39747 MULTI-PURPOSE PANEL ADHESIVE
TECHNICAL DATA SHEET

Description

39747 MULTI-PURPOSE PANEL ADHESIVE is a non-sag, two component epoxy adhesive system formulated to bond steel, aluminum, SMC and fiberglass panels without the use of an external primer. **39747** provides long working times (90 minutes) allowing body shops to correctly position parts for proper alignment. This adhesive contains glass beads to insure adequate bond line control. **39747** is an easy to use 2:1 adhesive that forms resilient bonds and maintains its strength over a wide range of temperatures. **39747** is suitable for bonding a variety of substrates, especially automotive grade cold rolled steel.

Features

- **Long working time**
- **Superior impact and peel strength**
- **Excellent environmental resistance**
- **100% reactive**
- **Glass beads for consistent bond line thickness**
- **Non-sagging gaps filled up to ½"**
- **Minimal surface preparation**

Typical Cured Properties

Peel strength (pli) on steel	20-40	ASTM D 3167
Tensile lap shear @ 77°F (25°C) (psi) on steel	3000-3800	ASTM D 1002
Tensile lap shear @ 175°F (79°C) (psi) on steel	2400-2600	ASTM D 1002
Bond line thickness (inches)	0.005-0.5	

Typical Uncured Properties

	Part A	**Part B**	**Mixed**
Working time @ 77°F (25°C)	-	-	60-90 minutes
Set time @ 77°F (25°C)	-	-	4 hours
Color	Cream	Black	Black

Packaging

7 oz **DUAL-MIX** cartridge with two static mixers

Handling and Application

PREPARATION: Bonding surfaces should be clean, dry and free of contamination. Minimal surface preparation is required for **39747**, and superior bonds can be formed on most substrates following directions.

MIXING: It is highly recommended that adhesives be dispensed through a static mixer. Once mixed, **39747** should achieve a uniform color. This is important! Heat build up during and after mixing is normal.

Use Static Mixers: **70011 INTEGRAL NUT SQUARE STATIC MIXERS** (6 pack) or **70012 INTEGRAL NUT SQUARE STATIC MIXERS** (50 pack)

***APPLICATION*:** Use enough material to completely fill the joint when parts are clamped. Always follow step by step directions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesive's working time.

NOTE: 39747 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.

CURING: Parts should remain undisturbed during the interval of time 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), **39747** sets in 4 hours and fully cures in 24 hours.

WELDING: **39747** is versatile and can be used with traditional welding methods or resistance spot welding techniques when following OEM recommendations.

NOTE: Remove excess adhesive prior to welding.

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 containers tightly closed after use. **39747** is flammable when exposed.

STORAGE: **39747 MULTI-PURPOSE PANEL ADHESIVE** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **39747** is 2 years when stored at 40-77°F (4-25°C). Exposure above room temperature will reduce shelf life.

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.

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