



68442 CLEAR FAST SET ADHESIVE

TECHNICAL DATA SHEET

Description

68442 CLEAR FAST SET ADHESIVE creates an invisible bond to many substrates including plastic, metal, fiberglass and wood. When a clear, fast setting adhesive is preferred, **68442** is the ideal, multipurpose choice.

Features

- Epoxy technology
- Strong clear bond
- Isocyanate free
- Fast setting
- Bonds multiple substrates

Typical Properties

Container	1 oz. MINI-MAX cartridge
Color	Clear
Working time	1-2 minutes @ 70°F (21°C)
Set time	5-6 minutes @ 70°F (21°C)
Cure time	1 hour @ 70°F (21°C)
Lap shear strength	1200-1500 psi (ASTM D 1002)

Handling and Application

PREPARATION:



Clean with **3833**() **SCUFF & CLEAN** and rinse with water. Next, clean with **3835**() **PLASTIC/LEATHER PREP**. Apply according to directions. Sand painted areas to be bonded with 180 grit paper and clean again with **3835**().

MIXING:



Remove cap between pistons. Cut off cartridge tips at perforation. Dispense material and mix until uniform.

APPLICATION:



General purpose bonding

1. Clean surface as outlined in Preparation section.
2. For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied. **DO NOT ALLOW 68442 TO FLOW OVER MASKED AREA OR ONTO PAINTED SURFACE.**
3. Apply **68442** to surface to be bonded.
4. Hold or clamp firmly. Repair piece will be securely bonded in 3-5 minutes. Allow another 30 minutes to ensure a secure bond.

STORAGE:



68442 CLEAR FAST SET ADHESIVE should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **68442** is 1 year when stored under normal conditions.

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: The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

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.