

PRODUCT FEATURES & APPLICATION



Dominion Sure Seal Ltd.

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XSM 5002 - 2 Part Epoxy Medium Panel Adhesive

Stock: XSM5002 (200 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, 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 45-55 min. at 75° 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 (45-55 min. 75° 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.
- 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: 2153 psi

Shore Hardness D 80

Elongation 10-15%

Properties listed below are at 75° F. (22° C.) using a 1/4" extruded bead.

Work time 45 - 55 minutes

Set 4 hours

Hard 5 - 6 hours

Paint 1 Hour

Full Cure @ 75° F. (22° C.) 36 - 48 hours

All times listed may be accelerated with heat.

Clamps may be removed from the panel in 3-4 hours at 75° F. (22° C.), however if the temperature is lower than 75° 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 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 36 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).
- 4) Place cartridge into T202 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 – apply the adhesive to both the replacement part and on the vehicles bond line area. Spread the adhesive over the entire bare metal bond line area on both the car and the replacement part. This is to ensure corrosion protection within the bond line area.
- 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.