



# NON-SAG FAST SET ADHESIVE

## TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

## DESCRIPTION

**Non-Sag Fast Set Adhesive** is a two-component, epoxy based adhesive for fast bonds on most surfaces.

## FEATURES

- **DUAL-MIX™** Forever Warranty
- Superior adhesion
- Ideal working time
- Bonds multiple substrates

## SUITABLE SUBSTRATES

- SMC
- Fiberglass
- Steel
- Aluminum

## TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
39907	Non-Sag Fast Set Adhesive	Black	7 oz. Cartridge
Working time:	3 minutes @ 70°F (21°C)		
Set time:	7 minutes @ 70°F (21°C)		
Cure time:	60 minutes @ 70°F (21°C)		
Heat cure time:	15 minutes @ 120°-140°F (49°-60°C)		
Lap shear strength:	1800-2000 psi (ASTM D 1002)		

## HANDLING AND APPLICATION

### PREPARATION:

1. Clean with **Scuff & Clean** and rinse with water.
2. Clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.

### MIXING:

1. Place cartridge into **Universal Manual Applicator** or **Universal Pneumatic Applicator**. Remove cartridge tip. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally.
2. Install **Static Mixer** and cut tip to desired bead size. Dispense 2-3 inches of test material to make certain color is uniform before applying to job.



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## STATIC MIXERS:

Part:	Product Name:	For:	Container:
70011	Integral Nut Square Static Mixers	7 oz. Cartridge	6 Pack
70012	Integral Nut Square Static Mixers	7 oz. Cartridge	50 Pack

## APPLICATION:

### FOR USE WITH PLASTIC REPAIR REINFORCING TAPE:

1. Clean surface as outlined in Preparation section.
2. Sand with 80 grit paper 2-3 inches around damaged area. "V" groove damaged area with a 24-36 grit disc at low RPM so as not to overheat or melt the plastic. Blow off dust and clean again with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.
3. Lay **Plastic Repair Reinforcing Tape** on the back side of the repair.
4. Dispense **Non-Sag Fast Set Adhesive** over the **Plastic Repair Reinforcing Tape** and spread firmly 2-3 inches beyond repair.
5. Proceed with the appropriate **Dual-Mix** repair material or **Carbo-Fill+**.

## APPLICATION

### GENERAL PURPOSE BONDING:

1. Clean surface as outlined in Preparation section.
2. Sand painted areas to be bonded with 180 grit paper and clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.
3. For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied.

### IMPORTANT:

Do not allow **Non-Sag Fast Set Adhesive** to flow over masked area or onto painted surface.

4. Apply **Non-Sag Fast Set Adhesive** to surface to be bonded.
5. Hold or clamp firmly. Repair piece will be securely bonded in 30 minutes. Allow another 30 minutes for full cure.

### Note:

For smaller repairs, use 1 oz. **Mini-Max General Purpose Adhesive**.

## STORAGE:

**Non-Sag Fast Set Adhesive** should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Non-Sag Fast Set Adhesive** is 2 years when stored under normal conditions.



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## RELATED PRODUCTS:

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	Aerosol
38354	Plastic & Leather Prep	Quart
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart
40542	Carbo-Fill+	Tube
68432	Mini-Max General Purpose Adhesive	1 oz. Tube
70006	Plastic Repair Reinforcing Tape	36' Roll
70011	Integral Nut Static Mixers	6 Pack
70012	Integral Nut Static Mixers	50 Pack
70039	Universal Pneumatic Applicator	Each
71119	Universal Manual Applicator	Each

### Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

#### Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.