



4020() QUICK SET 20

TECHNICAL DATA SHEET

Description

4020() QUICK SET 20 is a fast curing, general purpose urethane adhesive designed for automotive plastic repair. **4020()** is an excellent choice for quickly repairing bumper brackets, tabs, headlight buckets and grills. In addition, **4020()** may be used for bonding backer panels, moldings, emblems and most small plastic, metal and aluminum parts. **4020()** is sandable, has high strength and offers excellent gap filling properties.

Features

- Urethane technology
- Non-sagging
- High strength
- Gap filling
- Super fast setting
- Sandable
- Bonds most plastics

Typical Properties

Containers	40207 - 7 oz. DUAL-MIX cartridge 40202 - 1.7 oz. cartridge
Color	Clear/opaque
Working time	15-30 seconds @ 70°F (21°C)
Set time	<5 minutes @ 70°F (21°C)
Cure time	45-60 minutes @ 70°F (21°C)
Tensile strength	4750-4800 psi
Elongation	14-19%

Handling and Application

PREPARATION:



Clean with **38338 SCUFF & CLEAN** and rinse with water. Next, clean with **3835() PLASTIC/LEATHER PREP**. Apply according to directions. Sand area to be repaired with 180 grit paper. Blow off dust and re-clean with **3835()**. For application on TPO, EPDM, PP and other similar thermoplastics, use **3986() PLASTIC ADHESION PROMOTER** per instructions.

MIXING:



Place cartridge into **70029 DUAL-MIX APPLICATOR GUN** or **70019 1.7 oz. MANUAL APPLICATOR GUN**. To remove cap, insert flat head screwdriver into slot and pry upward. **NOTE:** For cap replacement, match circles and square, 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.

APPLICATION:



General purpose bonding:

1. Clean 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. **DO NOT ALLOW 4020() TO FLOW OVER MASKED AREA OR ONTO PAINTED SURFACE.**
4. Apply **4020()** to either surface.
5. Quickly bond the two surfaces. Hold or clamp together until set.

APPLICATION

Cont':



For tab repair using **70007 PLASTIC REPAIR CONTOURING TAPE**:

1. Clean surface as outlined in Preparation section.
2. Drill $\frac{1}{8}$ " holes approximately $\frac{1}{2}$ " apart into the repair area. This will help lock the repair material in place.
3. Cut a piece of **70007** twice the length of the repair.
4. Dispense **4020()** onto **70007**. Quickly apply **70007** and **4020()** to the repair area and mold into shape using your hands or a spreader.
5. Allow the repair material to cure for 5 minutes before removing the plastic film.
6. Sand with a 36 grit disc to desired shape and drill as needed.

NOTE: WORK QUICKLY! The repair material will set in 15-30 seconds.

CAUTION: 4020() can get very hot while curing.

STORAGE:



4020() QUICK SET 20 should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. Product should be refrigerated at 40°F (4.4°C) for maximum shelf life. The shelf life for **4020()** is 1 year when stored under optimal 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.

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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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