

## DESCRIPTION

**Weld-Bond** is a non-sag, two component acrylic adhesive system formulated to bond metal surfaces without the use of an external primer.

## FEATURES

- **DUAL-MIX™** Forever Warranty
- Superior impact and peel strength
- Glass beads for consistent bond line thickness
- Non-sagging gaps filled up to 1/2"
- Excellent environmental resistance
- Long working time

## SUITABLE SUBSTRATES

- Steel
- Aluminum

## TYPICAL CURED PROPERTIES

Part:	Product Name:	Color:	Container:
39537	Weld-Bond Adhesive	Opaque Cream	7 oz. Cartridge
<b>Working time:</b>		60 minutes @ 70°F (21°C)	
<b>Set time:</b>		3 hours @ 70°F (21°C)	
<b>Cure time:</b>		24 hours @ 70°F (21°C)	
<b>Heat cure time:</b>		1 hour @ 120°-140°F (49°-60°C)	
<b>Lap shear @ 70°F (21°C) (psi) on steel:</b>		3500+ ASTM D 1002	
<b>Coverage:</b>		115" @ 3/8" diameter bead	

Check local VOC regulations to ensure compliance of all products in your area.

## HANDLING AND APPLICATION

### PREPARATION:

1. Bonding surfaces should be clean, dry and free of contamination.
2. Clean surfaces to be bonded with **SEM Solve** or **Zero VOC Surface Cleaner**.



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**3.** Grind each surface with a 36 grit grinding disc at low speed to maintain grinding marks.

Do not grind at high speed.

**4.** Re-clean surfaces with **SEM Solve** or **Zero VOC Surface Cleaner** if necessary.

**Note:**

Always use lint-free towels when cleaning surfaces to avoid lint and particle contamination.

**MIXING:**

It is highly recommended that adhesives be dispensed through a static mixer. Once mixed, **Weld-Bond Adhesive** should achieve a uniform color.

**IMPORTANT:**

Heat buildup during and after mixing is normal.

Place cartridge into **71119 Universal Manual Applicator** or **70039 Universal Pneumatic Applicator**. Remove cartridge tip. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer and cut tip to desired bead size. Dispense 2-3 inches of test material to make certain color is uniform before applying to job.

**STATIC MIXERS:**

Part:	Product Name:	For:	Container:
70011	Integral Nut Square Static Mixers	7 oz. Cartridge	6 Pack
70012	Integral Nut Square Static Mixers	7 oz. Cartridge	50 Pack

**APPLICATION:**

Use enough material to completely fill the joint when parts are clamped. Remove the excess material from the front of the repair. Always follow step by step directions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesive's working time. Wipe away excess material squeezed out during clamping process. Do not over clamp. Exposed material left to dry may not fully harden, especially in high humidity conditions.

**Note:**

**Weld-Bond Adhesive** is intended for full panel replacement only. Partial panel replacements may show a bond line or halo due to techniques in workmanship and are not warranted.

**IMPORTANT:**

Bonding applications are intended for secondary (cosmetic) panels only. Structural components should never be bonded unless specified by the OEM.

**DAMPENING MATERIAL:**



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When replacing door skins, roof skins or quarter panels, **Flexible Urethane Foam**, **Rigid Urethane Foam** and **Panel Vibration Control Material** can be used to replace the OEM dampening material found between the panels and the structural members. Refer to product information for proper selection

## CURING:

Parts should remain undisturbed between the material's working time and set time. After the set time is achieved, the material has reached handling strength. Temperatures below 55°F (13°C) will slow the cure; above 85°F (29°C) will accelerate cure rate. To enhance cure time, heat to 120°-140°F (49°-60°C) for 1 hour. At 77°F (25°C), **Weld-Bond Adhesive** sets in 3 hours and fully cures in 24 hours.

## WELDING:

**Weld-Bond Adhesive** is versatile and can be used with traditional welding methods or resistance spot welding techniques while still wet when following OEM recommendations. A 1 inch gap must be left where welding will occur.

### Note:

Remove excess adhesive prior to welding.

### Note:

Prior to welding apply **Weld-Thru Primer** or **Copperweld Weld-Thru Primer** on any area where adhesive will not be present. Allow weld-thru primer to fully dry.

## CLEANUP:

It is important to clean up excess adhesive from the work area and application equipment before it cures. Use appropriate cleaning materials compliant with VOC regulations in your area. Keep container tightly closed after use. Remove static mixer after use and replace cap. **Weld-Bond Adhesive** is flammable when exposed.

## STORAGE:

**Weld-Bond Adhesive** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Weld-Bond Adhesive** is 1 year when stored at 40°-77°F (4°-25°C). Exposure above room temperature will reduce shelf life.



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## RELATED PRODUCTS:

Part:	Product Name:	Size:
38371	SEM Solve	Gallon
38373	SEM Solve	Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart
71119	Universal Manual Applicator	1 Each
70039	Universal Pneumatic Applicator	1 Each
70011	Integral Nut Square Static Mixer	6 Pack
70012	Integral Nut Square Static Mixer	50 Pack
39357	Flexible Urethane Foam	7 oz. Cartridge
39977	Panel Vibration Control Material	7 oz. Cartridge
39997	Rigid Urethane Foam	7 oz. Cartridge
39783	Weld-Thru Primer	Aerosol
39786	Brushable Weld-Thru Primer	8 oz. can
40783	Copperweld Weld-Thru Primer	Aerosol

### Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

#### Disclaimer:

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Users should review the Material Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and product label are available upon request.