



# TECHNICAL DATA

## MANUS – BOND 75-UHVFC

### 1. PRODUCT DESCRIPTION:

Manus-Bond 75-UHVFC is an STPE or MS Polymer compound. It is non-yellowing, environmentally friendly, solvent and isocyanate free sealant/adhesive for the transportation industry. Manus-Bond 75-UHVFC is designed for primerless adhesion to most common trailer assembly substrates. It is designed to replace mechanical fasteners, yet cost effective enough to be used as a sealant as well. The fast cure, high strength, low temperature flexibility, and ease of a one-part make Manus-Bond 75-UHVFC the perfect choice for both manufacturing and repair. The higher viscosity formulation aids in toolability.

### 2. TECHNICAL DATA:

Specific Gravity	1.52-1.56
Tack Free Time	Less than 40 minutes @ 77°F/50% RH
Skin Time	Less than 20 minutes @ 77°F/50% RH
Sag	Non-sagging
Tensile Strength (ASTM D412)	285 psi
100% Modulus (ASTM D412)	200 psi
Lap Shear	300 psi
Peel Strength (ASTM D1781)	75 PLI
Elongation	Approx. 250%
High Temperature Resistance	Up to 350°F for short periods
Low Temperature Flexibility	Properties retained to -75°F
Shore A	55-60
Corrosive Properties	Non-corrosive
Staining	Non-staining
Primerless Adhesion	100% cohesive failure on most common substrates
UV Ratings	After 2000 hours UV-A no change in appearance or physical properties (ASTM G26)
VOC Content	12 g/liter
Shrinkage	Negligible

**3. PACKAGING:**

10.1 fl.oz. cartridges and sausage packs; 13.5 fl. oz. sausage packs; 20 fl.oz. sausage packs; 1, 5 and 55 gallon containers.

**4. SURFACE AND PREPARATION:**

75-UHVFC 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 75-UHVFC. 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.

**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. BEAD SIZE & COVERAGE:**

For a 1/16" bondline thickness, a ¼" bead will spread to a bond width of ¾"

For a 1/32" bondline thickness, a 3/16" bead will spread to a bond width of ¾"

Bondline thickness of less than 1/32" should be avoided

**8. 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.

**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.

**11. PRODUCT BENEFITS:**

- Bonds and Seals at same time
- One Part Formulation
- Replace rivets and mechanical fasteners
- High Thixotropy for good gap filling properties
- Adhesion to wide range of substrates
- Short tack free and curing time
- Non-staining curing process
- Initial load bearing capacity
- Sandable and paintable
- Increases torsional stiffness of final assembly
- Shock/impact resistance
- vibration and sound dampening