

PANEL BONDING, PLASTICS, STEEL, FIBERGLASS – ONE LINE DOES IT ALL

www.nortonautomotive.com



SPEEDGRIP STRUCTURAL ADHESIVES

Whether you're working on Steel, SMC, FRP, fiberglass, rigid plastic, semi-rigid plastic, flexible plastic or panel bonding, Norton SpeedGrip Urethane and Epoxy Structural Adhesives get the job done. Put Norton SpeedGrip to the test in your shop.

NORTON



SPEEDGRIP STRUCTURAL ADHESIVES FROM NORTON



Availability

PART NUMBER	PKG. MIN.	CASE QTY.	PACKS/ CASE	DESCRIPTION	ADHESIVE COLOR	TYPE	SIZE	USE MIXING TIP
SPEEDGRIP EPOXY PANEL BONDING								
636425-06115	6	6	1	Epoxy Adhesive – 90 minutes	Black	Epoxy	220 ml	04628
SPEEDGRIP FLEXIBLE REPAIR EPOXY ADHESIVE AND FILLER								
636425-06116	6	6	1	Flexible Epoxy Repair	Gray	Epoxy	200 ml	04628
SPEEDGRIP URETHANE STRUCTURAL ADHESIVES								
636425-04647	6	6	1	30 seconds	Opaque	Urethane	220 ml	04627
636425-04615	6	6	1	1 minute	Black	Urethane	220 ml	04627
636425-04616	6	6	1	5 minutes	Black	Urethane	220 ml	04627
636425-04617	6	6	1	15 minutes	Black	Urethane	220 ml	04627
636425-04618	6	6	1	40 minutes	Black	Urethane	220 ml	04627
SPEEDGRIP EPOXY SEAM SEALERS – PAINTABLE IN 30 MINUTES								
636425-97120	6	6	1	Seam Sealer	Black	Epoxy	220 ml	04628
636425-97121	6	6	1	Seam Sealer – Self Leveling	Black	Epoxy	220 ml	04628
SPEEDGRIP FOAM								
636425-04622	4	4	1	Flexible Urethane Foam	Gray	Urethane	220 ml	04627
PLASTIC PARTS CLEANER								
636425-04623	12	12	1	Plastic Parts Cleaner			1 quart	
TPO ADHESION PROMOTER								
636425-04624	12	12	1	TPO Adhesion Promoter Brush Top			118 ml	
636425-04625	12	12	1	TPO Adhesion Promoter Aerosol			333 grams	
ACCESSORIES								
636425-41400	1	1	1	Heavy Duty Manual Applicator Gun				
636425-41399	1	1	1	Pneumatic Applicator Gun				
636425-04627	6	60	10	Mixing Tips 18 element (blue)				
636425-04628	6	6	1	Mixing Tips 24 element (green)				
636425-04631	6	6	1	Structural Backing Patch				
636425-04632	6	6	1	Nylon Reinforcing Tape				
636425-04633	6	6	1	Plastic Contour Release Film				
3" SPEED-LOK TR DISC								
662611-38674	25	25	1	36 Grit Disc NorZon (Blue)				
662611-62328	25	25	1	36 Grit Disc Norton SG Blaze (Orange)				
PANEL AND ADHESIVE CLEANER								
076607-82780	1	12	12	Adhesive Cleaner			1 quart	
ZINC RICH WELD-THRU PRIMER								
076607-82781	1	12	12	Aerosol Can			16 ounce	

URETHANE ADHESIVES

Norton SpeedGrip Urethane Structural Adhesives are a versatile and fast two part urethane system for bonding and repairing steel, aluminum, flexible, semi-rigid and rigid plastic and fiberglass. All products perform the same on all materials. Just select the working time that best fits your needs

Improve Repair Quality

- OEM quality and performance
- Outstanding corrosion protection
- High strength structural bonding
- 100% solids – no shrinkage

Increase Productivity

- Eliminate application of rust-inhibiting primers
- Faster unclamp times
- Fast application – apply adhesive to one side, not two
- Faster repair time than welding and no heat warpage

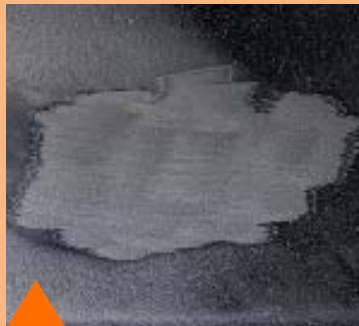


Question 1: IS IT TPO OR NOT?

