

TEROSON® PU 8599

December 2024

Direct glazing adhesive with high position tack

Product description

TEROSON® PU 8599 provides the following product characteristics:

Technology	1C Polyurethan adhesive, free from PVC and solvents
Product type	Direct Glazing for industrial use
Application	Elastic bonding
Additional function	High position tack

TEROSON® PU 8599 is outstanding for the following properties:

- very good sag resistance
- high cure rate
- high shear strength and good elasticity, even after aging
- excellent adhesion to glass, glass with ceramic coating, encapsulation and to painted surfaces, in connection with primer/activator

Application areas:

TEROSON® PU 8599 is used for the bonding of front, rear and side screens to the body of motor vehicles (car, truck, bus).

Technical data

(Typical test results)

Colour	black
Odour	imperceptible
Consistency	pasty
Density, g/cm³	1.27
Viscosity at 23°C, Pas	6,000 to 7,500
Solids, %	100
Curing mechanism	moisture curing, accelerable
Cure rate, mm/h (23 °C, 50 % rh)	4/24
Skin formation time, min (23 °C, 50 % rh)	approx. 20
Shore A hardness	approx. 70
Tensile strength, MPa	approx. 9
Elongation at break, %	approx. 400
Shear modulus G10, MPa	approx. 2.5
Shear strength, MPa	approx. 5
In service temperature range, °C	-40 to 90
Recommended application temperature, °C	50 to 65

Direction for use

Preliminary statement:

Prior to use it is necessary to read the **Material 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. Please also refer to the local safety instructions and contact Henkel for analytical support.

Surface pretreatment and priming:

Ensure that the substrates to be bonded are dry and free from oil, dust, grease and other dirt. Use for glass, paint and cathaphoretic dip painting (E-coat) the approved cleaners. The approved Henkel primer has to be used according to prior agreement with Technical Customer Service.

Application:

It is recommended to use a complete heated application system. To face the HPT effect the material must be heated up to minimum 60°C.

- The entire equipment, including hoses and pipes, must be moisture tight.
- The follower plate must be driven by a double ram.
- Necessity of centering the container.
- It is recommended to switch off heating during a shutdown of more than 1 hour.
- The adhesive is applied from pails or drums using high pressure piston pumps with a pneumatic ratio minimum 55:1.

Due to the various application conditions it is recommended to follow the references in the current valid application data sheet. The application data sheet also provides necessary information about suitable application equipment and conditions. For further information, please contact the responsible sales representative.

Classification:

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

Transport Regulations  
Hazardous Information  
Safety Regulations

Storage:

Frost sensitive	no
Recommended storage temperature, °C	15 to 25
Shelf life (depending on packaging), months	6 to 18



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