



DRIVING SURFACE PERFECTION™

STRONGHOLD 904

45 Minute Black Semirigid Adhesive for Doorskin, Metal, Aluminium, SMC & Fibreglass Bonding

TECHNICAL DATA SHEET

TECHNICAL DATA SHEET & PROCESS GUIDE

STRONGHOLD 904 is a 45 Minute Black Semirigid Adhesive for Doorskin, Metal, Aluminium, SMC & Fibreglass Bonding. Typical applications include doorskins, body kits, small panel and sectional replacements.

PROPERTIES and BENEFITS

- Non-sag
- Non-shrinking
- Can be sanded and over painted
- Excellent gap filling properties
- Once cured, STRONGHOLD 904 provides a bond of excellent strength and durability
- Bonds to Ferrous Metals & Aluminium, Zinc and Galvanised Metal, GRP / SMC/ Thermoset Composites, Rigid Thermoplastics and Wood
- Reduces risk of fire from the welding process.
- Reduces the risk of panel deformation & distortion due to overheating.
- Reduces corrosion by bonding and sealing in one operation.
- Used to secure dissimilar substrates e.g. steel to SMC.
- Bonding reduces labour time and material costs and does not require a specialist operator.

STRONGHOLD 904 is suitable for use on the following substrates:

- Ferrous Metals & Aluminium
- Zinc & Galvanised Metal
- GRP/SMC/Thermoset Composites
- Rigid Thermoplastics
- Wood

APPLICATION GUIDE

- Remove existing coatings/oxidation from all surfaces to be bonded using an abrasive no finer than P180 grit abrasive.
- Thoroughly clean areas to be bonded using PLAS/1 (Aerosol Metal Cleaner), or S2000 (water based Cleaner) ensuring any residue is removed using a lint free cloth. Plastic substrates should be treated with PLAS/2 (Aerosol adhesion promoter).
- Use the Stronghold adhesive selector chart to choose the most appropriate adhesive for the work piece. The choice will be determined by substrate/s work time plus the size & complexity of the repair.
- Remove the cartridge, mixing tip & locking nut from outer packaging & load the cartridge into the dispensing gun.
- Holding the gun & cartridge vertically up, remove the “break off tip” located at the top of the cartridge using either a set of pliers or similar equipment.
- Squeeze out a small amount of both parts A + B onto a piece of cloth & discard.
- Attach the mixing tip using the locking nut. If required, cut mixing tip to the desired diameter or angle.
- Dispense a small bead of product through the tip (approx 5cm / 2`) & discard - the product is now correctly equalised & ready for use.
- Apply a bead of adhesive to one of the surfaces to be bonded and smooth the adhesive to a tin film using an applicator.
- Now apply a second bead of adhesive to the same surface. Beach thickness should be approximately 5mm.
- The panels may now be aligned in preparation for clamping and curing..
- Any adjustments to alignments must be carried out immediately by sliding the panels against each other. DO NOT ATTEMPT TO SEPARATE THE PANELS ONCE CONTACT HAS BEEN MADE.
- Apply any clamps and/retaining devises as necessary. Remove any excess adhesive using a lint free cloth.
- Please Note: Cure time may be accelerated with infra red or low bake facilities.



Application and Drying Times

Work Time/Open Time 45 minutes

De-Clamping, Sanding and overpainting time 3 hours



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Optimum cure time 24 hours



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TECHNICAL DATA SHEET & PROCESS GUIDE STORAGE & VOC INFORMATION



Shelf Life

1 year from date of manufacture in sealed original sachets. Six months once out of sachet

Recommended Storage Temperature 5°C - 25°C

Order Codes		
SH90452 200ml cartridge		

IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the U-POL website at WWW.U-POL.COM. U-POL is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits.

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