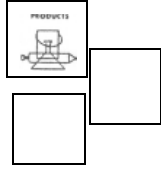


HI-COMPRESSION TAPES  
 ADHESIVES • SEALANTS SPECIAL  
 INDUSTRIAL PAINTS CUSTOM  
 MECHANICAL EQUIPMENT

SALES • SERVICE ENGINEERING  
 CONSULTING  
 ENGINEERING NEW  
 PRODUCT DESIGN



# TECHNICAL DATA

## MANUS – BOND 75-AM Fast Cure N33-1

### 1. PRODUCT DESCRIPTION:

Manus-Bond 75-AM Fast Cure (N33-1) is an environmentally friendly, VOC compliant adhesive for the transportation industry. Manus-Bond 75-AM Fast Cure (N33-1) is designed for primerless adhesion to most common trailer assembly substrates. The fast cure, high strength, low temperature flexibility, and ease of a one-part make Manus-Bond 75-AM Fast Cure (N33-1) the perfect choice for both manufacturing and repair.

### 2. TECHNICAL DATA:

Specific Gravity	1.38-1.42
Tack Free Time	Less than 30 minutes @ 77°F/50% RH
Skin Time	Less than 15 minutes @ 77°F/50% RH
Sag	Non-sagging
Tensile Strength	350 psi
100% Modulus	200 psi
Lap Shear	325 psi
Adhesion-in-Peel Strength	35 PLI
Elongation	Approx. 300%
High Temperature Resistance	Up to 350°F for short periods
Low Temperature Flexibility	Properties retained to -75°F
Shore A	45-50
Corrosive Properties	Non-corrosive
Staining	Non-staining
Primerless Adhesion	100% cohesive failure on most common substrates

### 3. PACKAGING:

10.3 fl.oz. cartridges and sausage packs; 20 fl.oz. sausage packs; 1, 5 and 50 gallon containers.

### 4. SURFACE PREPARATION:

Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying 75-AM. Testing a small area for compatibility is recommended.

**5. PAINTING:**

Cured product may be painted with most industrial & consumer paints. Testing prior to painting is recommended.

**6. STORAGE LIFE:**

12 months. For maximum shelf life, store unopened product at or below 80°F.

**7. 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 MSDS for additional information. KEEP OUT OF REACH FROM CHILDREN.

**8. 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.

**9. 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.