



## ONE LINE DOES IT ALL PUT NORTON TO THE TEST

Whether you're working on steel, aluminum, SMC, FRP, fiberglass, rigid plastic, semi-rigid plastic, flexible plastic or panel bonding, our full line of Norton SpeedGrip Structural Adhesives gets the job done.

- Acrylic Adhesives
- Urethane Adhesives
- Epoxy Adhesives
- Epoxy Seam Sealers
- Foams
- Accessories

**QUALITY THAT PAYS™**

# ACRYLIC FOR METAL BONDING

2,500 PSI Lap shear strength makes acrylic adhesives one of the strongest available. It remains flexible and performs well at extremely low temperatures. Acrylic is the best choice for metal-to-metal bonding. For optimal results, grind the panel to bare metal.

<b>GUARANTEED:</b>	Norton SpeedGrip acrylic adhesives provide a lifetime corrosion and performance warranty
<b>PRODUCTIVE:</b>	Reduce repair time versus welding, seals and bonds in one application and de-clamp in as little as 90 minutes
<b>PRECISE CONTROL:</b>	Glass bead technology allows for correct panel spacing and perfect bond control
<b>VERSATILE:</b>	Bonds a variety of substrates: automotive grade cold-rolled steel, galvanized steel, e-coat, aluminum and stainless steel with minimal surface preparation



## Metal Door Skin Bonding Adhesive

Two-part acrylic (2:1) for panel bonding of door panels, other body sheet metal, steel and aluminum.

- Bonds door panels to door frames without welding
- Guaranteed corrosion protection



Meets Ford WSS-M2G410-A2 and GM6449G Metal Bonding Specifications



## Metal Panel/Weld Bonding Adhesive

Two-part acrylic (2:1) for panel bonding and weld bonding of quarter panels, rear body panels, roof panels, door panels, van side panels and outer truck bed panels on bare metals, including aluminum.

- Long work time 75 minutes for bonding large areas
- Guaranteed corrosion protection
- Perfect for high temperatures



Meets Chrysler MS-CD507 Metal Bonding Specification

PART #	WORK TIME	CLAMP TIME	CURE TIME
636425 <b>06419</b>	45 minutes	1-1/2 hours	8 hours

### Applications:

- Bonding of patch panels and trailer side wall sections, etc.
- Bonding of exterior body panels including door panels, quarter panels, roof panels, etc.
- Can be used to weld and/or rivet bond structural or non-structural body panels. Follow OEM procedures.

PART #	WORK TIME	CLAMP TIME	CURE TIME
636425 <b>06420</b>	75 minutes	2-1/2 hours	8 hours

### Applications:

- Bonding of exterior body panels including door panels, quarter panels, roof panels, etc., when an extended working time is needed.
- Can be used to weld and/or rivet bond structural or non-structural body panels. Follow OEM procedures.

## TECH TIP

After clamping, wipe any excess adhesive off the panel while wet.

Times will increase as temperature decreases.

Times shown above are at 70°F/21°C.

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.

**RESISTANCE SPOT WELDING:** Norton recommends resistance welding through Metal Bonding Adhesives in a wet or cured state with no burn back.

**MIG WELDING:** Norton Adhesive **CANNOT** be in the weld area or burn back will occur. Norton recommends at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.

# URETHANE FOR PLASTIC REPAIR

Urethane adhesives provide 3,500+ PSI Lap shear strength and perform well at higher temperatures. Urethanes work with most repair applications and are sandable. They are recommended for most plastic repair jobs.

<b>DURABLE:</b>	Stronger than the original plastics
<b>100% SOLIDS:</b>	No shrinkage
<b>SANDS GREAT:</b>	Undetectable feather edge
<b>FAST:</b>	Sandable in as little as 5 minutes



## Adhesion Promoter

No need to identify plastic type – just simply apply to all plastics once, no need to re-apply. Allow for a 10 minute flash time.



PART #	DESCRIPTION	SIZE
636425 <b>04625</b>	Aerosol	333 g

### Applications:

- No plastic identification required.
- Use with urethane adhesives on plastic parts.



## SpeedGrip 45 seconds

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS.

