

PRODUCT FEATURES & APPLICATION

Dominion Sure Seal Ltd.

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XSM 11002 – 2 Part Epoxy Small Panel Adhesive

Stock: XSM11002 (207 ML) Part # 11002

Color: Black

Description: XSM11002 – 2 Part Epoxy Small Panel Adhesive is a multi usage repair & bonding epoxy paste. XSM11002 is designed for use as a small panel bonding adhesive. XSM 11002 provides incredible strength with good sandability. XSM11002 is suitable for all Non- Structural Panel-Bonding applications of Metal, Aluminum, Fiberglass and SMC. Some areas of use include: Cab Corners, Door Skins, Small Panels, Small Quarter Panels, and Rust Panels. This is one of the highest strength Small Panel Repair Adhesives available in the market today.

* Dominion Sure Seal Ltd utilizes OEM recommendations for panel bonding and roof replacements, in conjunction with welding.

Features:

- Can be used on Plastic, Metal, Aluminum, SMC, Fiberglass, Wood and most other substrates
- High strength
- Fast Unclamp times
- Bonds and seals seams simultaneously
- Reduces conventional welding, and related hazards
- Saves shop labor costs
- Can be accelerated with heat

Technical Properties:

Lap Shear Strength 2720 psi
Shore Hardness D 60

Properties listed below are at 72° F. (21° C.) using a 1/4” extruded bead.

Work time	15-18 minutes
Set /Unclamp	60-90 minutes
Full Cure @ 72° F. (21° C.)	24-48 hours

Clamps may be removed from the panel in 60 to 90 min at 72° F. (21° C.), however if the temperature is lower than 72° F. or there is any tension on the part additional cure time is required. Cure time may be accelerated with heat. Allow a min. of 12 hours before returning the car back to the customer.

Bonding instructions (panels):

- 1) Remove all paint and rust from surface to be bonded using 50 to 80 grit sand paper.
- 2) Straighten all metal and “pre fit” the replacement part.
- 3) Clean area to be bonded with Sure Solv (BSS/SUS). If applying to SMC/Fiberglass go to step #4.
 - Metal and Aluminum – spread adhesive over the entire bare metal bond line area on the car and replacement part to ensure corrosion protection within the bond area. This is to be done during the application of adhesive step #6.
- 4) Place cartridge into T221 dispensing gun, purge cartridge, attach mixer
- 5) Purge a minimum of 1 mixer length to assure an even mix and discard.
- 6) Apply approx. a 3/16-1/4 inch bead of adhesive to the area to be bonded. On metal and aluminum spread the adhesive over the entire bare metal bond line area on both the car and the replacement part.
- 7) Clamp panel into position and tool any adhesive squeeze out to provide a sealed seam along outside edge of bonded panel.
- 8) If bonding metal - Weld appropriate areas while the adhesive is still wet
- 9) Let cure. Cure times can be accelerated with heat. While curing reapply anti corrosion material (ASS512C).

* Please See “Instructions for Panel Bonding” for more detailed instructions.