



CARBORUNDUM

CARBORUNDUM **EZ REPAIR ADHESIVES**

**NEW!**



***ez* REPAIR™**

Whether you're working on steel, SMC, FRP, fiberglass, rigid plastic, semi-rigid plastic, flexible plastic or panel bonding, Carbo EZ Repair Acrylic, Urethane and Epoxy Adhesives get the job done.



*legendary*  
**performance**

[www.carboauto.com](http://www.carboauto.com)

Ideal for metal bonding / Lifetime warranty

ACRYLIC – 2,500 PSI Lap shear strength makes acrylic adhesives one of the strongest available. It remains flexible and performs well at extremely low temperatures. Acrylic is the best choice for metal-to-metal bonding. For best results, grind the panel to bare metal.

EZ REPAIR

### GUARANTEED

Carborundum EZ REPAIR acrylic adhesives provide a lifetime corrosion and performance warranty.

### PRODUCTIVE

Reduces repair time versus welding, seals and bonds in one application and de-clamp in as little as 90 minutes.

### PRECISE CONTROL

Glass bead technology allows for correct panel spacing and perfect bond control.

### VERSATILE

Bonds a variety of substrates: automotive grade cold-rolled steel, galvanized steel, e-coat, aluminum and stainless steel, with minimal surface prep.

PART NUMBER	WORK TIME	CLAMP TIME	CURE TIME
99405	45 minutes	1-1/2 to 2 hours	8 hours
99404	75 minutes	2-1/2 to 3 hours	8 hours

Times will increase as temperatures decrease.

Times shown above are at 70°F/21°C.

EZ REPAIR 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.

**RESISTANCE TYPE SPOT WELDING:** Carborundum recommends resistance welding through Metal Bonding Adhesives in a wet or cured state with little to no burn back.

**MIG WELDING:** Carborundum Adhesive CANNOT be in the weld area or burn back will occur. We recommend at least 1" clearance from the weld site. A 1" clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.



### METAL DOOR SKIN BONDING ADHESIVE

#055395-99405

Two-part acrylic (2:1) for panel bonding of door panels, other body sheet metal, steel and aluminum.

- Bonds door panels to door frames without welding
- Work time 45 minutes
- Clamp time 1-1/2 hours
- Guaranteed corrosion protection

**OEM APPROVED**

Meets Ford WSS-M2G410-A2 and GM6449G Metal Bonding Specifications



### METAL PANEL/WELD BONDING ADHESIVE

#055395-99404

Two-part acrylic (2:1) for panel bonding and weld bonding of quarter panels, rear body panels, roof panels, door panels, van side panels and outer truck bed panels on bare metals, including aluminum.

- Long work time of 75 minutes for bonding large areas
- Guaranteed corrosion protection
- Perfect for high temperatures

**OEM APPROVED**

Meets Chrysler MS-CD507 Metal Bonding Specification

### Applications:

Bonding of patch panels and trailer side wall sections, etc.

Bonding of exterior body panels including door panels, quarter panels, roof panels, etc.

Can be used to weld and/or rivet bond structural or non-structural body panels. Follow OEM procedures.

### Applications:

Bonding of exterior body panels including door panels, quarter panels, roof panels, etc., when an extended working time is needed.

Can be used to weld and/or rivet bond structural or non-structural body panels. Follow OEM procedures.



Ideal for plastic repair / Stronger than original plastics

Urethane adhesives provide 3,500+ PSI Lap shear strength and perform well at higher temperatures. Urethanes work with most repair applications and are sandable. They are recommended for most plastic repair jobs.

## DURABLE

Stronger than the original plastics

## SANDS GREAT

Undetectable feather edge

## FAST

Sandable in as little as 5 minutes

## 100% SOLIDS

No shrinkage

PART NUMBER	OPEN TIME	WORK TIME	HANDLING TIME	SANDING TIME	PAINT TIME
<b>99400</b>	1 minute	1-1/2 minutes	7 minutes	12-20 minutes	1 hour
<b>99401</b>	5 minutes	7 minutes	15 minutes	45 minutes	2 hours
<b>99402</b>	15 minutes	20 minutes	45 minutes	90 minutes	3 hours

Times will increase as temperatures decrease.

Times shown above are at 70°F/21°C.

Full cure time is 24 hours but this may be accelerated with heat.

EZ REPAIR 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 EZ REPAIR ADHESIVE. IF POLYESTER BASED FILLER MUST BE USED, THE URETHANE EZ REPAIR MUST BE SEALED WITH ONE OF THE FOLLOWING: PRIMER (EITHER 2 PART EPOXY OR 2 PART URETHANE OR SKIM COAT OVER THE EZ REPAIR REPAIR AREA USING EZ REPAIR SKIM COAT EPOXY REPAIR/FILLER ADHESIVE #99403).

All are 220ml, 1:1 cartridges.



### EZ REPAIR 1 MINUTE

#055395-99400

Two-part urethane (1:1) used for structural and cosmetic repairs of all plastic bumpers including TPE, TPO, TEO, PP and ABS and can be used to bond SMC or fiberglass panels.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand
- Will not lift or roll up
- No plastic identification required with use of 99410 / 99411 adhesion promoter



### EZ REPAIR 5 MINUTES

#055395-99401

Two-part urethane (1:1) adhesive used for structural and cosmetic repairs of all plastic bumpers, bumper tabs, emblems, door trims, interior and exterior plastic repairs and cosmetic repairs including TPE, TPO, TEO, PP and ABS and can also be used to bond SMC or fiberglass panels.

- One product for all structural and cosmetic repairs on bumpers
- Easy to sand to a feather edge
- Good for elevated temperatures
- Will not lift or roll up
- No plastic identification required with use of 99410 / 99411 adhesion promoter
- Accelerate cure with heat (3 min @ 140°F)

#### Applications:

Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.

