

PRODUCT FEATURES & APPLICATION

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XSM 2002 – 2 Part Medium Urethane

Repair/Plastic Repair Adhesive

Stock XSM 2002 (207 mL Cartridge)

Finished Color: Black

Description: XSM 2002 is a 2 part Medium Urethane Adhesive. XSM2002 is designed for Bumper Repair and Plastic Repair. This unique product is designed for fast repairs and reinforcement on all plastics, including TPO, PP and other “olefin” plastics. XSM 2002 can be used to repair plastics, reinforce plastics and bond plastic components. Some examples are: bonding of plastic bumper brackets, replacement of bumper tabs, reinforcing the backside of a plastic repair, bonding of SMC/Fiberglass backer panels to SMC/Fiberglass panels, and many others. XSM2002 is a 100% solids Urethane with excellent bond strength, and excellent featheredging characteristics with no pin holing. XSM 2002 is compatible with Dominion Sure Seal epoxy repair materials and all automotive topcoats.

Features:

- Multi Purpose – Works on all Flexible and Semi Rigid Bumpers
- Bonds SMC and Fiberglass
- Compatible with all Automotive Plastics
- Fast Sand times
- Excellent shelf life
- 100% solids/VOC FREE

Surface Preparation:

1. Wash the repair area with soap and water. Allow to dry.
2. Clean repair area with SPPV (Panel Prep) by applying the cleaner to a rag and wiping the surface thoroughly. Allow to dry.
3. Sand the back side of the area to be repaired with 80 grit sandpaper. Sand the front of the repair with 80 grit sandpaper feathering the paint surrounding the repair area. Bevel (v-groove) the damaged repair line on the front side of the plastic to be repaired. On Bumpers - Adhesive Weld (XPSA) can be used to re-bond the repair line before V-grooving.
4. Blow off the sanding residue and re-clean using SPPV (Panel Prep) (See #2). Allow to dry.

Repair of Flexible and Semi-Rigid Plastic Bumpers:

1. Apply Adhesion Aid SXPP or XPPP to the bare prepped plastic on both the front and backside of the repair area. Allow to dry for a minimum of 10-15 min at 72 degrees (21 C).
2. Reinforce the backside of damage with Reinforcing Tape (XWT).
 - If reconstructing a tab – use XWT where adhesive is to be applied.
 - If reconstructing a missing part – use XWT for reinforcement in the reconstruction of the part

Technical Properties:

(Based on a ¼” bead at 72° F (21 C))

Work Time:	5-10 Min.
Sand & Paint Time	45 – 60 Min.
Full Cure Strength	3 Hours
Tensile Strength	1000
Elongation	200%

Lap Shear (after 48 hours cure @ 72 F (21 C))

TPUR	420 psi	substrate failure
PUR	730 psi	substrate failure
RIM	775 psi	substrate failure
TPO	390 psi	substrate failure
ABS	753 psi	substrate failure
Xenoy	801 psi	substrate failure
SMC	380 psi	substrate failure
FRP	740 psi	substrate failure
Steel	1850 psi	adhesive failure

Continued on page 2

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Repair of Flexible and Semi-Rigid Plastic Bumpers:

Cont.:

3. Insert the XSM2002 cartridge into the T221 dispensing gun. Remove any cap or plug. Purge a small amount of material to equalize the cartridge. Attach the mixer and tighten. Proceed to extrude 1 mixer length of material and dispose, to ensure a proper mix. Apply XSM2002 to the back side of the repair. Spread evenly over the repair area. Allow to dry before sanding, if needed.
 - If reconstructing a tab, you can use the inside of the XSM2002 bag as a contouring sheet. Apply the XSM2002 to the tab area and contour using the inside of the XSM2002 bag while the material is wet. Hold in place and allow the product to cool. After the product has cooled you can remove the bag and finish the reconstruction of the tab. On the front side of the tab sand thoroughly to prepare for finishing material. Example (epoxy skim coat)
 - If reconstructing a part, use the inside of the XSM2002 bag as a contouring sheet to help to mold the new piece while the adhesive is wet. Allow the adhesive to cool and remove the bag and continue to contour the new piece. If reconstructing a part, allow to cure. If sanding is necessary start with 80 grit followed by 180/220 grit sandpaper.
4. After spreading the appropriate material on the back side, go to the front side of the repair area and make sure your repair materials do not sit higher than the surrounding plastic. If so, while the material is wet, spread into the repair area.
5. If the material on the back side is allowed to cure you will need to scuff the material showing through on the front side for adhesion. If you scuff or clean the bare plastic, you will need to re-clean and re-apply the Adhesion Aid before proceeding.
6. Apply the proper repair material to the front side of the repair thoroughly covering the damaged area.
 - If using cartridge material (XEZC) - Insert the material into the dispensing gun. Remove any cap or plug. Purge a small amount of material to equalize the cartridge. Attach the mixer and tighten. Proceed to extrude 1 mixer length of material and dispose, to ensure a proper mix. Apply the material to the front side of the repair thoroughly covering the damaged area allow to dry.
 - If using squeeze tube material (XPST, XPSAP, XRF) squeeze equal parts of Part A and Part B onto a mixing board. Mix thoroughly. Avoid whipping materials during mixing. This can cause you to whip air into the materials. After mixing the materials thoroughly, spread over the front side of the repair thoroughly covering damaged area. Allow the materials to dry.
7. Sand to contour using 80 to 180 grit sandpaper.
8. If additional filling material is needed follow step #4 under surface preparation (re-clean –SPPV), #1 under Repair (Apply Adhesion Aid – apply on all bare plastic – front side.), # 6 Repair (Apply XEZC), and step #7 (Contour)
8. Finish sand with 180 to 220 grit sandpaper.
9. Blow off sanding residue and re-clean with SPPV (Panel Prep) Allow to dry. If any bare plastic is present apply a medium coat of SXPP (Adhesion Aid) and allow to dry for 10-15 min.
10. Prime surface with the appropriate Dominion Sure Seal primer, sand and Paint.