

Technical Data Sheet

Universal Quick Adhesive is a fast-curing, urethane adhesive designed for plastic repairs. It is ideal for quickly repairing bumper tabs, brackets, headlight buckets and grills. It is an excellent choice for bonding backer panels, moldings, emblems and most small plastic, metal and aluminum parts. Universal Quick Adhesive is specially formulated for most automotive plastics, (including TPO, PP, PE) as well as metal, SMC, and fiberglass. This high strength adhesive is sandable and offers great featheredging characteristics with no pinholing.

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel	✓	Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	
Bare Galvanized		Raw Plastic - Flexible (ABD, PPO) +	✓	Primer - 1K	
Bare Aluminum	✓	Raw Plastic - Soft (PUR) +	✓	Primer - 2K	
OEM E-Coat**		Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	

** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: 1:1

FLASH TIMES/DRY TIMES



Work time: 1-2 minutes
 Paint time: 5 minutes
 Declamp time: 5 minutes
 Sand time: 8-15 minutes
 Full cure time: 1 hour

SURFACE PREPARATION



Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Sand with 80 grit.

* For more information on surface prep and application refer to next page.

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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SURFACE PREPARATION

Cleaning & Sanding: Wash area with soap and water and wipe dry. Clean repair area with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and wipe dry. Sand the front and back of repair area with 80 grit sandpaper. Make sure to feather the paint surrounding the repair area. Bevel the damaged line on the front side of the plastic to be repaired. Remove sanding residue and reclean with SCAT, Speedi SCAT or Aqua SCAT 2. Wipe dry.

CARTRIDGE PREPARATION & APPLICATION

Cartridge Preparation: Immediately before using material, prepare the cartridge for use. Insert the cartridge into the 4450 application gun. Remove any cap or plug. To equalize the cartridge, purge a small amount of material. Attach the mixer and tighten. To ensure a proper mix, gun out 1 mixer length of material and dispose.

Repair of Flexible and Semi-Rigid Plastic Bumpers: Apply Mul-TIE Adhesion Promoter 1031/1033/1034 or Plasto-Mend TPO Adhesion Promoter 1021 to the bare sanded plastic on the front and back of repair. Allow area to dry. Reinforce the backside of damage with Plastic Repair Tape. Apply Universal Quick Adhesive to the back of the repair area, spreading evenly over the repair area. Allow area to dry prior to sanding.

If reconstructing a tab, use the inside of the 1458 bag as a contouring sheet. Apply material to the tab and contour using the inside of the bag while the material is wet. Once cooled, remove the bag and finish the reconstruction. Sand the front of the tab to prepare for finishing material.

If reconstructing a part, use the inside of the 1458 bag as a contouring sheet to help mold the piece while the adhesive is wet. Allow to cool and remove the bag and continue to contour the new part. Allow the new part to fully cure. If sanding, start with 80 grit and finish with 180-220. After the back has enough material, go to the front side of the repair. Check that the material is not higher than the surrounding plastic. If so, spread into the repair area while it is still wet. If material on back is allowed to dry, scuff the material showing through on the front side for adhesion. Reclean the area and reapply Adhesion Promoter if scuffing is necessary. Apply material to the front side of the repair area thoroughly covering the damaged area. Sand to contour using 80-180 grit paper. Finish sand with 180-220 and reclean with SCAT, Speedi SCAT or Aqua SCAT 2. If bare plastic is present, apply another coat of Mul-TIE Adhesion Promoter or Plasto-Mend TPO Adhesion Promoter and allow to dry prior to priming surface.

SMC/Fiberglass: Follow the application instructions for Repair of Flexible & Semi-Rigid Plastic Bumpers except step 1 (Apply Adhesion Promoter). The use of adhesion promoter is not recommended for use on SMC.

Bonding - small patch/backer panels, SMC/fiberglass panels and general quick bonding: Remove all loose paint and sand area with 80 grit on all areas to be bonded. Clean both surfaces with SCAT, Speedi SCAT or Squa SCAT 2. Pre-fit part to be bonded. See cartridge preparation for purge and application information. Clamp and let cure. Refer to Addendum B for specific bonding application information.

