

## TEROSON® BOND ALL-IN-ONE PRIMER

Known as TEROSON® PU 8519 P  
August 2020**PRODUCT DESCRIPTION**

TEROSON® BOND ALL-IN-ONE PRIMER provides the following product characteristics:

<b>Technology</b>	Primer
Chemical Type	Polyurethane
Appearance (uncured)	Black liquid
Components	One-component – requires no mixing
Viscosity	Liquid
<b>Cure</b>	Humidity
<b>Application</b>	Surface pretreatment
Environmental temperature at application	-5 to 45°C (23 to 113°F)
Material application temperature	5 to 35°C (41 to 95°F)
In service temperature	-40 to 90°C (-40 to 194°F)
Short exposure (up to 1h)	120°C (248°F)
Specific Benefits	<ul style="list-style-type: none"> <li>• Excellent adhesion on glass, ceramic, paint, plastics and remaining beads</li> <li>• Simple process</li> <li>• UV resistant</li> <li>• Fast evaporation</li> </ul>

TEROSON® BOND ALL-IN-ONE PRIMER is a thin liquid, solvent containing masking aid based on polyurethane. The product is notable for its excellent covering properties and its good UV-stability. The primer is suitable for promoting the adhesion of other PUR adhesives/sealants to glass, glass ceramic, various plastics, metals and can also be used for PUR-coated glasses and remaining beads. TEROSON® BOND ALL-IN-ONE PRIMER is also suitable as corrosion protection for small flange damages. It is free from chlorinated hydrocarbons and aromatic solvents. Typical applications include the bonding of front, rear and side screens to the body of passenger-, utility-, special- and rail vehicles.

**TYPICAL PROPERTIES**

Tested @ 23°C/50%RH

Specific Gravity	0.98
Solids, %	35
Drying time, minutes (1C adhesive)	2
Drying time, minutes (2C adhesive)	15
Open time, hours	8

**GENERAL INFORMATION**

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

**Direction For Use****Surface Pretreatment**

The surfaces to be coated must be dry, free of oil, dust, grease and other components or residues which would adversely affect adhesion. The surface must be cleaned and pretreated with TEROSON® VR 10 or TEROSON® BOND GLASS CLEANER. Technical Data Sheet of recommended cleaner has to be observed.

**Preparation**

Prior to use, shake the aluminum bottle vigorously by hand for at least 1 minute. A steel ball is provided in the bottle to assist mixing. This should move freely after three to four shakes.

**Application**

TEROSON® BOND ALL-IN-ONE PRIMER may be applied thinly and evenly with felt applicator or TEROSON® BOND SPONGE. Let the primed surface evaporate as stated before the direct glazing adhesive is applied. A second application on the same point should be avoided, as partially dried primer will be softened again which can adversely affect adhesion properties. The optimal application temperature is between 5 to 30°C. In exceptional cases the application can be done at higher temperatures. A higher reaction speed will be noticed.

**Handling Precautions:**

TEROSON® BOND ALL-IN-ONE PRIMER must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations.

Special care must be taken to avoid contact of the product or its vapor with a flame or any electrical equipment that is not flame proofed.

The solvent can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

**Storage**

Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

**Optimal Storage: 15 to 25 °C. Storage below 5 °C or greater than 25 °C can adversely affect product**

**properties.**

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 Henkel representative.

**Product Specification:**

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

**Approval and Certificate:**

Please contact Henkel representative for related approval or certificate of this product.

**Data Ranges**

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23 °C / 50% RH = 23 $\pm$ 2 °C / 50 $\pm$ 5% RH.

**Conversions:**

(°C x 1.8) + 32 = °F  
 kV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 $\mu$ m / 25.4 = mil  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 N/mm<sup>2</sup> x 145 = psi  
 MPa x 145 = psi  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = cP

**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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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