- Perfect to join pieces which cannot be clamped in place, simply hold the pieces in place for 20 seconds



## SpeedGrip 1 minute

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand
- Will not lift or roll up

PART #	SIZE	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME
636425 <b>04647</b>	(220 ml)	30 seconds	45 seconds	2-1/2 minutes	5 - 7 minutes
636425 <b>97122*</b>	(50 ml)	30 seconds	45 seconds	2-1/2 minutes	5 - 7 minutes

\* 2,000 PSI Lap shear strength

### Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

PART #	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
636425 <b>04615</b>	1 minute	1-1/2 minutes	7 minutes	12 - 20 minutes	1 hour

### Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

Times will increase as temperatures decrease.

Times shown above are at 70°F/21°C.

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 PRIMERS: 2 part epoxy or 2 part urethane. Or you can use Skim-Plus #06400 to finish the repair directly over the SpeedGrip.

All are 220 ml, except #97122, which is 50 ml.

## URETHANE FOR PLASTIC REPAIR (CONT.)



### SpeedGrip 5 minutes

Two-part urethane (1:1) adhesive used for structural and cosmetic repairs of all plastic bumpers, bumper tabs, emblems, door trims, interior and exterior plastic repairs and cosmetic repairs including TPE, TPO, TEO, PP and ABS and can also be used to bond SMC or fiberglass panels.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand to a feather edge
- Good for elevated temperatures
- Will not lift or roll up
- Accelerate cure with heat (3 min @ 140°F)



### SpeedGrip 15 minutes

Two-part urethane (1:1) adhesive used for installation of hood panels, roof panels, fenders, fender liners, fairings, spoilers, wind deflectors, cab extenders, ground effects, headlamp buckets and other body panels. For bonding fiberglass, SMC, carbon fiber and other plastics to itself and to primed metal.

- One product for all structural and cosmetic repairs on bumpers
- Work window allows for larger repairs
- Perfect for elevated temperatures
- Easy to sand to a feather edge
- Accelerate cure with heat (10 min @ 140°F)

PART #	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
636425 <b>04616</b>	5 minutes	7 minutes	15 minutes	45 minutes	2 hours

#### Applications:

- Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.
- Repairs tears and holes on bumpers, trim, moldings, etc.

PART #	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
636425 <b>04617</b>	15 minutes	20 minutes	45 minutes	90 minutes	3 hours

#### Applications:

- Bonds composite materials to itself or to coated metals.

## EPOXY FOR PANEL BONDING



### Impact Toughened Structural Adhesive

Two-component epoxy structural adhesive for use in automotive bonding applications. Adheres to a wide variety of properly prepared substrates including steel and aluminum. The Impact Toughened Structural Adhesive has an extended work time for large applications, but can be accelerated with applied heat.

- Optimum impact strength than traditional structural adhesives
- Can be used in weld bonded or rivet bonded OEM applications
- Outstanding performance in extreme temperatures (-40°F through 140°F)
- Consistent bond line thickness contained by glass beads



GM: Impact-resistant joint repair



To view a step-by-step video for **Impact Toughened** go to:  
<http://nortonsga.us/applyspeedgr>

PART #	WORK TIME	CLAMP TIME	SANDING TIME	PAINT / CURE TIME
636425 <b>06427</b>	90 minutes	10 hours	N/A	N/A

#### Applications:

- Repair structural components, reinforcements and body rails.

For use on outer body panels only. Not for use on structural components such as pillars, frame rails, core supports, or rocker panels (on unibody vehicles).

Times will increase as temperatures decrease. Times shown above are at 77°F/25°C. Full cure time is 24 hours, but this may be accelerated with heat.

RESISTANCE SPOT WELDING: Norton recommends resistance welding through Multi-Bonding Adhesives in a wet state only with little to no burn back.

MIG WELDING: Multi-Bonding Adhesive CANNOT be in the weld area or burn back will occur. Norton recommends at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.



# EPOXY FOR PANEL BONDING (CONT.)



## Epoxy Panel-Bonding Adhesive

Two-part epoxy adhesive designed to bond SMC, FRP, fiberglass, steel and aluminum auto parts and body panels to each other and to metal frames (no primer required).

