

PRODUCT FEATURES & APPLICATION

Dominion Sure Seal Ltd.

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XSM6002 – All Purpose Fast Urethane Adhesive

Stock: XSM6002 (207 ML Cartridge)

Color: Black

Description: XSM6002 – All Purpose Fast Urethane Adhesive is designed for fast repairs where a work time of 1- 2 minutes is desired. XSM6002 can be used as a fast set general bonder or a fast set repair material (work time 1-2 min.) on metal, automotive plastic and SMC/fiberglass. This specially formulated product works on all automotive plastics including the “tough to bond” plastics TPO, PP and PE. This products compatibility makes this product a perfect choice for use as a reinforcement material on all automotive plastics. We have now taken the guess work out of plastic repairs. Some areas of use on plastics include: bonding/repair of bumper tabs, bonding of bumper brackets, reinforcement of the back side of a plastic repair, bonding of SMC/Fiberglass backer panels, bonding or reinforcing broken SMC/Fiberglass pieces, bonding cracked head light buckets, repairing of grills, and general quick repairs to most broken plastic pieces. Some areas of use as a general bonder include: bonding of emblems, body side moldings, belt moldings (usually in place of a broken clip), bonding of an exterior side mirror glass to the plastic housing, bonding of decorative plastic pieces, ground effects, and the repair of stripped out threads. XSM6002 is a 100% solids Urethane, has excellent bonding strength, and excellent featheredging characteristics with no pinholing. XSM6002 is also compatible with Dominion Sure Seal epoxy repair materials and all automotive primers.

Features:

- Fast Set (1-2 min. work time)
- Fast Sanding
- Unique Formulation – Compatible with All Automotive Plastics
- Multi Purpose – Bonds/Repairs/Fills
- Can be used on Metal, Automotive Plastic, SMC/Fiberglass

Typical Properties:

(Based on a ¼” bead at 72° F (21 C)

Work Time:	1-2 Min.
Sand Time:	8 -15 Min.
Full Cure Strength:	1 Hours
Elongation:	50%
Shore Hardness D	68

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

*Plastic primed with SXPP (Adhesion Aid)

*TPUR	295 psi	substrate failure
*PUR	315 psi	substrate failure
*RIM	525 psi	substrate failure
*TPO	267 psi	substrate failure
*ABS	505 psi	substrate failure
*Xenoy	417 psi	substrate failure
SMC	380 psi	substrate failure
FRP	640 psi	substrate failure
Steel	1850 psi	

Cartridge Preparation: This step is to be done right before the material is to be used. The dwell time of the adhesive in the mixer is approx. 1-2 min. @ 72° F (21° C)

1. Insert the XSM6002 cartridge into a 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.

Plastic instructions – 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/taper) 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 SPD (Citrus Base Panel Prep) (See #2). Allow to dry.

Repair of Flexible and Semi-Rigid Plastic Bumpers:

1. Apply Adhesion Aid SXPP24 or XPPPQ 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). Do not use this step on Fiberglass/SMC
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

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3. Cartridge Preparation – See Above.
4. Apply XSM6002 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 XSM6002 bag as a contouring sheet. Apply the XSM6002 to the tab area and contour using the inside of the XSM6002 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 XSM6002 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 appropriate repair materials) 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 SXPP24 (Adhesion Aid) and allow to dry for 10-15 min.
10. Prime surface with the appropriate Dominion Sure Seal primer, sand and Paint.

SMC/Fiberglass:

1. If repairing Fiberglass or SMC follow all the above steps except step 1 (Apply Adhesion Aid) under Repair of Flexible and Semi Rigid Plastic Bumpers
 - * Adhesion Aid is not recommended on SMC and Fiberglass

Bonding:

(Works for small Patch/backer Panels, SMC/Fiberglass Panels, and general quick bonding.)

1. Remove all loose paint, sand area (80 grit paper) on both surfaces to be bonded, Clean both surfaces with Dominion Sure Seal Solv. (BSS) or Dominion Sure Seal Panel Prep (SPPV)
2. Pre-fit part to be bonded
3. Purge and apply adhesive. (Cartridge Preparation)
4. Clamp to let cure.
5. See “Instructions for Panel Bonding” for more details

*Call your local Dominion Sure Seal Jobber for more details.