PRODUCT SPECIFICATIONS

Color: Black	Shelf Life: 1 year
RTU Solids: 100%	Shore D Hardness: 68
Size: 7 fl oz (207 ml)	Elongation: 50%

REGULATORY

Category: Adhesive			
VOC Actual	<.08#/gal (<10 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	<.08#/gal (<10 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	<1	Density of Material #/gal	10.14
Weight % of Water	0		

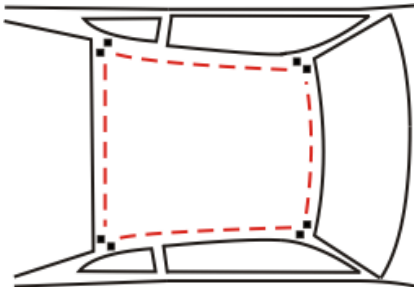
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ADDITIONAL APPLICATION INFORMATION

Panel Bonding Adhesives may be used to bond metal, aluminum, fiberglass and SMC, including door skins, roof skins, fenders, quarter panels, cab corners, and small & medium & large sized panels. Choose the appropriate adhesive depending on the amount or work time needed. Do not use on structural components such as frame rails, pillars, core supports or rocker panels.

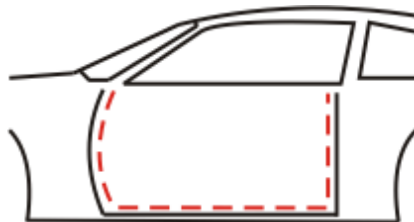
1. Remove all paint, primer, corrosion and rust from the surface to be bonded using 36 - 50 grit abrasive disc. When preparing aluminum surfaces use 80 grit abrasive disc.
2. Straighten all metal and clamp equipment panels for proper alignment and fit. There should be no tension on the replacement panels.
3. Remove panels from vehicle.
4. Clean areas to be bonded with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 1391/1394. Other cleaner may leave a film and prevent optimum bonding.
5. Place cartridge in dispensing gun, purge cartridge, attach mixer and purge cartridge to ensure product mixed properly (minimum of 1 mixer length).
6. Apply 3/16 - 1/4" 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 replacement part to ensure proper corrosion protection
7. Clamp the panel into position and tool any extra adhesive to provide a seal along outside edge of bonded panel. Do not over-tighten.
8. If bonding metal, weld appropriate areas while the adhesive is still wet. Apply Weld Through Primer 4353 per the product instructions to the weld area only. Clean 4353 overspray areas with Acry Solvent 9783/9784 or 6700-F Series Zero VOC Urethane Grade Reducer where panel bonding adhesive will be used. Note: Do not apply panel bonding adhesive material where Weld Through Primer exists.
9. Let panel cure. Cure time can be accelerated with heat. While curing reapply anti-corrosion material. (Clamps may be removed from the panel per times on the technical datasheet 72°F (22°C). If the temperature is lower or there is tension on the part, additional cure time is required.

ROOF PANELS



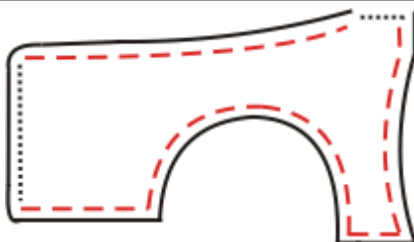
Follow vehicle manufacturer's replacement procedures to prepare the service panel for replacement. Leave a space of two inches at each of the four corners to allow for two plug welds or a two inch lap weld. Use adhesive around entire perimeter of the roof and on the roof bows if applicable. Follow directions 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.

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 directions for surface preparation and applying adhesive.

QUARTER PANELS



Follow vehicle manufacturer's replacement procedures to prepare the service panel for replacement. Follow vehicle manufacturer's replacement procedures for welding the joint between the rear body and the quarter panel, as well as the sail panel. Adhesive can be used on all other areas, lower panel, wheel opening, door jamb, and trunk drip rail. Follow directions for surface preparation and applying adhesive.

Adhesive Area - - - - -

Welding Area ■ ■ ■ ■ ■

Visit www.tat-co.com to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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