

URETHANE FOR PLASTIC REPAIR

Urethane adhesives provide 3,500+ PSI Lap shear strength and perform well at higher temperatures. Urethanes work with most repair applications and are sandable. They are recommended for most plastic repair jobs.

DURABLE:	Stronger than the original plastics
100% SOLIDS:	No shrinkage
SANDS GREAT:	Undetectable feather edge
FAST:	Sandable in as little as 5 minutes



Adhesion Promoter

No need to identify plastic type – just simply apply to all plastics once, no need to re-apply. Allow for a 10 minute flash time.



PART #	DESCRIPTION	SIZE
636425 04625	Aerosol	333 g

Applications:

- No plastic identification required.
- Use with urethane adhesives on plastic parts.



SpeedGrip 45 seconds

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS.

- Perfect to join pieces which cannot be clamped in place, simply hold the pieces in place for 20 seconds



SpeedGrip 1 minute

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand
- Will not lift or roll up

PART #	SIZE	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME
636425 04647	(220 ml)	30 seconds	45 seconds	2-1/2 minutes	5 - 7 minutes
636425 97122*	(50 ml)	30 seconds	45 seconds	2-1/2 minutes	5 - 7 minutes

* 2,000 PSI Lap shear strength

Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

PART #	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
636425 04615	1 minute	1-1/2 minutes	7 minutes	12 - 20 minutes	1 hour

Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

Times will increase as temperatures decrease.

Times shown above are at 70°F/21°C.

Full cure time is 24 hours but this may be accelerated with heat.

SpeedGrip adhesives **SHOULD NOT** be used for bonding structural components such as rails, pillars, rocker panels, core supports, etc. If in doubt as to what is a structural component, contact the vehicle manufacturer.

DO NOT APPLY POLYESTER BASED FILLERS (POLYESTER PUTTY/FILLER) TO ANY URETHANE SPEEDGRIP ADHESIVE. IF POLYESTER BASED FILLER MUST BE USED, THE URETHANE SPEEDGRIP MUST BE SEALED WITH ONE OF THE FOLLOWING PRIMERS: 2 part epoxy or 2 part urethane. Or you can use Skim-Plus #06400 to finish the repair directly over the SpeedGrip.

All are 220 ml, except #97122, which is 50 ml.

URETHANE FOR PLASTIC REPAIR (CONT.)



SpeedGrip 5 minutes

Two-part urethane (1:1) adhesive used for structural and cosmetic repairs of all plastic bumpers, bumper tabs, emblems, door trims, interior and exterior plastic repairs and cosmetic repairs including TPE, TPO, TEO, PP and ABS and can also be used to bond SMC or fiberglass panels.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand to a feather edge
- Good for elevated temperatures
- Will not lift or roll up
- Accelerate cure with heat (3 min @ 140°F)



SpeedGrip 15 minutes

Two-part urethane (1:1) adhesive used for installation of hood panels, roof panels, fenders, fender liners, fairings, spoilers, wind deflectors, cab extenders, ground effects, headlamp buckets and other body panels. For bonding fiberglass, SMC, carbon fiber and other plastics to itself and to primed metal.

- One product for all structural and cosmetic repairs on bumpers
- Work window allows for larger repairs
- Perfect for elevated temperatures
- Easy to sand to a feather edge
- Accelerate cure with heat (10 min @ 140°F)

PART #	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
636425 04616	5 minutes	7 minutes	15 minutes	45 minutes	2 hours

Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

PART #	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
636425 04617	15 minutes	20 minutes	45 minutes	90 minutes	3 hours

Applications:

- Bonds composite materials to itself or to coated metals.

EPOXY FOR PANEL BONDING



Impact Toughened Structural Adhesive

Two-component epoxy structural adhesive for use in automotive bonding applications. Adheres to a wide variety of properly prepared substrates including steel and aluminum. The Impact Toughened Structural Adhesive has an extended work time for large applications, but can be accelerated with applied heat.

- Optimum impact strength than traditional structural adhesives
- Can be used in weld bonded or rivet bonded OEM applications
- Outstanding performance in extreme temperatures (-40°F through 140°F)
- Consistent bond line thickness contained by glass beads



GM: Impact-resistant joint repair



To view a step-by-step video for **Impact Toughened** go to:
<http://nortonsga.us/applyspeedgr>

PART #	WORK TIME	CLAMP TIME	SANDING TIME	PAINT / CURE TIME
636425 06427	90 minutes	10 hours	N/A	N/A

Applications:

- Repair structural components, reinforcements and body rails.

For use on outer body panels only. Not for use on structural components such as pillars, frame rails, core supports, or rocker panels (on unibody vehicles).

Times will increase as temperatures decrease. Times shown above are at 77°F/25°C. Full cure time is 24 hours, but this may be accelerated with heat.

RESISTANCE SPOT WELDING: Norton recommends resistance welding through Multi-Bonding Adhesives in a wet state only with little to no burn back.

MIG WELDING: Multi-Bonding Adhesive CANNOT be in the weld area or burn back will occur. Norton recommends at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.