



## **ADHESION PRODUCTS**

22290 Challenger Drive  
Elkhart, IN 46514  
(574) 970-8425 (O)  
(574) 970-8426 (F)

### **TECHNICAL DATA SHEET**

#### **AP-602 HV High Viscosity**

#### **PRODUCT DESCRIPTION:**

Adhesion Product's AP-602 HV is a High Viscosity VOC compliant adhesive/sealant designed for transportation and product assembly applications. It is non-yellowing, environmentally friendly, solvent and isocyanate free. AP-602 HV is designed for primerless adhesion to most common transportation assembly substrates. It is a cost effective sealant that won't shrink like most single component products used. The high viscosity, high strength, low temperature flexibility, and ease of a one-part make AP-602 HV the perfect choice for production assembly operations. Conforms to ASTM C920 Class 12.5. USDA Accepted.

#### **PRODUCT BENEFITS**

- Bonds and Seals at same time
- One Part Formulation
- Fast cure
- Adhesion to wide range of substrates
- Short tack free and curing time
- Non-staining curing process
- Sandable and paintable
- Shock/impact resistance
- Vibration and sound dampening

#### **SURFACE PREPARATION:**

All surfaces should be clean, dry, and free of dust and grease. No primer required for non-porous surfaces.

#### **SHELF LIFE:**

12 months in unopened packaging in a cool and dry storage place at temperatures between +41° F and +77° F

#### **STANDARD COLOR:**

Black, White, Aluminum

#### **PACKAGING:**

20 oz. sausage packs, 1 gl, 5 gl. And 55 gl containers.

#### **Cleanup:**

Uncured material can be wiped from surfaces using mineral spirits and Kent Acrysol.

#### **Limited Warranty:**

Adhesion Products warrants product to be of good quality and will replace or, at our election, refund the purchase price of any products proved to be defective. Satisfactory results depend not only upon quality products, but also upon many factors beyond our control. Therefore, except for such replacement or refund, ADHESION PRODUCTS MAKES NO WARRANTY OR GUARANTEE, EXPRESSED OR IMPLIED, INCLUDING WARRANTIES OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, RESPECTING ITS PRODUCTS, and ADHESION PRODUCTS shall have no other liability with respect thereto. Any claim regarding product defect must be received in writing one (1) year from the date of shipment. No claim will be considered without such written notice or after the specified time interval. User shall determine the suitability of the products for the intended use and assume all risks and liability in connection therewith.



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## TECHNICAL SPECIFICATIONS:

UV Rating (ASTM G26)	After 2000 hrs UV-A no change in appearance or physical properties
Tack Free Time	Less than 45 minutes @ 77°F/50% RH
Skin Time	Less than 30 minutes @ 77°F/50% RH
Sag	Non-sagging
Tensile Strength (ASTM D412)	225 psi
100% Modulus (ASTM D412)	200 psi
Lap Shear	275 psi
Elongation	275%
High Temperature Resistance	Up to 350°F for short periods
Low Temperature Flexibility	Properties retained to -75°F
Shore A	50
Corrosive Properties	Non-corrosive
Staining	Non-staining
Primerless Adhesion	100% cohesive failure on most common substrates

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**COVERAGE:**

For a .063" bond line thickness, a .250" bead will spread to a bond width of .750"  
For a .031" bond line thickness, a .188" bead will spread to a bond width of .750"  
Bond line thickness of less than .031" should be avoided

**SURFACE PREPARATION:**

AP-602 HV bonds to aluminum, galvanized steel, stainless steel, fiberglass, most paints and primers and many plastics including polyester, PVC and ABS. Not recommended for use on Polyethylene, polypropylene, TPO, and PTFE without surface treatment.

Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying AP-602 HV. Testing a small area for compatibility is recommended. Uncured sealant can be removed easily with mineral spirits and many industrial cleaning solutions. Cured material will need to be physically removed.

**PAINTING:**

Cured product may be painted with most industrial & consumer paints. Testing prior to paint is end customer responsibility.

**PRECAUTIONS:**

Use with adequate ventilation. Inhalation of vapor during application and cure may cause slight eye or throat irritation. In case of contact with eyes, lips, or mouth, flush thoroughly with water. If irritation persists, consult a physician. Avoid repeated, prolonged contact with skin. See SDS for additional information. **KEEP OUT OF REACH FROM CHILDREN.**

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