



## ONE LINE DOES IT ALL PUT NORTON TO THE TEST

Whether you're working on steel, aluminum, SMC, FRP, fiberglass, rigid plastic, semi-rigid plastic, flexible plastic or panel bonding, our full line of Norton SpeedGrip Structural Adhesives gets the job done.

- Acrylic Adhesives
- Urethane Adhesives
- Epoxy Adhesives
- Epoxy Seam Sealers
- Foams
- Accessories

**QUALITY THAT PAYS™**

# ACRYLIC FOR METAL BONDING

2,500 PSI Lap shear strength makes acrylic adhesives one of the strongest available. It remains flexible and performs well at extremely low temperatures. Acrylic is the best choice for metal-to-metal bonding. For optimal results, grind the panel to bare metal.

|                         |  |
|-------------------------|--|
| <b>GUARANTEED:</b>      | Norton SpeedGrip acrylic adhesives provide a lifetime corrosion and performance warranty   |
| <b>PRODUCTIVE:</b>      | Reduce repair time versus welding, seals and bonds in one application and de-clamp in as little as 90 minutes  |
| <b>PRECISE CONTROL:</b> | Glass bead technology allows for correct panel spacing and perfect bond control  |
| <b>VERSATILE:</b>       | Bonds a variety of substrates: automotive grade cold-rolled steel, galvanized steel, e-coat, aluminum and stainless steel with minimal surface preparation |



## Metal Door Skin Bonding Adhesive

Two-part acrylic (2:1) for panel bonding of door panels, other body sheet metal, steel and aluminum.

- Bonds door panels to door frames without welding
- Guaranteed corrosion protection



Meets Ford WSS-M2G410-A2 and GM6449G Metal Bonding Specifications



## Metal Panel/Weld Bonding Adhesive

Two-part acrylic (2:1) for panel bonding and weld bonding of quarter panels, rear body panels, roof panels, door panels, van side panels and outer truck bed panels on bare metals, including aluminum.

- Long work time 75 minutes for bonding large areas
- Guaranteed corrosion protection
- Perfect for high temperatures



Meets Chrysler MS-CD507 Metal Bonding Specification

| PART #       | WORK TIME  | CLAMP TIME  | CURE TIME |
|--------------|------------|-------------|-----------|
| 636425-06419 | 45 minutes | 1-1/2 hours | 8 hours   |

### Applications:

- Bonding of patch panels and trailer side wall sections, etc.
- Bonding of exterior body panels including door panels, quarter panels, roof panels, etc.
- Can be used to weld and/or rivet bond structural or non-structural body panels. Follow OEM procedures.

| PART #       | WORK TIME  | CLAMP TIME  | CURE TIME |
|--------------|------------|-------------|-----------|
| 636425-06420 | 75 minutes | 2-1/2 hours | 8 hours   |

### Applications:

- Bonding of exterior body panels including door panels, quarter panels, roof panels, etc., when an extended working time is needed.
- Can be used to weld and/or rivet bond structural or non-structural body panels. Follow OEM procedures.



Scan this QR code with your smartphone to view a step-by-step video for **Metal Bonding**

## TECH TIP

After clamping, wipe any excess adhesive off the panel while wet.

Times will increase as temperature decreases.

Times shown above are at 70°F/21°C.

SpeedGrip adhesives **SHOULD NOT** be used for bonding structural components such as rails, pillars, rocker panels, core supports, etc. If in doubt as to what is a structural component, contact the vehicle manufacturer.

**RESISTANCE SPOT WELDING:** Norton recommends resistance welding through Metal Bonding Adhesives in a wet or cured state with no burn back.

**MIG WELDING:** Norton Adhesive **CANNOT** be in the weld area or burn back will occur. Norton recommends at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.

