

DESCRIPTION

Quick Set 20 is a very fast, two-component urethane adhesive designed for bumper tab repair and bonding most small plastic, steel and aluminum parts.

FEATURES

- **DUAL-MIX™** Forever Warranty
- High strength and sandable
- Bonds almost anything
- Non-sag formula fills gaps
- Colorless
- Super-fast setting

SUITABLE SUBSTRATES

- Plastic
- Steel
- Aluminum

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
40202	Quick Set 20	Clear	1.7 oz. Cartridge
40207	Quick Set 20	Clear	7 oz. Cartridge

Working time:	15 seconds @ 70°F (21°C)
Set time:	20 seconds @ 70°F (21°C)
Cure time:	15 minutes @ 70°F (21°C)
Lap shear @70°F (21°C) (psi) on steel:	2300+ ASTM D 1002

Check local VOC regulations to ensure compliance of all products in your area.

HANDLING AND APPLICATION

PREPARATION:

FOR PLASTIC:

1. Clean with **Scuff & Clean** and rinse with water.
2. Clean with **Plastic & Leather Prep** or **Zero VOC Surface Cleaner**.
3. Sand area to be repaired with 24-36 grit paper and blow off dust.



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For application on TPO, EPDM, PP and other similar thermoplastics, use **Plastic Adhesion Promoter** or **XXX Adhesion Promoter** per instructions.

FOR METAL:

- 1.** Clean with **SEM Solve** or **Zero VOC Surface Cleaner**.
- 2.** Sand with 80 grit paper and blow off dust.
- 3.** Re-clean with **SEM Solve** or **Zero VOC Surface Cleaner**.

MIXING:

Place cartridge into the **Universal Manual Applicator** or the **1.7 oz. Manual Applicator**. To remove cap, insert flat head screwdriver into slot and pry upward.

Note:

For cap replacement, match circles and squares, and snap back into place. When using 1.7 oz. cartridges, twist the blue retaining nut and remove. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired application size.

STATIC MIXERS:

Part:	Product Name:	For:	Container:
70011	Integral Nut Square Static Mixers	7 oz. cartridge	6 Pack
70012	Integral Nut Square Static Mixers	7 oz. cartridge	50 Pack
70020	1.7 oz Turbo Static Mixers	1.7 oz. cartridge	6 Pack
70021	1.7 oz Turbo Static Mixers	1.7 oz. cartridge	50 Pack

APPLICATION:

GENERAL PURPOSE BONDING:

- 1.** Prepare surface as outlined in Preparation section.
- 2.** Dry fit parts to ensure proper alignment.
- 3.** For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied.

Note:

Do not allow **Quick Set 20** to flow over masked area or onto painted surface.

- 4.** Apply **Quick Set 20** to either surface.
- 5.** Quickly bond the two surfaces. Hold or clamp together until set.



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FOR TAB REPAIR USING PLASTIC REPAIR CONTOURING TAPE:

1. Prepare surface as outlined in Preparation section.
2. For badly torn damage, drill 1/8" holes approximately 1/2" apart into the repair area. This will help lock the repair material in place.
3. Cut a piece of **Plastic Repair Contouring Tape** twice the length of the repair.
4. Dispense **Quick Set 20** onto **Plastic Repair Contouring Tape**. Quickly apply both to the repair area and mold into shape using gloved hands or a spreader.
5. Allow the repair material to cure for 5 minutes before removing the plastic film.
6. Sand with a 80-180 grit disc to desired shape and drill as needed.

Note:

WORK QUICKLY! The repair material will set in 20 seconds.

CAUTION:

Quick Set 20 can get very hot while curing.

STORAGE:

Quick Set 20 should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Quick Set 20** is 1 year when stored under optimal conditions.

RELATED PRODUCTS

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	Aerosol
39864	Plastic Adhesion Promoter	Quart
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart
70007	Plastic Repair Contouring Tape	15' Roll
70011	Integral Nut Square Static Mixers	6 Pack



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70012	Integral Nut Square Static Mixers	50 Pack
70019	1.7 oz Manual Applicator Gun	1 Each
70020	1.7 oz Turbo Static Mixers	6 Pack
70021	1.7 oz Turbo Static Mixers	50 Pack
71119	Universal Manual Applicator Gun	1 Each
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	Aerosol
77724	XXX Adhesion Promoter	Quart

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:

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Users should review the Safety Data Sheet (SDS) 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 SDS and product label are available upon request.