A quick sand test will determine what type of plastic you're working on. Lightly sand an inconspicuous spot on the plastic to be repaired with 36 grit Speed-Lok TR Disc.



TPO PLASTIC, WHEN SANDED, WILL MELT AND SMEAR. TPO ADHESION PROMOTER (#04624 OR #04625) MUST BE USED PRIOR TO APPLYING SPEEDGRIP ADHESIVE.



IF THE PLASTIC POWDERS AND SANDS CLEANLY, THEN IT IS NOT TPO. DO NOT USE TPO ADHESION PROMOTER.

Question 2: WHAT'S THE WORK TIME WINDOW?

Depending on the size of the work area to be repaired the work time window will vary. We offer five different work time adhesives. Pick your time and you pick your adhesive. It's that simple.

Five Work time Windows

PART NUMBER	OPEN TIME	WORK TIME	CLAMPING OR FIXTURE TIME	SANDING OR PAINTING TIME
04647	30 seconds	–	2 1/2 minutes	5 minutes
04615	1 minute	1-1/2 minutes	7 minutes	12 minutes
04616	5 minutes	7 minutes	15 minutes	45 minutes
04617	15 minutes	20 minutes	45 minutes	90 minutes
04618	40 minutes	60 minutes	2 hours	3 hours

TIMES WILL INCREASE AS TEMPERATURES DECREASE.

TIMES SHOWN ABOVE ARE AT 70F/21C.

FULL CURE TIME IS 24 HOURS BUT THIS MAY BE ACCELERATED WITH HEAT.

SPEEDGRIP ADHESIVES SHOULD NOT BE USED FOR BONDING STRUCTURAL COMPONENTS SUCH AS RAILS, PILLARS, ROCKER PANELS, CORE SUPPORTS, ETC. IF IN DOUBT AS TO WHAT IS A STRUCTURAL COMPONENT, CONTACT THE VEHICLE MANUFACTURER.

DO NOT APPLY POLYESTER BASED FILLERS (POLYESTER PUTTY/FILLER) TO ANY URETHANE SPEEDGRIP ADHESIVE. IF POLYESTER BASED FILLER MUST BE USED, THE URETHANE SPEEDGRIP MUST BE SEALED WITH ONE OF THE FOLLOWING: PRIMER (EITHER 2 PART EPOXY OR 2 PART URETHANE).



FOR TECHNICAL HELP: 1 866 879-3761

EPOXY ADHESIVES

Superior two-part epoxy SpeedGrip adhesive designed to bond steel, aluminum, SMC, FRP and fiberglass auto parts and panels. It seals and bonds in one application. The longer work time to allows for adequate adjusting and handling. The glass beads mixed in this formulation provide the adequate spacing between parts for optimal bond strength.

Improve Repair Quality

- Glass beads for proper spacing
- Eliminates corrosion normally caused by welding
- Automatic mixing
- Superior sag resistance

Increase Productivity

- No primer required
- Easy to sand formulation



Panel Bonding Adhesive – 90 Minutes

Two-part epoxy used to bond Steel, Aluminum, SMC, FRP and fiberglass body panels to each other and to metal frames (no primer required).

- Automatic mixing
- Outstanding sag resistance
- Longest work time for bonding large areas
- Minimal odor
- Glass beads for adequate spacing
- 2:1 mixing ratio



PART NUMBER	WORK TIME	CLAMPING OR FIXTURE TIME	CURE TIME
06115	90 minutes	4 hours	24 hours

Flexible Parts Epoxy Repair Adhesive and Filler

Two-part SpeedGrip epoxy used to repair most plastic parts, including bumper covers and other plastic body panels. Formulated to finish the front side of flexible repairs used over the top of urethane adhesives. Use TPO Adhesion Promoter #04625 (aerosol) or #04624 (brush top) for System II plastics.