# URETHANE FOR PLASTIC REPAIR

Urethane adhesives provide 3,500+ PSI Lap shear strength and perform well at higher temperatures. Urethanes work with most repair applications and are sandable. They are recommended for most plastic repair jobs.

|                     |                                     |
|---------------------|-------------------------------------|
| <b>DURABLE:</b>     | Stronger than the original plastics |
| <b>100% SOLIDS:</b> | No shrinkage                        |
| <b>SANDS GREAT:</b> | Undetectable feather edge           |
| <b>FAST:</b>        | Sandable in as little as 5 minutes  |



## Adhesion Promoter

SpeedGrip Adhesion Promoter is available in both aerosol and brush top. No need to identify plastic type – just simply apply to all plastics once, no need to re-apply. Allow for a 10 minute flash time.

### Applications:

- No plastic identification required.
- Use with urethane adhesives on plastic parts.



| PART #               | DESCRIPTION | SIZE   |
|----------------------|-------------|--------|
| 636425- <b>04624</b> | Brush Top   | 118 ml |
| 636425- <b>04625</b> | Aerosol     | 333 g  |



## SpeedGrip 45 seconds

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS.

- Perfect to join pieces which cannot be clamped in place, simply hold the pieces in place for 20 seconds



## SpeedGrip 1 minute

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand
- Will not lift or roll up

| PART #                | SIZE     | OPEN TIME  | WORK TIME  | HANDLING TIME | SANDING TIME  |
|-----------------------|----------|------------|------------|---------------|---------------|
| 636425- <b>04647</b>  | (220 ml) | 30 seconds | 45 seconds | 2-1/2 minutes | 5 - 7 minutes |
| 636425- <b>97122*</b> | (50 ml)  | 30 seconds | 45 seconds | 2-1/2 minutes | 5 - 7 minutes |

\* 2,000 PSI Lap shear strength

### Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

| PART #               | OPEN TIME | WORK TIME     | HANDLING TIME | SANDING TIME    | PAINT TIME |
|----------------------|-----------|---------------|---------------|-----------------|------------|
| 636425- <b>04615</b> | 1 minute  | 1-1/2 minutes | 7 minutes     | 12 - 20 minutes | 1 hour     |

### Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

Times will increase as temperatures decrease.

Times shown above are at 70°F/21°C.

Full cure time is 24 hours but this may be accelerated with heat.

SpeedGrip adhesives **SHOULD NOT** be used for bonding structural components such as rails, pillars, rocker panels, core supports, etc. If in doubt as to what is a structural component, contact the vehicle manufacturer.

DO NOT APPLY POLYESTER BASED FILLERS (POLYESTER PUTTY/FILLER) TO ANY URETHANE SPEEDGRIP ADHESIVE. IF POLYESTER BASED FILLER MUST BE USED, THE URETHANE SPEEDGRIP MUST BE SEALED WITH ONE OF THE FOLLOWING PRIMERS: 2 part epoxy or 2 part urethane. Or you can use Skim-Plus #06400 to finish the repair directly over the SpeedGrip.

All are 220 ml, except #97122, which is 50 ml.

## URETHANE FOR PLASTIC REPAIR (CONT.)



### SpeedGrip 5 minutes

Two-part urethane (1:1) adhesive used for structural and cosmetic repairs of all plastic bumpers, bumper tabs, emblems, door trims, interior and exterior plastic repairs and cosmetic repairs including TPE, TPO, TEO, PP and ABS and can also be used to bond SMC or fiberglass panels.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand to a feather edge
- Good for elevated temperatures
- Will not lift or roll up
- Accelerate cure with heat (3 min @ 140°F)



### SpeedGrip 15 minutes

Two-part urethane (1:1) adhesive used for installation of hood panels, roof panels, fenders, fender liners, fairings, spoilers, wind deflectors, cab extenders, ground effects, headlamp buckets and other body panels. For bonding fiberglass, SMC, carbon fiber and other plastics to itself and to primed metal.

- One product for all structural and cosmetic repairs on bumpers
- Work window allows for larger repairs
- Perfect for elevated temperatures
- Easy to sand to a feather edge
- Accelerate cure with heat (10 min @ 140°F)

| PART #               | OPEN TIME | WORK TIME | HANDLING TIME | SANDING TIME | PAINT TIME |
|----------------------|-----------|-----------|---------------|--------------|------------|
| 636425- <b>04616</b> | 5 minutes | 7 minutes | 15 minutes    | 45 minutes   | 2 hours    |

#### Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

| PART #               | OPEN TIME  | WORK TIME  | HANDLING TIME | SANDING TIME | PAINT TIME |
|----------------------|------------|------------|---------------|--------------|------------|
| 636425- <b>04617</b> | 15 minutes | 20 minutes | 45 minutes    | 90 minutes   | 3 hours    |

#### Applications:

- Bonds composite materials to itself or to coated metals.

