once set.

- Teroson Plastic Filler specially developed for use on plastics e.g. PP/EPDM, SMC, PC, PA, ABS and PUR
- Excellent application areas: repair of bumpers, trim and body parts made of plastic
- Must be used with primer Terokal 150
- Cures without shrinking
- Excellent sag resistance
- Easy to apply, even on vertical surfaces
- Excellent sandability after complete drying
- Cured material is resistant to water, salt solutions, organic solvents, diluted acids and alkalis

Technical Data:

Uncured material	Part A	Part B
Chemical base:	Polyester	Dibenzoylperoxide
Appearance:	Dark grey	Red
Density:	approx. 1.8 g/cm ³	approx. 1.2 g/cm ³
Mixing ratio by volume:	100	2–4
Cured material		
Physical properties:		
Hardness (Shore D):	~ 75	
Sandability:	after 15 min	
Shelf life:	12 months, stored under 20 °C	

Packaging	Contents	Quantity	IDH No.
Teroson Plastic Filler	Can 920 g	6	882485



A World of Engineering Solutions and Customer Support

Henkel – The Solution Provider

Henkel has been recognised for its comprehensive portfolio of solutions for automotive interiors and exteriors, chassis/power train and body engineered systems.

At Henkel, we understand the challenges of today's body shop professionals and provide solutions that work.

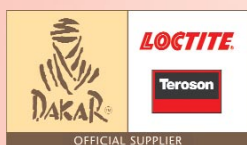
Henkel – A Driving Force in the Racing World

Around the world, Henkel has an extensive commitment to motorsports. In 2004, the Henkel logo appeared for the first time on the rear wing of the Team McLaren Mercedes race cars, thereby continuing the technical association with the team which began in 1995 through the Loctite® brand. As Official Supplier, Henkel provides a wide variety of innovative solutions to the team. In North America, Henkel's NASCAR sponsorships include several brands.

The Dakar Rally is the latest in the long line of top-level competitive motor sport events in which Henkel has been involved. It's a tough 16-day tour through gruelling desert terrain, and the mechanical components in the cars, bikes and trucks that compete are put under enormous stresses. Automotive and motorcycle plastics often get badly damaged in collisions with trees, ditches, rocks and boulders. Henkel has assisted the drivers by providing the ingenious Plastic Repair system for repairing cracks, holes, scratches or gashes in plastic parts easily, perfectly and fast enough to allow the competitors to continue their race and make it to the finish line.

Supporting the Dakar competitors as an Official Supplier since the 2005 event, Henkel has offered the drivers a wide range of Loctite® and Teroson branded adhesives, sealants, maintenance products, cleaners, bonding tapes and repair kits that proved they were more than a match for the world's most demanding conditions.

Products from the Henkel range – Designed for everyday use – Tested on the world's toughest events



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