



4020() QUICK SET 20 4050() QUICK SET 50

4020() QUICK SET 20 and 4050() QUICK SET 50 are fast curing urethane adhesives designed for automotive plastic repair. 4020() and 4050() are excellent for repairing tabs and brackets as well as bonding most small plastic, metal and aluminum parts.

PREPARATION:



Clean with **38338 SCUFF & CLEAN** and rinse with water. Next, clean with **3835() PLASTIC/LEATHER PREP**. Apply according to instructions. 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 TO FLOW OVER MASKED AREA OR ONTO PAINTED SURFACE.**
4. Apply **4020()** or **4050()** to either surface.
5. Quickly bond the two surfaces. Hold or clamp together.

For tab repair using 70007 PLASTIC REPAIR CONTOURING TAPE:

1. Clean surface as outlined in Preparation section.
2. 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 **70007** twice the length of the repair.
4. Dispense **4020()** or **4050()** onto **70007**. Quickly apply **70007** and repair material to the repair area and mold into shape using your hands or a spreader.

NOTE: Work quickly – the repair material will set in 15–30 seconds using **4020()** and 45–60 seconds using **4050()**.

5. **CAUTION: 4020()** or **4050()** can get very hot while curing.
6. Allow the repair to cure for 5 minutes before removing the plastic film.
7. Sand with a 36 grit disc to desired shape and drill as needed.

For additional information, refer to the **QUICK SET TECHNICAL DATA SHEETS** or contact us at www.sem.ws.



The Right Choice

SEM PRODUCTS, INC. • 651 Michael Wylie • Charlotte, NC 28217-1546

704-522-1006 • 800-831-1122

www.sem.ws