## EPOXY FOR PANEL BONDING



### Impact Toughened Structural Adhesive

Two-component epoxy structural adhesive for use in automotive bonding applications. Adheres to a wide variety of properly prepared substrates including steel and aluminum. The Impact Toughened Structural Adhesive has an extended work time for large applications, but can be accelerated with applied heat.

- Optimum impact strength than traditional structural adhesives
- Can be used in weld bonded or rivet bonded OEM applications
- Outstanding performance in extreme temperatures (-40°F through 140°F)
- Consistent bond line thickness contained by glass beads



GM: Impact-resistant joint repair

| PART #               | WORK TIME  | CLAMP TIME | SANDING TIME | PAINT / CURE TIME |
|----------------------|------------|------------|--------------|-------------------|
| 636425- <b>06427</b> | 90 minutes | 10 hours   | N/A          | N/A               |

#### Applications:

- Repair structural components, reinforcements and body rails.

For use on outer body panels only. Not for use on structural components such as pillars, frame rails, core supports, or rocker panels (on unibody vehicles).

Times will increase as temperatures decrease. Times shown above are at 77°F/25°C. Full cure time is 24 hours, but this may be accelerated with heat.

RESISTANCE SPOT WELDING: Norton recommends resistance welding through Multi-Bonding Adhesives in a wet state only with little to no burn back.

MIG WELDING: Multi-Bonding Adhesive CANNOT be in the weld area or burn back will occur. Norton recommends at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.



# EPOXY FOR PANEL BONDING (CONT.)



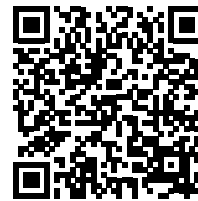
## Epoxy Panel-Bonding Adhesive

Two-part epoxy adhesive designed to bond SMC, FRP, fiberglass, steel and aluminum auto parts and body panels to each other and to metal frames (no primer required).

- Minimal odor
- Glass beads for proper spacing
- Easy to sand formulation
- Paintable
- Seals and bonds in one step



Scan this QR code with your smartphone to view a step-by-step video for **Structural Plastic Repair**



Scan this QR code with your smartphone to view a step-by-step video for **Cosmetic Plastic Repair**

| PART #               | WORK TIME  | CLAMP TIME | SANDING TIME | PAINT / CURE TIME |
|----------------------|------------|------------|--------------|-------------------|
| 636425- <b>06418</b> | 30 minutes | 2 hours    | 3 hours      | 24 hours          |
| 636425- <b>06421</b> | 90 minutes | 4 hours    | 8 hours      | 24 hours          |

# EPOXY FOR SMC/PLASTIC REPAIR

Epoxy adhesives work well at both high and low temperatures, have shear strength of 3,000 PSI and perform well filling gaps. Ideal for undetectable SMC repairs, plus they can be used with most other collision repair applications.



## Plastic Repair Skim-Plus

Two-part epoxy (1:1) used to repair most plastic parts, including bumper covers and other plastic body panels including PP, fiberglass, Metton®, Telene®, SMC, TE0 and urethane. Formulated to finish the front side of flexible repairs or used over the top of urethane adhesives.

- Incredibly easy to sand in 20 minutes or less
- No plastic ID required
- No adhesion promoter needed
- Mix with spreader



## Cosmetic Repair Skim-Plus+

Two-part epoxy (1:1) designed for repair of surface imperfections, scratches and gouges on all plastic bumpers and body panels, including such plastics as PP, fiberglass, Metton®, Telene®, SMC, TE0 and urethane. Cosmetic Repair Skim-Plus+ is a longer open time finishing adhesive, ideal for applications during hot weather when Plastic Repair Skim-Plus adhesive may harden too fast.