- Automatic mixing
- Epoxy based for easy sanding
- Designed to be used as a filler and adhesive
- Formulated for excellent feather edge
- Flexible through a wide range of temperatures



PART NUMBER	WORK TIME	SANDING TIME	CURE TIME	FULL CURE
06116	6 minutes	15 minutes	60 minutes	6 hours

Selecting SpeedGrip Mixing Tips

PART NUMBER	DESCRIPTION	18 ELEMENT BLUE 04627	24 ELEMENT GREEN 04628
06115	Epoxy 2:1		●
06116	Flex. Epoxy 1:1		●
04647	30 seconds 1:1	●	
04615	Adh. 1 Min. 1:1	●	
04616	Adh. 5 Min. 1:1	●	
04617	Adh. 15 Min. 1:1	●	
04618	Adh. 40 Min. 1:1	●	
97120	Seam Sealer 1:1		●
97121	Self Leveling 1:1		●
04622	Foam 1:1	●	

Adhesion Promoters

SpeedGrip TPO Adhesion promoter is available in both aerosol and brush top.



EPOXY SEAM SEALERS

**Paintable
in 30
Minutes!**

Seam Sealer

SpeedGrip Seam Sealer is used to seal interior and exterior seams, joints and voids. It will not shrink, harden or crack and retains its flexibility. For use on vertical and horizontal seams.

- Matches OEM seams
- No cracking or shrinkage
- Non-sagging, non-flowing sealer



#97120 SEAM SEALER
WORK TIME: 8 – 10 MINUTES
SAND/PAINT TIME: 30 MINUTES
FULL CURE: 2 HOURS

Self Leveling Seam Sealer

SpeedGrip Self Leveling Seam Sealer is formulated for use on roof channels, trunk seams and drip rails. For use on horizontal seams.

- Matches OEM seams
- No cracking or shrinkage



#97121 SELF-LEVELING SEAM SEALER
OPEN TIME: 5 – 10 MINUTES
SAND/PAINT TIME: 30 MINUTES
FULL CURE: 2 HOURS

URETHANE FOAM

Two-part flexible urethane foam formulated to expand 10 times its original volume.

- Expands to 10 times its volume
- Eliminates wind noise
- Matches OEM flexible foams



#04622 URETHANE FOAM
EXPANSION TIME: 5-9 SECONDS
WORK TIME: 15-20 SECONDS
CURE TIME: 5 MINUTES

ACCESSORIES

Applicator guns 1:1 and 2:1

Can be used for either 200 ml. or 220 ml. cartridges.



HEAVY DUTY MANUAL GUN #41400



PNEUMATIC GUN #41399

Structural Backing Patch

Combination of fiberglass cloth, fiberglass reinforcing tape and release film designed to provide additional strength to the repair.



STRUCTURAL BACKING PATCH #04631

Nylon Reinforcing Tape

Self-adhesive backing tape for repairing and filling holes and plastic gouges. It can be used for both urethane and epoxy adhesives.



NYLON REINFORCING TAPE #04632

Plastic Contour Release Film

Film to be overlaid on speedgrip adhesive just after it has been applied to prevent air entrapment. Use this Plastic Contour Release Film to force the bead of SpeedGrip adhesive into the groove and shape it closely to the original contour.



PLASTIC CONTOUR RELEASE FILM #04633

Plastic Parts Cleaner

Selected combination of solvents that remove wax, grease, and silicone from all plastic and rubber parts. This cleaner is safe for use on all types of plastics and does not leave any residue.



PLASTIC PARTS CLEANER #04623

Mixing Tips

PRODUCT	MIXING TIP	
All Urethane and Foam	#04627 - 3/8" x 18 elements	Blue
All Epoxy	#04628 - 3/8" x 24 elements	Green

SPEEDGRIP
 STRUCTURAL ADHESIVES

SPEEDGRIP

STRUCTURAL ADHESIVES



FOR TECHNICAL HELP: 1 866 879-3761

Ask your Norton Jobber for Details



HOW MUCH TIME CAN YOU SAVE WITH NORTON SPEEDGRIP STRUCTURAL ADHESIVES? TRY A LET'S TALK SHOP CLINIC AND SEE. EXPERIENCE NORTON HIGH PERFORMANCE FOR YOURSELF. AT A LET'S TALK SHOP CLINIC, SHOP PROS CAN ACTUALLY GET A CHANCE TO SEE HOW GOOD NORTON PRODUCTS ARE...UNDER REAL SHOP CONDITIONS...AGAINST ANY OTHER PRODUCT ON THE JOB. ASK YOUR NORTON REPRESENTATIVE HOW YOU CAN ATTEND ONE, EITHER IN YOUR OWN SHOP OR AT A LOCAL JOBBER.

NORTON®

NOTHING SAYS NORTON LIKE THE END RESULT

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NO-RISK
TEST POLICY
GUARANTEED

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