



# 68432 GENERAL PURPOSE ADHESIVE

## TECHNICAL DATA SHEET

### Description

**68432 GENERAL PURPOSE ADHESIVE** provides fast bonds for backing materials on most plastics. With a fast set up time, **68432** is perfect for adhering backer strips when replacing sections of SMC and fiberglass. **68432** has the ability to bond a good cross section of substrates, giving bodyshops a much needed quick-setting adhesive.

### Features

- Epoxy technology
- Isocyanate free
- Fast setting
- Bonds multiple substrates

### Typical Properties

Container	1 oz. <b>MINI-MAX</b> cartridge
Color	Black
Working time	2-3 minutes @ 70°F (21°C)
Set time	5-7 minutes @ 70°F (21°C)
Cure time	45-60 minutes @ 70°F (21°C)
Lap shear strength	1800-2000 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.



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



**APPLICATION:** For use with **70006 PLASTIC REPAIR REINFORCING TAPE**



1. Clean surface as outlined in Preparation section.
2. Sand with 80 grit paper 2-3 inches around damaged area. Blow off dust and clean again with **3835( )**. "V" groove damaged area with a 24 grit disc at low RPM so as not to overheat or melt the plastic.
3. Lay **70006** on the back side of the repair.
4. Dispense **68432** over **70006** and spread firmly 2-3 inches beyond repair.
5. Proceed with the appropriate **DUAL-MIX** repair material.

## **APPLICATION**

**Cont’:**



General purpose bonding

1. Clean surface as outlined in preparation section.
2. Sand painted areas to be bonded with 180 grit paper and clean with **3835()**.
3. For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied. **DO NOT ALLOW 68432 TO FLOW OVER MASKED AREA OR ONTO PAINTED SURFACE.**
4. Apply **68432** to surface to be bonded.
5. Hold or clamp firmly. Repair piece will be securely bonded in 30 minutes. Allow another 30 minutes for full cure.

**STORAGE:**



**68432 GENERAL PURPOSE ADHESIVE** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **68432** 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.

**SEM Products, Inc.**  
**1685 Overview Dr. Rock Hill SC 29730**  
**Tel: 800/ 831-1122**  
**[www.semproducts.com](http://www.semproducts.com)**