- No plastic ID required
- No adhesion promoter needed
- Mix with spreader

| PART #               | WORK TIME   | CLAMP TIME | SANDING TIME  | PAINT TIME | CURE TIME  |
|----------------------|-------------|------------|---------------|------------|------------|
| 636425- <b>06400</b> | 1-2 minutes | —          | 15-20 minutes | 60 minutes | 60 minutes |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.

| PART #               | WORK TIME     | CLAMP TIME | SANDING TIME  | PAINT TIME | CURE TIME  |
|----------------------|---------------|------------|---------------|------------|------------|
| 636425- <b>06111</b> | 15-17 minutes | —          | 50-60 minutes | 60 minutes | 60 minutes |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.



## SMC/Fiberglass Repair Adhesive

Two-part epoxy (1:1) used for structural and cosmetic repair of all types of rigid body plastics such as SMC, GTX, fiberglass, Metton® and carbon fiber.

- One product for all rigid body panels
- Sands very easily
- Will not lift or roll up
- No read-through and zero shrinkage



Ford: SMC panel repair  
GM: SMC panel repair



## Repair and Filler

Two-part epoxy (1:1) used for cosmetic repairs on both flexible and rigid parts. Adhesion Promoter must be used on plastic parts. Work time is 5 minutes and it can sanded in 15-30 minutes. It sands easily and feathers well.

- Incredibly easy to sand in 30 minutes or less
- Use adhesion promoter on plastic parts
- Feathers well
- Mix with spreader

| PART #               | WORK TIME  | CLAMP TIME               | SANDING TIME       | PAINT TIME         | CURE TIME          |
|----------------------|------------|--------------------------|--------------------|--------------------|--------------------|
| 636425- <b>06417</b> | 40 minutes | 3 hours (10 min @ 180°F) | 10 minutes @ 180°F | 60 minutes @ 180°F | 60 minutes @ 180°F |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.

| PART #               | WORK TIME | CLAMP TIME | SANDING TIME  | PAINT TIME    | CURE TIME |
|----------------------|-----------|------------|---------------|---------------|-----------|
| 636425- <b>06412</b> | 5 minutes | —          | 15-30 minutes | 15-30 minutes | 6-8 hours |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.

# SPEEDGRIP SEAM SEALERS



## Seam Sealer

Two-part epoxy (1:1) used to seal interior and exterior seams, joints and voids.

- Will not shrink, harden or crack
- Retains flexibility
- For use on vertical or horizontal seams



| PART #               | WORK TIME      | SANDING / PAINT TIME | FULL CURE |
|----------------------|----------------|----------------------|-----------|
| 636425- <b>97120</b> | 8 - 10 minutes | 30 minutes           | 2 hours   |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.



## Seam Sealer-Self Leveling

Two-part epoxy (1:1) is formulated for use on drip rails, trunk seams and roof channels.

- Will not shrink, harden or crack
- Retains flexibility
- For use on horizontal seams



| PART #               | WORK TIME      | SANDING / PAINT TIME | FULL CURE |
|----------------------|----------------|----------------------|-----------|
| 636425- <b>97121</b> | 5 - 10 minutes | 30 minutes           | 2 hours   |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.



## Seam Sealer-Controlled Flow

Two-part epoxy (1:1) is a permanently flexible epoxy sealer that features a controlled leveling characteristic.

- Formulated for use on horizontal and sloped areas, trunk and roof seams, drip rails, and core supports.
- Paintable after 30 minutes.



| PART #               | WORK TIME      | SANDING / PAINT TIME | FULL CURE   |
|----------------------|----------------|----------------------|-------------|
| 636425- <b>06402</b> | 5 - 10 minutes | 30 minutes           | 2 - 3 hours |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.



## Bare Metal Epoxy Seam Sealer

Two-part epoxy (1:1), non-sag, high solid epoxy designed where a fast setting and fast paint time sealer is desired.