- Minimal odor
- Glass beads for proper spacing
- Easy to sand formulation
- Paintable
- Seals and bonds in one step



To view a step-by-step video for **Structural Plastic Repair** go to: <http://nortonsga.us/structuralspeedgr>



To view a step-by-step video for **Cosmetic Plastic Repair** go to: <http://nortonsga.us/plasticspeedgr>

PART #	WORK TIME	CLAMP TIME	SANDING TIME	PAINT / CURE TIME
636425 <b>06418</b>	30 minutes	2 hours	3 hours	24 hours
636425 <b>06421</b>	90 minutes	4 hours	8 hours	24 hours

# EPOXY FOR SMC/PLASTIC REPAIR

Epoxy adhesives work well at both high and low temperatures, have shear strength of 3,000 PSI and perform well filling gaps. Ideal for undetectable SMC repairs, plus they can be used with most other collision repair applications.



## Plastic Repair Skim-Plus

Two-part epoxy (1:1) used to repair most plastic parts, including bumper covers and other plastic body panels including PP, fiberglass, Metton®, Telene®, SMC, TE0 and urethane. Formulated to finish the front side of flexible repairs or used over the top of urethane adhesives.

- Incredibly easy to sand in 20 minutes or less
- No plastic ID required
- No adhesion promoter needed
- Mix with spreader



## SMC/Fiberglass Repair Adhesive

Two-part epoxy (1:1) used for structural and cosmetic repair of all types of rigid body plastics such as SMC, GTX, fiberglass, Metton® and carbon fiber.

- One product for all rigid body panels
- Sands very easily
- Will not lift or roll up
- No read-through and zero shrinkage



Ford: SMC panel repair  
GM: SMC panel repair

PART #	WORK TIME	CLAMP TIME	SANDING TIME	PAINT TIME	CURE TIME
636425 <b>06400</b>	1-2 minutes	—	15-20 minutes	60 minutes	60 minutes

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.

PART #	WORK TIME	CLAMP TIME	SANDING TIME	PAINT TIME	CURE TIME
636425 <b>06417</b>	40 minutes	3 hours (10 min @ 180°F)	10 minutes @ 180°F	60 minutes @ 180°F	60 minutes @ 180°F

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.



## Repair and Filler

Two-part epoxy (1:1) used for cosmetic repairs on both flexible and rigid parts. Adhesion Promoter must be used on plastic parts. Work time is 5 minutes and it can sanded in 15-30 minutes. It sands easily and feathers well.

- Incredibly easy to sand in 30 minutes or less
- Use adhesion promoter on plastic parts
- Feathers well
- Mix with spreader

PART #	WORK TIME	CLAMP TIME	SANDING TIME	PAINT TIME	CURE TIME
636425 <b>06412</b>	5 minutes	—	15-30 minutes	15-30 minutes	6-8 hours

Times will increase as temperatures decrease. Times shown above are at 70°F/21°C unless noted otherwise.

# SPEEDGRIP SEAM SEALERS



## Seam Sealer

Two-part epoxy (1:1) used to seal interior and exterior seams, joints and voids.

- Will not shrink, harden or crack
- Retains flexibility
- For use on vertical or horizontal seams



PART #	WORK TIME	SANDING / PAINT TIME	FULL CURE
636425 <b>97120</b>	8 - 10 minutes	30 minutes	2 hours

*Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.*



## Seam Sealer-Self Leveling

Two-part epoxy (1:1) is formulated for use on drip rails, trunk seams and roof channels.

- Will not shrink, harden or crack
- Retains flexibility
- For use on horizontal seams



PART #	WORK TIME	SANDING / PAINT TIME	FULL CURE
636425 <b>97121</b>	5 - 10 minutes	30 minutes	2 hours

*Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.*



## Seam Sealer-Controlled Flow

Two-part epoxy (1:1) is a permanently flexible epoxy sealer that features a controlled leveling characteristic.

- Formulated for use on horizontal and sloped areas, trunk and roof seams, drip rails, and core supports.
- Paintable after 30 minutes.



PART #	WORK TIME	SANDING / PAINT TIME	FULL CURE
636425 <b>06402</b>	5 - 10 minutes	30 minutes	2 - 3 hours

*Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.*



## Bare Metal Epoxy Seam Sealer

Two-part epoxy (1:1), non-sag, high solid epoxy designed where a fast setting and fast paint time sealer is desired.

