

URETHANE ADHESIVES

Norton SpeedGrip Urethane Structural Adhesives are a versatile and fast two part urethane system for bonding and repairing steel, aluminum, flexible, semi-rigid and rigid plastic and fiberglass. All products perform the same on all materials. Just select the working time that best fits your needs

Improve Repair Quality

- OEM quality and performance
- Outstanding corrosion protection
- High strength structural bonding
- 100% solids – no shrinkage

Increase Productivity

- Eliminate application of rust-inhibiting primers
- Faster unclamp times
- Fast application – apply adhesive to one side, not two
- Faster repair time than welding and no heat warpage



Question 1:

IS IT TPO OR NOT?

A quick sand test will determine what type of plastic you're working on. Lightly sand an inconspicuous spot on the plastic to be repaired with 36 grit Speed-Lok TR Disc.



TPO PLASTIC, WHEN SANDED, WILL MELT AND SMEAR. TPO ADHESION PROMOTER (#04624 OR #04625) MUST BE USED PRIOR TO APPLYING SPEEDGRIP ADHESIVE.



IF THE PLASTIC POWDERS AND SANDS CLEANLY, THEN IT IS NOT TPO. DO NOT USE TPO ADHESION PROMOTER.

Question 2:

WHAT'S THE WORK TIME WINDOW?

Depending on the size of the work area to be repaired the work time window will vary. We offer five different work time adhesives. Pick your time and you pick your adhesive. It's that simple.

Five Work time Windows

PART NUMBER	OPEN TIME	WORK TIME	CLAMPING OR FIXTURE TIME	SANDING OR PAINTING TIME
04647	30 seconds	–	2 1/2 minutes	5 minutes
04615	1 minute	1-1/2 minutes	7 minutes	12 minutes
04616	5 minutes	7 minutes	15 minutes	45 minutes
04617	15 minutes	20 minutes	45 minutes	90 minutes
04618	40 minutes	60 minutes	2 hours	3 hours

TIMES WILL INCREASE AS TEMPERATURES DECREASE.

TIMES SHOWN ABOVE ARE AT 70F/21C.

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: PRIMER (EITHER 2 PART EPOXY OR 2 PART URETHANE).

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FOR TECHNICAL HELP: **1 866 879-3761**