- Faster paint time than the traditional sealers
- Extrudes easily with excellent tooling characteristics
- No shrinkage



| PART #               | WORK TIME      | SANDING / PAINT TIME | FULL CURE   |
|----------------------|----------------|----------------------|-------------|
| 636425- <b>06398</b> | 5 - 10 minutes | 45 minutes           | 6 - 8 hours |

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.

# SPEEDGRIP FOAM



## Flexible Urethane Foam

Two-part gray, flexible urethane foam formulated to expand up to 10 times its original volume.

- Eliminates wind noise
- Matches OEM flexible foams
- Sound deadening and vibration dampening

| PART #               | DESCRIPTION            | PAINT TIME | CURE TIME  |
|----------------------|------------------------|------------|------------|
| 636425- <b>04622</b> | Flexible Urethane Foam | 15 minutes | 15 minutes |



## Rigid Urethane Foam

Two-part yellow, non-structural rigid foam used for sound deadening, vibration dampening, reinforcement, sealing and filling of: pillars, rocker panels, fender rails, quarter panels and floors.

- Expands up to 10 times its original volume
- Matches OEM sound deadening foams
- Vibration dampening

| PART #               | DESCRIPTION         | PAINT TIME | CURE TIME  |
|----------------------|---------------------|------------|------------|
| 636425- <b>06399</b> | Rigid Urethane Foam | 15 minutes | 45 minutes |

# SPEEDGRIP ACCESSORIES



Manual Applicator Gun



Manual Gun



Pneumatic Gun

## Manual Applicator Gun

This applicator gun is designed for use with SpeedGrip Adhesives either 200 ml or 220 ml cartridges 1:1 or 2:1.

## Manual Gun

This applicator gun is designed for use with SpeedGrip Adhesives 50 ml cartridges 1:1.

## Pneumatic Applicator Gun

This applicator gun is designed for use with SpeedGrip Adhesives either 200 ml or 220 ml Pneumatic Gun cartridges 1:1 or 2:1.

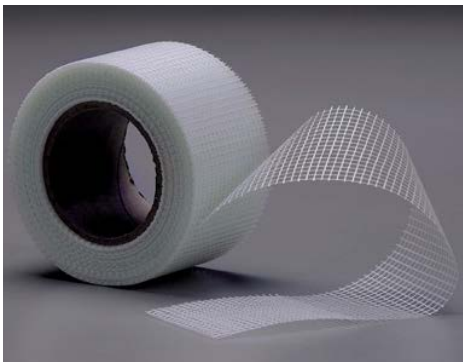
| PART #               | PKG/CASE | DESCRIPTION                              | SIZE        |
|----------------------|----------|--|-------------|
| 636425- <b>41400</b> | 1/1      | Manual Applicator Gun for 200ml/220ml    | 1:1 and 2:1 |
| 636425- <b>97117</b> | 1/1      | Manual Gun for 50ml                      | 1:1         |
| 636425- <b>41399</b> | 1/1      | Pneumatic Applicator Gun for 200ml/220ml | 1:1 and 2:1 |



## Mixing Tips

Mixing tips ensure automatic mixing for optimal performance.

| PART #               | PKG/CASE | DESCRIPTION | MIXING TIP  | COLOR |
|----------------------|----------|-------------|-------------|-------|
| 636425- <b>04628</b> | 6/60     | All 220 ml  | 24 elements | Green |
| 636425- <b>97118</b> | 6/72     | All 50 ml   | 16 elements | White |



## Nylon Reinforcing Tape

Self-adhesive backing tape for repairing and filling holes and plastic gouges. It can be used for both urethane and epoxy adhesives.

| PART #               | PKG/CASE | SIZE     |
|----------------------|----------|----------|
| 636425- <b>04632</b> | 1/6      | 2" x 65' |



## Mixing Spreader with Tapered Edges

For use with #06400 Plastic Repair Skim-Plus.

| PART #               | PKG/CASE | SIZE    |
|----------------------|----------|---------|
| 636425- <b>06396</b> | 25/100   | 3" x 4" |



## Fiberglass Cloth

Fiberglass cloth designed to provide additional strength to the repair. Help eliminate "bull's eye" in SMC repairs.

| PART #               | PKG/CASE | SIZE     |
|----------------------|----------|----------|
| 636425- <b>06397</b> | 1/6      | 4" x 12' |



## Sprayable Seam Sealer S-4 Kit

The S-4 (Sprayable Seam Sealer System) Starter Kit includes one S-4 Atomization Unit with a standard M style air fitting (which can be changed out), a bag of six S-4 Mixing Tips and instructions for use.

