

## TEROSON EP 5020 TR

June 2019

### PRODUCT DESCRIPTION

<b>Technology</b>	Epoxy Resin
<b>Product type</b>	Body rework, Rebuilding of Car Body Metal Surfaces
<b>Additional Information</b>	2-component lead free solvent free

TEROSON EP 5020 TR is a solvent free, two component, high strength levelling compound based on Epoxy Resins with low density. By heating up both components the chemical reaction will accelerate. TEROSON EP 5020 TR has been specially developed for body rework and for rebuilding of car body metal surfaces to substitute traditional tin soldering. It is free of isocyanate, silicones and lead. The product has no shrinkage and is excellent for grinding. TEROSON EP 5020 TR shows no sagging and has very good reshaping properties. TEROSON EP 5020 TR is sandable after ~2.5 hours at 23°C.

#### Application Areas:

The material is used as a plumb free tin-solder replacement to fill and smooth damages. TEROSON EP 5020 TR works on steel and also on aluminium.

### TECHNICAL DATA

(Typical Test Results)

#### PART A

Base	Epoxy Resin
Colour	dark grey
Odour	characteristic
Density	approx. 0.9 g/cm <sup>3</sup>

#### PART B

Base	Amine
Colour	white/ light grey
Odour	of amines
Density	approx. 0.7 g/cm <sup>3</sup>

Mixing ratio A:B  
by volume 2:1

#### Mixture (PART A+B)

Colour	grey
Odour	no smell after curing
Processing time (23°C, 50% rh):	~10 min
Sandable 3 mm layer thickness (23°C, after ~2.5 hrs 50% rh):	
Density (cured)	approx. 0.8 g/cm <sup>3</sup>
Water absorption	
24 hr(s) at 98 % rh and 40 °C	<0.5 % weight gain

### PRELIMINARY STATEMENT

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

#### Pretreatment:

The surfaces must be dry and free of oil, grease and dust. For pretreatment of the application area / surface use TEROSON VR 10 .

#### Application:

During the storage time and shipment a crystallization of the resin may occur. By heating the adhesive above 60 °C for about 60 minutes this physical process is reversible. All properties stay afterwards on the same level. It is recommended that the adhesive should be used with a minimum temperature of 15 °C. TEROSON EP 5020 TR is processed from universal cartridges with manual application tools (guns driven by hand, air pressure or battery). Only use cartridge pistols that are equipped with a piston rod. Insert the cartridge into a suitable application gun. Apply pressure to the cartridge to ensure a simultaneous and homogeneous flow of both components. Thereafter, clean the tip and attach the static mixer. To ensure proper mixing, discard the first approx. 5 cm of the adhesive bead. If material is left in the cartridge leave the static mixer attached. For further use of the product, simply remove the mixer and install a new one. Apply the levelling compound onto the repair area in a way that the area is sufficiently filled with excessive material (between 3 and max. 5 mm). After curing excessive material is sanded back and sanding residues are removed. Maximum recommended layer thickness before varnish application is 3 mm. Thereafter clean the sanded parts with TEROSON VR 10 . Further treatment (e.g. filling or painting) is executed according to the directions of the manufacturer. The use of body filler (TEROSON UP 210) is required. The use of BONDERITE M-NT 1455-W for bare metal is recommended after sanding before the body filler is applied. The material is not designed to be used on large repair areas at buses and coaches like side panels and roofs.

#### Curing:

TEROSON EP 5020 TR cures without additional exterior heat only by chemical reaction after mixing component A and B at room temperature. The development of reaction heat and consequently the curing time, are determined by the application temperature, layer thickness and the room temperature. For accelerated curing it is recommended to use a heat source. 60 °C object temperature for 15 minutes is recommended.

**Cleaning:**

Cured adhesive can only be removed mechanically. Fresh, uncured material can be removed with the aid of TEROSON VR 10.

**Classification:**

Please refer to the corresponding **Material Safety Data Sheets** for details on:

**Hazards identification****Transport information****Regulatory information****Storage:**

Frost sensitive	conditionally
Recommended storage temperature	15 to 35 °C
Shelf life	12 months in original packaging

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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.

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