



**Urethane formula  
bonds all  
materials**

**Minimal inventory  
handles multiple  
applications**

**Full range of  
products**

#### FEATURES

- High strength structural bonding
- Various work times

#### BENEFITS

- Faster repair time than welding and no heat warpage
- OEM quality and performance
- Outstanding corrosion protection
- Faster unclamp time to increase productivity



## SpeedGrip Structural Adhesives – Urethane

Norton SpeedGrip Structural Adhesive is a versatile and fast two part urethane system for bonding and repairing steel, aluminum, flexible, semi-rigid and rigid plastic and fiberglass. All products perform the same on all materials. Just select the working time that best fits your needs. If working with TPO, adhesion promoter must be used.

DESCRIPTION	SIZE	636425-
45 seconds	50ml	97122*
45 seconds	220 ml	04647
1 minute	220 ml	04615
5 minutes	220 ml	04616
15 minutes	220 ml	04617
40 minutes	220 ml	04618
CASE		6
*CASE		12



### Five Work Time Windows

PART NUMBER	OPEN TIME	WORK TIME	CLAMPING OR FIXTURE TIME	SANDING OR PAINTING TIME
97122 / 04647	45 seconds	–	2-1/2 minutes	5 minutes
04615	1 minute	1-1/2 minutes	7 minutes	12 minutes
04616	5 minutes	7 minutes	15 minutes	45 minutes
04617	15 minutes	20 minutes	45 minutes	90 minutes
04618	40 minutes	60 minutes	2 hours	3 hours

Times will increase as temperatures decrease.

Times shown above are at 70F/21C.

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: PRIMER (EITHER 2 PART EPOXY OR 2 PART URETHANE OR SKIM COAT OVER THE SPEEDGRIP REPAIR AREA USING SPEEDGRIP FLEXIBLE REPAIR ADHESIVE).



## SpeedGrip TPO Adhesion Promoter

SpeedGrip TPO Adhesion Promoter is available in both aerosol and brush top. To test for TPO plastic, lightly sand an inconspicuous spot on the plastic to be repaired with a 36 grit Speed-Lok TR disc. If the area melts and/or smears, then it is TPO plastic. If it sands cleanly, then it is not TPO.

DESCRIPTION	SIZE	636425-
TPO Adhesion Promoter Brush Top	118 ml	04624
TPO Adhesion Promoter Aerosol	333 grams	04625
CASE		12

**NORTON**



### SpeedGrip Seam Sealers – Epoxy

This seam sealer is available in two formulations and both are paintable in 30 minutes.

SpeedGrip Seam Sealer is used to seal interior and exterior seams, joints and voids. It will not shrink, harden or crack and retains its flexibility. For use on vertical and horizontal seams.

DESCRIPTION	SIZE	636425-
Seam Sealer	220 ml	97120
Seam Sealer – Self Leveling	220 ml	97121
CASE		6

#### Work Times

PART NUMBER	WORK TIME	SANDING/ PAINT TIME	FULL CURE
97120	8-10 minutes	30 minutes	2 hours
97121	5-10 minutes	30 minutes	2 hours



### Panel Bonding Adhesive – Epoxy

Two-part automatic mixing epoxy to bond Steel, Aluminum, SMC and fiberglass body panels to each other and to metal frames (no primer required).

- Outstanding sag resistance
- Longest work time for bonding large areas
- Minimal odor
- Glass beads for spacing

DESCRIPTION	SIZE	636425-
Panel Bonding Adhesive 2:1	220ml	06115
CASE		6

#### Working Time

WORK TIME	CLAMPING / FIXTURE TIME	CURE TIME
90 minutes	4 hours	24 hours



### Flexible Parts Repair Adhesive and Filler – Epoxy

Two-part automatic mixing epoxy to repair most plastic parts, including bumper covers and plastic body panels. Formulated to finish the front side of flexible repairs used over the top of urethane adhesives. Use TPO Adhesion Promoter on TPO plastics.

- Designed to be used as a filler and adhesive
- Epoxy based for easy sanding
- Formulated for excellent feather edge
- Flexible through a wide range of temperatures

DESCRIPTION	SIZE	636425-
Epoxy Repair Adhesive and Filler	200ml	06116
CASE		6

#### Working Time

WORK TIME	SANDING TIME	CURE TIME	FULL CURE
6 minutes	15 minutes	60 minutes	6 hours



### SpeedGrip Urethane Foam

Two-part gray, flexible urethane foam formulated to expand 10 times its original volume. Used to stop wind, noise and water leaks in pillar posts. Adds reinforcement to panels. Matches OEM flexible foams.

DESCRIPTION	SIZE	636425-
Flexible Urethane Foam	220 ml	04622
CASE		4

## Accessories



### Heavy-Duty Manual Applicator Gun – 1:1 and 2:1

Heavy-duty manual applicator gun designed for SpeedGrip Structural Adhesive system. Can be used for either 200 ml or 220 ml cartridges.



### Pneumatic Applicator Gun – 1:1 and 2:1

Pneumatic applicator gun designed for SpeedGrip Structural Adhesive system. Can be used for either 200 ml or 220 ml cartridges.



### 50 ml Gun – 1:1

Manual gun used with the 50 ml cartridge.



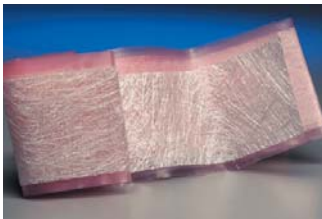
### Mixing Tips

18-element and 24-element mixing tips ensure automatic mixing for 220 ml. 16 element mixing tips are used with the 50 ml cartridge.

DESCRIPTION	636425-	636425-	636425-	636425-
Heavy Duty Manual Applicator Gun 1:1 & 2:1	41400	–	–	–
Pneumatic Applicator Gun 1:1 & 2:1	41399	–	–	–
50 ml Applicator Gun 1:1	97117	–	–	–
Mixing Tips – 18 element (blue) 220 ml	–	04627	–	–
Mixing Tips – 24 element (green) 220 ml	–	–	04628	–
Mixing Tips – 16 element (white) 50 ml	–	–	–	97118
CASE	1	6/60	6	6/72

### Mixing Tip Application Guide

PRODUCT	MIXING TIP
All Urethane and Foam 220 ml	#04627 – 3/8" x 18 elements (Blue)
All Epoxy 220 ml	#04628 – 3/8" x 24 elements (Green)
All 50 ml	#97118 – 16 elements (White)



### Structural Backing Patch

Combination of fiberglass cloth, fiberglass reinforcing tape and release film to provide additional strength to the repair.

Size: 4" x 72"



### 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. Size: 2" x 65'



### Plastic Contour Release Film

Film to be overlaid just after SpeedGrip has been applied to prevent air entrapment. Use Release Film to force the adhesive into the groove and shape it closely to the original contour of the plastic. Size 5" x 72", 5 mil thick.



### Plastic Parts Cleaner

Selected combination of solvents that remove wax, grease, and silicone from all plastic and rubber parts. This cleaner is safe for use on all types of plastics and does not leave any residue.

DESCRIPTION	SIZE	636425-	636425-	636425-	636425-
Structural Backing Patch	4" x 72"	04631	–	–	–
Nylon Reinforcing Tape	2" x 65'	–	04632	–	–
Plastic Contour Release Film	5" x 72"	–	–	04633	–
Plastic Parts Cleaner	1 Qt./946 ml	–	–	–	04623
CASE		6	6	6	12