The S-4 Atomization Unit attaches to the bottom of the Pneumatic Applicator Gun (#41399) and can easily adjust the air pressure as needed. The unique S-4 Mixing Tip (#06404) screws onto the cartridge, and the opposite end of the tip attaches to the hose on the S-4 Unit.

| PART #               | DESCRIPTION     |
|----------------------|-----------------|
| 636425- <b>06403</b> | S-4 Starter Kit |
| 636425- <b>06404</b> | S-4 Mixing Tips |

## Availability

| PART #                    | QUANTITY<br>PKG/CASE | DESCRIPTION                             | SIZE        | COLOR  | OPEN<br>TIME | WORK<br>TIME | HANDLING/<br>CLAMP TIME | SANDING<br>TIME   | PAINT TIME        | CURE TIME                     | OEM APPROVALS                                  |
|---------------------------|----------------------|---|-------------|--------|--------------|--------------|-------------------------|-------------------|-------------------|-------------------------------|--|
| <b>ACRYLIC ADHESIVES</b>  |                      |   |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>06419</b>      | 1/6                  | Metal Door Skin Bonding                 | 220 ml 2:1  | Green  |              | 45 min       | 1½ hrs                  |                   |                   | 8 hours                       | Ford: WSS-M2G410-A2<br>GM: 6449G               |
| 636425- <b>06420</b>      | 1/6                  | Metal Panel/Weld Bonding                | 220 ml 2:1  | Gray   |              | 75 min       | 2½ hrs                  |                   |                   | 8 hours                       | Chrysler: MS-CD507                             |
| <b>URETHANE ADHESIVES</b> |                      |   |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>97122</b>      | 1/12                 | Adhesive 45 second                      | 50 ml 1:1   | Opaque | 30 sec       | 45 sec       | 2½ min                  | 5-7 min*          |                   | 24 hours                      |  |
| 636425- <b>04647</b>      | 1/6                  | Adhesive 45 second                      | 220 ml 1:1  | Opaque | 30 sec       | 45 sec       | 2½ min                  | 5-7 min*          |                   | 24 hours                      |  |
| 636425- <b>04615</b>      | 1/6                  | Adhesive 1 minute                       | 220 ml 1:1  | Black  | 1 min        | 1½ min       | 7 min                   | 12-20 min*        | 1 hour            | 24 hours                      |  |
| 636425- <b>04616</b>      | 1/6                  | Structural Adhesive 5 minute            | 220 ml 1:1  | Black  | 5 min        | 7 min        | 15 min                  | 45 min            | 2 hours           | 24 hours                      |  |
| 636425- <b>04617</b>      | 1/6                  | Structural Adhesive 15 minute           | 220 ml 1:1  | Black  | 15 min       | 20 min       | 45 min                  | 90 min            | 3 hours           | 24 hours                      |  |
| 636425- <b>04624</b>      | 1/12                 | Adhesion Promoter Brush Top             | 118 ml      |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>04625</b>      | 1/12                 | Adhesion Promoter - Aerosol             | 333 grams   |        |              |              |                         |                   |                   |                               |  |
| <b>EPOXY ADHESIVES</b>    |                      |   |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>06400</b>      | 1/6                  | Plastic Repair Skim-Plus                | 220 ml 1:1  | Blue   |              | 1-2 min      |                         | 15-20 min*        | 60 min            | 60 min                        |  |
| 636425- <b>06111</b>      | 1/6                  | Cosmetic Repair Skim-Plus+              | 220ml 1:1   | Cream  |              | 10 min       |                         | 30-45 min         | 60 min            | 60 min                        |  |
| 636425- <b>06412</b>      | 1/6                  | Repair and Filler                       | 220 ml 1:1  | Purple |              | 5 min        |                         | 15-30 min*        | 15-30 min         | 6-8 hours                     |  |
| 636425- <b>06417</b>      | 1/6                  | SMC/Fiberglass Repair                   | 220 ml 1:1  | Beige  |              | 40 min       |                         | 10 min<br>@ 180°F | 60 min<br>@ 180°F | 60 min @180°F<br>24 hrs @70°F | Ford: SMC panel repair<br>GM: SMC panel repair |
