



TECHNICAL DATA

MANUS-BOND 25-AM HIGH STRENGTH/FAST CURE Adhesive/Sealant

1. PRODUCT DESCRIPTION:

Manus-Bond 25-AM is a high strength, fast cure adhesive/sealant. 25-AM exhibits excellent primerless adhesive properties to most common trailer and construction assembly substrates including aluminum, brass, vinyl, steel, stainless steel, glass, mortar, concrete, wood, painted surfaces, fiberglass and many plastics. 25-AM is highly weather resistant, remains flexible in low temperature extremes and can be painted with most paints. Contains no solvents or isocyanates and is non-yellowing. Reduces mechanical fasteners.

2. TECHNICAL DATA:

Specific Gravity	1.37-1.41
Color	White, Gray, Black, Almond
Skin Time @ 75°F & 50%RH	Less than 30 minutes
Cure Rate @ 75°F & 50%RH for 24 hours	0.15"
Hardness, Shore A	50
Sag	Nil
100% Modulus ASTM D412 *Rate = 2"/minute	118 psi
Tensile Strength ASTM D412 *Rate = 2"/minute	475 psi
Lap Shear Strength ASTM D1002 *Rate = 2"/minute	550 psi
% Elongation	500%
Peel Strength ASTM C794	110 pli
Service Temperature Range	-75°F to 350°F
Movement Capability	25%
UV Resistance	After 2000 hours UV-A no change in appearance or physical properties (ASTM G26)
VOC Content	15 grams/liter

*Above values are typical values for the material, but not intended for use in specifications. Field conditions may yield different results.

3. **COLORS:**
White, Gray, Black and Almond. Other colors available upon request.
4. **PACKAGING:**
10.1 and 28fl.oz. cartridges, 10 and 20 fl.oz. sausage packs, 1, 5 and 52 gallon containers
5. **SURFACE PREPARATION:**
Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying product. Some substrate materials may not be compatible with this product. Testing substrate compatibility with this product before full application is recommended.
6. **PAINTING:**
Cured product may be painted with most industrial & consumer paints. Testing prior to painting is recommended.
7. **STORAGE LIFE:**
For maximum shelf life, store unopened product at or below 80°F.
12 months = cartridges and sausage packs
6 months = 1, 5 and 55 gallon containers
8. **PRECAUTIONS:**
Some applications may not be compatible with this product. Testing suitability for intended application before proceeding with full application is recommended. 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 MSDS for additional information. **KEEP OUT OF REACH FROM CHILDREN.**
9. **TECHNICAL SERVICE:**
Manus technical representatives are always available to provide assistance. Please contact our Technical Service Department with your questions or requests for specific applications.
10. **LIMITED WARRANTY:**
Any goods prove defective will be replaced or the purchase price refunded. The limited warranty described herein is in lieu of any other warranty, expressed or implied, including any implied warranty of merchantability or fitness for a particular use. The user shall determine suitability of the product for its intended use. Liability for any incidental or consequential damage or loss is excluded. The user assumes all risks of the product's use, handling and storage.

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