



PRODUCT DATA

1132

Structural & Metal Bonding Adhesive (15 minute)

DESCRIPTION:

Transtar's Structural & Metal Bonding Adhesive is a two part non-sag structural adhesive formulated to dry in 15 minutes for small patch repairs, door skins and compact vehicle replacement panels. This product forms a tough, high strength, high impact resistant bond. It is formulated to bond thermoplastics, thermosets, composites and metal structural elements together in any combination. Structural & Metal Bonding Adhesive is formulated as a non-sag, creamy gel with balanced viscosity for both parts and is easy to dispense through the included static mixer.

TECHNICAL DATA:

APPEARANCE:	Part A - Off white, Part B - Amber
MIX RATIO:	1:1
OPEN/WORK TIME:	15 minutes
FIXTURE TIME:	25 - 35 minutes
FULL CURE TIME:	24 hours
HARDNESS:	70D
ELONGATION:	>20%
FLASH POINT (LCC):	51°F
OPERATING TEMP RANGE:	-40°F - 275°F
SHELF LIFE:	6 months (unopened)

BONDING TEST DATA: (TENSILE SHEAR STRENGTH USING ASTM TEST METHOD D1002)

(Prep Steps: Substrates were wiped with a cleaner/degreaser.)

<u>Substrate</u>	<u>Results</u>
Steel to Steel	>3500 psi
Aluminum to Aluminum	>3000 psi
PPO to HIPS	Substrate Failure*
Fiberglass to Fiberglass	Substrate Failure*
PVC to PVC	Substrate Failure*
SMC to SMC	Substrate Failure*
ABS to ABS	Substrate Failure*

* Substrate failure = Substrate breakdown prior to bond failure. (Area around bonded surfaces failed before the adhesive repair gave way).

SALES POINTS:

- Outstanding curability and dependability
- Non-sag formula
- Easy to use
- High strength, high impact resistant bond
- Bonds a wide range of substrates

SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS

(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.)

PACKAGE SIZE:

#1132 Structural & Metal Bonding Adhesive (15 minute), 300 ml cartridge, 6/case



Structural & Metal Bonding Adhesive (15 minute)

IMPACT STRENGTH:

Steel to Steel, Aluminum to Aluminum,
ABS to ABS, Auto Side Impact >9.5ft lbs/ft² (21KU/m² stops hammer at 72°F)

PEEL STRENGTH:(ASTM T PEEL TEST METHOD, NO ABRASION)

Impact test at cold and hot temperatures
for steel to steel 34 pli at -60°F 27 pli at 300°F

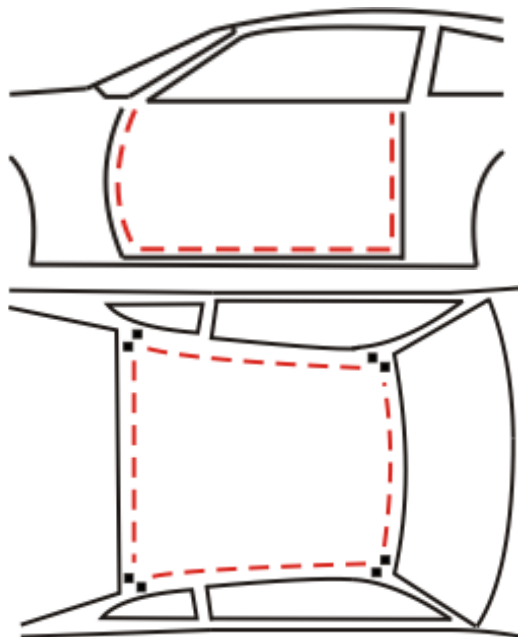
CHEMICAL RESISTANCE:

Excellent resistance to common service environments such as salt fog, water, gasoline, diesel fuel, antifreeze, hydraulic fluids and cutting oils. **NOT RECOMMENDED FOR CONTINUOUS EXPOSURE TO:** Crude Oil, Toluene, MEK, Acetone, Aldehydes and Ketones.

Note : For best results, test product for suitability for environment.

APPLICATION:

1. Remove all paint, primer, corrosion and rust from the surface to be bonded using 36 grit abrasive disc. When preparing aluminum surfaces use 80 grit abrasive disc.
2. Clean areas to be bonded with SCAT #6311, Speedi SCAT #6321/6323, or Aqua SCAT #6351/6354. Other cleaner may leave a film and prevent bonding.
3. Load #1132 cartridge into #4450 Dual Mix Gun. Remove end plugs and attach the static mixer nozzle (included in package). Attach the static mixer nozzle to the cartridge, slide on the mixer nut, and then tighten. Gun the material until both parts (A & B) are equally flowing from the cartridge. Prior to applying adhesive, dispense a bead of the adhesive approximately the length of the mixer to ensure a proper mix.
4. Apply adhesive to both mating surfaces. Using a spreader, tool out the adhesive to ensure all base metal surfaces are coated.
5. Secure panels using clamps. The adhesive contains glass beads to prevent over clamping and to provide a consistent bondline. Use screws or rivets in hard to clamp areas. If repositioning is needed, slide the panels rather than removing and reapplying. Tool any adhesive squeezed out to seal the bonded edge.
6. Allow adhesive to cure for 25 - 35 minutes before handling or declamping.



DOOR SKINS:

Follow vehicle manufacturer's replacement procedures to prepare the door frame and service panel for replacement. Adhesive may be used on the entire replacement panel. Follow #1132 directions for surface preparation and applying adhesive.

ROOF PANELS:

Follow vehicle manufacturer's replacement procedures to prepare the service panel for replacement. Leave a space of two inches at each of the four corners to allow for two plug welds or a two inch lap weld. Keep Weld Through Primer #4353 and welding a minimum of 2" from the adhesives as it is combustible when cured and will burn. Use adhesive around entire perimeter of the roof and on the roof bows if applicable. Follow #1132 directions for surface preparation and applying adhesive. NOTE: On extended length van roof panels, 2 - 3 extra plug welds should be placed evenly in each side of the roof panel.

Adhesive Area - - - - -

Welding Area ■ ■ ■ ■ ■

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.