| 636425- <b>06418</b>      | 1/6                  | Panel Bonder                            | 220 ml 1:1  | Black  |              | 30 min       | 2 hours                 | 3 hours           |                   | 24 hours                      |  |
| 636425- <b>06421</b>      | 1/6                  | Panel Bonder                            | 220 ml 2:1  | Black  |              | 90 min       | 4 hours                 | 8 hours           |                   | 24 hours                      |  |
| 636425- <b>06427</b>      | 1/6                  | Impact Toughened<br>Structural Adhesive | 220 ml 2:1  | Purple |              | 90 min       | 120 min                 |                   |                   | 10 hours                      | GM: Repair impact-<br>resistant joints         |
| <b>EPOXY SEAM SEALERS</b> |                      |   |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>97120</b>      | 1/6                  | Seam Sealer                             | 220 ml 1:1  | Black  |              | 8-10 min     |                         | 30 min            | 30 min            | 2 hours                       |  |
| 636425- <b>06402</b>      | 1/6                  | Seam Sealer - Controlled flow           | 220 ml 1:1  | Cream  |              | 5-10 min     |                         | 30 min            | 30 min            | 2-3 hours                     |  |
| 636425- <b>97121</b>      | 1/6                  | Seam Sealer Self-Leveling               | 220 ml 1:1  | Black  |              | 5-10 min     |                         | 30 min            | 30 min            | 2 hours                       |  |
| 636425- <b>06398</b>      | 1/6                  | Bare Metal Seam Sealer                  | 220 ml 1:1  | Gray   |              | 10-15 min    |                         |                   | 45 min            | 6-8 hours                     |  |
| <b>FOAMS</b>              |                      |   |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>04622</b>      | 1/4                  | Flexible Urethane Foam                  | 220 ml 1:1  | Gray   |              | 3-5 sec      |                         |                   | 15 min            | 15 min                        |  |
| 636425- <b>06399</b>      | 1/4                  | Rigid Urethane Foam                     | 220 ml 1:1  | Yellow |              | 10-25 sec    |                         |                   | 15 min            | 45 min                        |  |
| <b>ACCESSORIES</b>        |                      |   |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>41399</b>      | 1/1                  | Pneumatic Gun                           | 1:1 and 2:1 |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>41400</b>      | 1/1                  | Manual Gun                              | 1:1 and 2:1 |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>97117</b>      | 1/1                  | Gun for 50 ml                           | 1:1         |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>97118</b>      | 6/72                 | Mixing Tips 16 element                  | For 50 ml   | White  |              |              |                         |                   |                   |                               |  |
| 636425- <b>04628</b>      | 6/60                 | Mixing Tips 24 element                  | For 220 ml  | Green  |              |              |                         |                   |                   |                               |  |
| 636425- <b>04632</b>      | 1/6                  | Nylon Reinforcing Tape                  | 2" x 65'    |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>06396</b>      | 25/100               | Spreader for Skim-Plus                  | 3" x 4"     | Black  |              |              |                         |                   |                   |                               |  |
| 636425- <b>06397</b>      | 1/6                  | Fiberglass Cloth                        | 4" x 12'    |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>06403</b>      | 1/1                  | S-4 Starter Kit                         |             |        |              |              |                         |                   |                   |                               |  |
| 636425- <b>06404</b>      | 6/60                 | S-4 Mixing Tips                         |             |        |              |              |                         |                   |                   |                               |  |

\* Sanding time depends on film thickness \*\* Up to 30 days  
Times are @ 70°F/21°C except #06421 @ 77°F / 25°C



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