

# TK 3958

## Terokal 3958

**Contact adhesive for bonding plastic and rubber membranes, insulation materials and facade sealing strips.**

**Material base: synthetic rubber**

### PROPERTIES

- Application by roller, brush or airless spray
- Very high initial tack
- White pigmented

### SCOPE OF USE

Terokal 3958 is used for both surface and connection sealing when bonding fabric-backed plastic and rubber membranes (e.g. EVA, EPDM) and non-fabric-backed facade sealing strips (e.g. EPDM). Terokal 3958 is suitable for one-sided application but also for contact bonding.

Terokal 3958 is also suitable for bonding foamed plastics used for insulation, e.g. rigid polystyrene foam (styrofoam), mineral-fibre insulation materials (by Isover, Rockwool etc.), felt, jute with each other and on wooden materials, concrete, plastered masonry of mortar groups P II and P III, steel, GRP (glass-fibre reinforced plastic), aluminium, fibrous cement boards, sandwich-type and fibrous plasterboards. In addition, it can be used for fixing rigid polystyrene foams on many thermoplastic materials (rigid PVC, ABS, polystyrene), thermosetting plastics and bituminous roofing membranes.

### SUBSTRATE PREPARATION

The surfaces to be bonded must be load-bearing, clean, solid, level, dry and free of dust, grease, oil and cracks. Mechanically remove sintered layers and cement slurries from mineral substrates (e.g. concrete), then sweep clean and vacuum off the surfaces.

### APPLICATION

Stir Terokal 3958 well before use!

The adhesive is suitable for one-sided bonding or contact bonding and is applied using an airless spray device, adhesive roller or paint brush.

#### One-sided bonding:

One-sided application for surface bonding. The adhesive is applied over the entire substrate surface. Use a net-like pattern for plastic and rubber sheeting. After a short flash-off time (depending both on air and substrate temperature and air humidity), the covering material is placed into the semi-wet or wet adhesive bed. It can be re-positioned for a short time. A safer method to determine the proper flash-off time is the finger test. The adhesive film must stick to the finger over its entire contact area.

Make sure to entrap as little volatile matter as possible underneath the roofing membrane. Temporary blisters in the membranes will disappear as soon as the volatile substances have escaped.

Mineral-fibre insulation materials that are capable of diffusion (used e.g. on facades) can be fixed on sheet metal and concrete by one-sided application of Terokal 3958. Apply the adhesive onto the substrate, place the insulation material into the semi-wet or still wet adhesive bed, re-position it, briefly lift it off the surface and then briefly but firmly press it down. Bonding on unlaminated rigid polystyrene boards is not permissible.

#### Contact bonding:

Two-sided application of the adhesive, e.g. for connection sealing, especially in the area of parapets, walls, chimneys. Here as well, the flash-off time can best be determined by means of the finger test. The adhesive film must feel dry but still tacky when using this method. To ensure reliable bonding of insulation materials with each other, make sure to apply the adhesive uniformly, without adhesive pooling. A too short flash-off time will destroy the rigid polystyrene foam. Sufficient bonding can only be ensured if the required minimum amount of adhesive is applied.

When exposed to stronger wind uplift forces, a higher amount of adhesive must be used (see DIN 1055, part 4: Assumed loads for buildings, traffic and wind loads on buildings not susceptible to vibration; Flat Roof Guidelines; Guidelines for the Planning and Execution of Roofs with Waterproofing - in their currently valid versions).

### PLEASE NOTE

Temperatures below +5°C, humidity and wetness, snow and ice, biting wind and frost may have a detrimental effect on the bond. Therefore do not apply the adhesive under these conditions (DIN 18 338). Lower temperatures (+5°C) require a longer flash-off time; therefore do not embed the material too early into the adhesive.

When applying the adhesive, make sure not to soil the seam overlaps (welding area) or the membranes with adhesive. When using underlays which on their upper side are equipped with a separation layer (e.g. fabric or PE film) or coated with talcum, bonding with a cold adhesive is only possible when taking additional measures (flame treatment).

When bonding polystyrene foams, the foam cells may partly dissolve or even collapse if the flash-off time is too short or if a too high amount of adhesive is applied. Therefore make sure to observe the minimum flash-off time! On reaching the right moment for bonding, the surfaces to be joined must be accurately placed on top of each other as later re-positioning is hardly possible. Firmly press the bonded material down, roll it over and press home. Good initial strength is already achieved immediately after joining.

#### Cleaning:

Remove excess adhesive/adhesive stains with Teroson ST Cleaner while still uncured, also on tools. Use solvent-resistant gloves, eye protection, roller and a brush made of natural bristles.

Make sure to follow the aforementioned safety measures. For detailed safety information refer to the respective Safety Data Sheets.

### IMPORTANT INFORMATION

Apart from the information given, it is important to also observe the relevant guidelines and regulations of various organizations and trade associations as well as the respective DIN standards.

Please refer in particular to the following guidelines and regulations in their currently valid versions:

DIN 1055, part 4:	Assumed loads for buildings, traffic and wind loads with buildings not susceptible to vibration
DIN 18 164	Foamed plastics used for insulation in structural engineering
DIN 18 165	Mineral-fibre insulation materials used in structural engineering
DIN 18 338	Roof covering and roof sealing works

Flat Roof Guidelines issued by the respective trade associations

Guidelines for the Planning and Execution of Roofs with Waterproofing.

The above information, in particular proposals for the handling, application and use of our products, is based on our knowledge, experience and application tests. As materials and site- or application-specific conditions may vary from those described here and are thus beyond our control, we strongly recommend that the user always conducts sufficient tests to ensure our products are suitable for the intended application method and use. Legal liability cannot be accepted - neither based on the content of this Technical Data Sheet nor any verbal advice given - unless there is evidence of carelessness or gross negligence on the manufacturer's part.

In case of questions, please consult our advisory service. Technical hotlines:

Facade work: phone 02 11 / 797 - 106 50/64  
fax 02 11 / 798 - 20 65

Roof work: phone 0 60 53 / 708 - 141  
fax 0 60 53 / 708 - 113

This Technical Data Sheet supersedes all previous issues.

Please refer to our Safety Data Sheet for warnings, safety advice and transport labelling.

### STORAGE

The most favourable storage temperature is between +15°C and +20°C. The permitted shelf life is 12 months.

### DISPOSAL

Dispose of or recycle the packaging according to the local regulations.

### PACKAGING

9.5 kg bucket

## TECHNICAL DATA

Material base:	styrene-butadiene rubber (SBR)
Colour:	white to slightly beige
Odour:	smells of petrol
Consistency:	liquid
Application temperature (air and substrate):	+5 °C to +30 °C
Density at +20 °C:	approx. 0.88 g/cm <sup>3</sup>
Solid content:	approx. 41 %
Cleaner:	Teroson ST Cleaner
Minimum flash-off time:	Depends on air/substrate temperature and rel. air humidity. Carry out the finger test.
Open time:	approx. 10 minutes (+23 °C / 50 % rel. air humidity)
Required amount:	Depends on substrate condition and application method. Approx. 200 to 250 g/m <sup>2</sup> when applied on both sides (contact bonding).

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