- Faster paint time than the traditional sealers
- Extrudes easily with excellent tooling characteristics
- No shrinkage



PART #	WORK TIME	SANDING / PAINT TIME	FULL CURE
636425 <b>06398</b>	5 - 10 minutes	45 minutes	6 - 8 hours

*Times will increase as temperatures decrease. Times shown above are at 70°F/21°C.*

# SPEEDGRIP FOAM



## Flexible Urethane Foam

Two-part gray, flexible urethane foam formulated to expand up to 10 times its original volume.

- Eliminates wind noise
- Matches OEM flexible foams
- Sound deadening and vibration dampening

PART #	DESCRIPTION	PAINT TIME	CURE TIME
636425 <b>04622</b>	Flexible Urethane Foam	15 minutes	15 minutes



## Rigid Urethane Foam

Two-part yellow, non-structural rigid foam used for sound deadening, vibration dampening, reinforcement, sealing and filling of: pillars, rocker panels, fender rails, quarter panels and floors.

- Expands up to 10 times its original volume
- Matches OEM sound deadening foams
- Vibration dampening

PART #	DESCRIPTION	PAINT TIME	CURE TIME
636425 <b>06399</b>	Rigid Urethane Foam	15 minutes	45 minutes

# SPEEDGRIP ACCESSORIES



Manual Applicator Gun



Manual Gun



Pneumatic Gun

## Manual Applicator Gun

This applicator gun is designed for use with SpeedGrip Adhesives either 200 ml or 220 ml cartridges 1:1 or 2:1.

## Manual Gun

This applicator gun is designed for use with SpeedGrip Adhesives 50 ml cartridges 1:1.

## Pneumatic Applicator Gun

This applicator gun is designed for use with SpeedGrip Adhesives either 200 ml or 220 ml Pneumatic Gun cartridges 1:1 or 2:1.

PART #	PKG/CASE	DESCRIPTION	SIZE
636425 <b>41400</b>	1/1	Manual Applicator Gun for 200ml/220ml	1:1 and 2:1
636425 <b>97117</b>	1/1	Manual Gun for 50ml	1:1
636425 <b>41399</b>	1/1	Pneumatic Applicator Gun for 200ml/220ml	1:1 and 2:1



## Mixing Tips

Mixing tips ensure automatic mixing for optimal performance.

PART #	PKG/CASE	DESCRIPTION	MIXING TIP	COLOR
636425 <b>04628</b>	6/60	All 220 ml	24 elements	Green
636425 <b>97118</b>	6/72	All 50 ml	16 elements	White



## Nylon Reinforcing Tape

Self-adhesive backing tape for repairing and filling holes and plastic gouges. It can be used for both urethane and epoxy adhesives.

PART #	PKG/CASE	SIZE
636425 <b>04632</b>	1/6	2" x 65'



## Mixing Spreader with Tapered Edges

For use with #06400 Plastic Repair Skim-Plus.

PART #	PKG/CASE	SIZE
636425 <b>06396</b>	25/100	3" x 4"



## Sprayable Seam Sealer S-4 Kit

The S-4 (Sprayable Seam Sealer System) Starter Kit includes one S-4 Atomization Unit with a standard M style air fitting (which can be changed out), a bag of six S-4 Mixing Tips and instructions for use.

The S-4 Atomization Unit attaches to the bottom of the Pneumatic Applicator Gun (#41399) and can easily adjust the air pressure as needed. The unique S-4 Mixing Tip (#06404) screws onto the cartridge, and the opposite end of the tip attaches to the hose on the S-4 Unit.

PART #	DESCRIPTION
636425 <b>06403</b>	S-4 Starter Kit
636425 <b>06404</b>	S-4 Mixing Tips

