

PRODUCT FEATURES & APPLICATION

Dominion Sure Seal Ltd.

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XSM 7002 - 2 Part Epoxy Large Panel Adhesive

Stock: XSM7002 (207 ML)

Color: Med Gray/White

Description: XSM7002 Large Panel Adhesive is a strong multi usage, glass sphere filled epoxy adhesive that provides a superior bond and also seals the panel your bonding. XSM7002 is suitable for all Non-Structural Panel Bonding applications of Metal, Aluminum, Fiberglass and SMC. Some areas of use include: Door Skins, Roof Skins, Fenders, Quarter Panels, Cab Corners, Medium and Large sized panels. XSM7002 can be used to bond all Non-Structural Panels that you will need an adhesive with an optimal work time of 85-90 min. at 72° F. (21° C.) The special glass spheres in XSM7002 help you to obtaining the proper bond line thickness providing you excellent results.

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

Features:

- High strength
- Optimal work time (85-90 min. 72° F.)(21° 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, Aluminum, SMC and Fiberglass.
- 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: 2902 psi

Shore Hardness D 77

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

Work time 85 - 90 minutes

Set/Unclamp 4 ½ to 5 hours

Return to service 30 - 36 hours

Paint 1 Hour

Full Cure @ 72° F. (21° C.) 36 - 48 hours

All times listed may be accelerated with heat.

Clamps may be removed from the panel in 4 ½ to 5 hours 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 30 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 – 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.