

TECHNICAL DATA SHEET**RESIWELD (R) ADHESIVE****DESCRIPTION**

This product is a sag resistant version of our FE-0004 that provides the same general mixing and curing characteristics along with the physical cured strength of much thinner materials. Part A is yellow, Part B is blue and the blend is green to assure adequate mixing. This is truly a sag resistant all purpose adhesive.

SUGGESTED USES

Bonding metal to metal, wood to wood, honeycomb to metal for prefabricated buildings.

TYPICAL PHYSICAL PROPERTIES and GENERAL INFORMATION

| | Part A | Part B | Blend |
|---|---------------|---------------|--------------|
| RESIN SYSTEM | EPOXY | POLYAMIDE | EPOXY |
| COLOR | YELLOW | BLUE | GREEN |
| VISCOSITY (cP (mPa.s)) | 55,000 | 60,000 | 80,000 |
| WEIGHT PER U.S. GALLON (POUNDS) | 10.4 | 11.6 | 11 |
| SOLIDS (%) | 100 | 100 | 100 |
| BLENDING RATIO BY VOLUME (A/B) | | | 100/100 |
| BLENDING RATIO BY WEIGHT (A/B) | | | 90/100 |
| SHELF LIFE | ONE YEAR | ONE YEAR | |
| GEL TIME SAMPLE VOLUME IN FLUID OZ. (FL.OUNCES) | | | 4 |
| GEL TIME TEMPERATURE (F.) (DEGREES F.) | | | 77 |
| GEL TIME IN MINUTES (MINUTES) | | | 50 |
| TENSILE LAP SHEAR STR. ALUM @ -60 F (PSI) | | | 1,800 |
| TENSILE LAP SHEAR STR. ALUM @ 77 F (PSI) | | | 2,500 |
| TENSILE LAP SHEAR STR. ALUM @ 180 F (PSI) | | | 1,600 |

APPLICATION AND EQUIPMENT SUGGESTIONS

Suitable two part metering and mixing equipment is available. Contact your H.B. Fuller representative for suggested application equipment to suit your specific needs.

DIRECTIONS FOR USE

SURFACE PREPARATION: Surfaces must be clean, dry and free from grease, oil, paint, wax and weak oxide films and other surface contaminants. Chemical etching, sanding or grit blasting often give the best results.



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PROPORTIONING AND MIXING: Just prior to using, blend the two components, Part A and Part B, in the ratio above. Stir the two components together thoroughly, being certain to scrape in all material from the walls and bottom of the mixing container. Materials can be hand stirred. Mechanical mixing is preferable, but should be carried out at slow speeds (about 300 rpm), taking as little air as possible into the adhesive batch.

APPLICATION: Spread a thin layer of the mixed adhesive on one or both of the parts to be bonded. Once the adhesive is applied, no open time is necessary. The surfaces can be assembled immediately. Parts should be assembled while the adhesive is still wet to the touch and before it sets. The individual parts, the ambient temperature as well as the adhesive itself will dictate the open time permitted. The best results are usually obtained when the thickness at the bond line is between two and six mils.

*CURE SCHEDULE: 7-10 days at 77F
3-4 hours at 158F
40-60 min. at 200F

* Allow additional time for parts to warm to curing temperature.

STORAGE AND HANDLING

Use good personal hygiene. Avoid eye and skin contact. Wash contaminated clothing before reuse. Store material in a closed container in a cool, dry place.

CAUTION

Potential sensitizer. Eye and skin irritant. Vapors harmful. Consult the container label and Material Safety Data Sheets for additional cautionary information before using.



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CONDITIONAL ACCEPTANCE -- Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.