

PRODUCT FEATURES & APPLICATION

Dominion Sure Seal Ltd.

6175 Danville Road, Mississauga, Ontario, Canada L5T 2H7

TEL (905) 670-5411

FAX (905) 670-5174

XSM 5002 - 2 Part Epoxy Medium Panel Adhesive

Stock: XSM5002 (207 mL Cartridge)

Color: Gray/White

Description: XSM5002 Medium Panel Adhesive is a strong multi usage, glass sphere filled epoxy adhesive that provides a superior bond and also seals the panel your bonding. XSM5002 is suitable for all Non-Structural Panel Bonding applications of Metal, Aluminum, Fiberglass and SMC. Some areas of use include: Door Skins, Fenders, Quarter Panels, Cab Corners, Small and Medium Sized Panels. XSM5002 can be used to bond all Non-Structural Panels that you will need an adhesive with an optimal work time of 50-55 min at 72° F (22° C) The special glass spheres in XSM5002 assist you in obtaining the proper bond line thickness providing you excellent results every time.

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

Features:

- High strength
- Optimal work time: 50-70 min @ 72° F (22° C)
- Easy Sanding
- Bonds and seals seams simultaneously
- Build in Spacer to assist in obtaining the proper bond line thickness
- Multi purpose - Can be used on Metal, SMC and Fiberglass and Aluminum
- Weld Thru when wet
- Reduces conventional welding, and related hazards
- Saves shop labor costs
- Can be accelerated with heat

Technical Properties:

Lap Shear Strength

Steel: 2386 psi

Hardness, Shore D 77

Properties listed below are at 72° F (22° C) using a 1/4" extruded bead.

Work time 50 - 70 minutes

Set/unclamp 3 ½ to 4 hours

Return to service 24 - 36 hours

Paint 1 hour

Full Cure 36 - 48 hours

All times listed may be accelerated with heat.

Clamps may be removed from the panel in 3 ½ to 4 hours at 72° F (22° 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 minimum of 24 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 working on 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 done during the application of the adhesive. See 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.