## Availability

PART #	QUANTITY PKG/CASE	DESCRIPTION	SIZE	COLOR	OPEN TIME	WORK TIME	HANDLING/ CLAMP TIME	SANDING TIME	PAINT TIME	CURE TIME	OEM APPROVALS
<b>ACRYLIC ADHESIVES</b>											
636425 <b>06419</b>	1/6	Metal Door Skin Bonding	220 ml 2:1	Green		45 min	1½ hrs			8 hours	Ford: WSS-M2G410-A2 GM: 6449G
636425 <b>06420</b>	1/6	Metal Panel/Weld Bonding	220 ml 2:1	Gray		75 min	2½ hrs			8 hours	Chrysler: MS-CD507
<b>URETHANE ADHESIVES</b>											
636425 <b>97122</b>	1/12	Adhesive 45 second	50 ml 1:1	Opaque	30 sec	45 sec	2½ min	5-7 min*		24 hours	
636425 <b>04647</b>	1/6	Adhesive 45 second	220 ml 1:1	Opaque	30 sec	45 sec	2½ min	5-7 min*		24 hours	
636425 <b>04615</b>	1/6	Adhesive 1 minute	220 ml 1:1	Black	1 min	1½ min	7 min	12-20 min*	1 hour	24 hours	
636425 <b>04616</b>	1/6	Structural Adhesive 5 minute	220 ml 1:1	Black	5 min	7 min	15 min	45 min	2 hours	24 hours	
636425 <b>04617</b>	1/6	Structural Adhesive 15 minute	220 ml 1:1	Black	15 min	20 min	45 min	90 min	3 hours	24 hours	
636425 <b>04625</b>	1/12	Adhesion Promoter - Aerosol	333 grams								
<b>EPOXY ADHESIVES</b>											
636425 <b>06400</b>	1/6	Plastic Repair Skim-Plus	220 ml 1:1	Blue		1-2 min		15-20 min*	60 min	60 min	
636425 <b>06412</b>	1/6	Repair and Filler	220 ml 1:1	Purple		5 min		15-30 min*	15-30 min	6-8 hours	
636425 <b>06417</b>	1/6	SMC/Fiberglass Repair	220 ml 1:1	Beige		40 min		10 min @ 180°F	60 min @ 180°F	60 min @180°F 24 hrs @70°F	Ford: SMC panel repair GM: SMC panel repair
636425 <b>06418</b>	1/6	Panel Bonder	220 ml 1:1	Black		30 min	2 hours	3 hours		24 hours	
636425 <b>06421</b>	1/6	Panel Bonder	220 ml 2:1	Black		90 min	4 hours	8 hours		24 hours	
636425 <b>06427</b>	1/6	Impact Toughened Structural Adhesive	220 ml 2:1	Purple		90 min	120 min			10 hours	GM: Repair impact- resistant joints
<b>EPOXY SEAM SEALERS</b>											
636425 <b>97120</b>	1/6	Seam Sealer	220 ml 1:1	Black		8-10 min		30 min	30 min	2 hours	
636425 <b>06402</b>	1/6	Seam Sealer - Controlled flow	220 ml 1:1	Cream		5-10 min		30 min	30 min	2-3 hours	
636425 <b>97121</b>	1/6	Seam Sealer Self-Leveling	220 ml 1:1	Black		5-10 min		30 min	30 min	2 hours	
636425 <b>06398</b>	1/6	Bare Metal Seam Sealer	220 ml 1:1	Gray		10-15 min			45 min	6-8 hours	
<b>FOAMS</b>											
636425 <b>04622</b>	1/4	Flexible Urethane Foam	220 ml 1:1	Gray		3-5 sec			15 min	15 min	
636425 <b>06399</b>	1/4	Rigid Urethane Foam	220 ml 1:1	Yellow		10-25 sec			15 min	45 min	
<b>ACCESSORIES</b>											
636425 <b>41399</b>	1/1	Pneumatic Gun	1:1 and 2:1								
636425 <b>41400</b>	1/1	Manual Gun	1:1 and 2:1								
636425 <b>97117</b>	1/1	Gun for 50 ml	1:1								
636425 <b>97118</b>	6/72	Mixing Tips 16 element	For 50 ml	White							
636425 <b>04628</b>	6/60	Mixing Tips 24 element	For 220 ml	Green							
636425 <b>04632</b>	1/6	Nylon Reinforcing Tape	2" x 65'								
636425 <b>06396</b>	25/100	Spreader for Skim-Plus	3" x 4"	Black							
636425 <b>06403</b>	1/1	S-4 Starter Kit									
636425 <b>06404</b>	6/60	S-4 Mixing Tips									

\* Sanding time depends on film thickness \*\* Up to 30 days  
Times are @ 70°F/21°C except #06421 @ 77°F / 25°C

## QUALITY THAT PAYS™

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## CUSTOMER SERVICE:

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