Repairs tears and holes on bumpers, trim, moldings, etc.

#### Applications:

Repairs bumper tabs, trim, and small plastic parts. Bonds plastic parts to plastic and coated metals.

Repairs tears and holes on bumpers, trim, moldings, etc.



**EZ REPAIR 15 MINUTES**

#055395-99402

Two-part urethane (1:1) adhesive used for installation of hood panels, roof panels, fenders, fender liners, fairings, spoilers, wind deflectors, cab extenders, ground effects, head lamp buckets and other body panels. For bonding fiberglass, SMC, carbon fiber and other plastics to itself and to primed metal.

- Easy to gun out
- One product for all structural and cosmetic repairs on bumpers
- Work window allows for larger repairs
- Perfect for elevated temperatures
- Easy to sand to a feather edge
- Non-sag formulation
- No plastic identification required with use of 99410 / 99411 adhesion promoter
- Accelerate cure with heat (10 min @140°F)

**Applications:**

Bonds composite materials to itself or to coated metals.



**ADHESION PROMOTER**

EZ REPAIR Adhesion Promoter is available in both aerosol and brush top. No need to identify plastic type – just simply apply to all plastics once, no need to re-apply. Allow for a 10 minute flash time.

- No plastic identification required.



PART NO.	DESCRIPTION	SIZE
99410	Brush Top	118 ml
99411	Aerosol	333 grams

**eZ REPAIR™**

Ideal for SMC and plastic repair / Works on various substrates

Epoxy adhesives work well at both high and low temperatures, have shear strength of 3,000 PSI and perform well filling gaps. Epoxy is considered to be rigid so they perform well for undetectable SMC repairs. They can be used with most other collision repair applications.

PART NUMBER	WORK TIME	CLAMP TIME	SANDING TIME	PAINT / CURE TIME
99403	1-2 minutes	–	15-20 minutes	60 minutes
99406	90 minutes	4 hours	8 hours	–

Times will increase as temperatures decrease.  
 Times shown above are at 70°F/21°C for 99403 and 77°F/25°C for 99406.  
 Full cure time is 24 hours but this may be accelerated with heat.

**RESISTANCE SPOT WELDING:** Recommend resistance welding through Multi-Bonder Adhesives in a wet state only with little to no burn back.

**MIG WELDING:** Multi-Bonder Adhesive CANNOT be in the weld area or burn back will occur. Recommend at least one inch clearance from the weld site. A one inch clearance will keep the adhesive from contaminating the weld site while positioning the panel on the vehicle. If using weld through primer, make sure to cover weld area on vehicle and replacement panel, but do not contaminate bond line areas.

EZ REPAIR



### SKIM COAT EPOXY REPAIR/FILLER

#055395-99403

Two-part epoxy (1:1) used to repair most plastic parts, including bumper covers and other plastic body panels including PP, fiberglass, Metton®, Telene®, SMC, TEO and urethane. Formulated to finish the front side of flexible repairs used over the top of urethane adhesives.

- Incredibly easy to sand in 20 minutes or less
- Designed to be used for minor scratches, gouges and pinholes
- No plastic identification required
- No Adhesion Promoter needed
- No tip needed – hand mix with a clean spreader #06396

#### Applications:

Repairs minor imperfections, pinholes, scratches, gouges, etc.



### EPOXY MULTI-BONDER

#055395-99406

Two-part epoxy (2:1) used to bond SMC, FRP, fiberglass, steel, aluminum body panels to each other and to metal frames (no primer required).

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

#### Applications:

Bond panels to various substrates and to metal frames

## SEAM SEALERS



### SEAM SEALER

#055395-99407

Two-part epoxy (1:1) 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 or horizontal seams.

- Paintable in 30 minutes
- Will not shrink or crack
- Matches OEM seams
- Non-sagging, non-flowing sealer



### SEAM SEALER-SELF LEVELING

#055395-99408

Two-part epoxy (1:1) is formulated for use on drip rails, trunk seams and roof channels. It will not shrink, harden or crack and retains its flexibility. For use on horizontal seams.

- Paintable in 30 minutes
- Will not shrink or crack
- Offers building characteristics that reduce running
- Matches OEM seams

PART NUMBER	WORK TIME	SANDING / PAINT TIME	FULL CURE
99407	8 – 10 minutes	30 minutes	2 hours
99408	5 - 10 minutes	30 minutes	2 hours

Times will increase as temperatures decrease.  
 Times shown above are at 70°F/21°C.

Right tools for the job / Minimal inventory required



### APPLICATOR GUN

#636425-41400

For either 200 ml or 220 ml cartridges 1:1 or 2:1



### MIXING TIPS

#636425-04628

24-element mixing tips are used for all 220ml cartridges to ensure automatic mixing. The tips are green.



### NYLON REINFORCING TAPE

#636425-04632

Self-adhesive backing tape for repairing and filling holes and plastic gouges. It can be used for both urethane and epoxy adhesives. Size: 2" x 65'.



### MIXING SPREADER WITH TAPERED EDGES

#636425-06396

3" x 4" For use with #99403 Skim Coat Epoxy Repair/Filler



EZ REPAIR Technical Help Line **1 866 879-3761** / For repair techniques and procedures, visit [www.carboauto.com](http://www.carboauto.com)

## EZ REPAIR AVAILABILITY

PART NUMBER	DESCRIPTION	SIZE	COLOR	QTY / PKG	QTY / CASE
<b>Acrylic</b>					
055395-99405	Metal Door Skin Bonding 45 Minute	220ml 2:1	Green	1	6
055395-99404	Metal Panel / Weld Bonding 75 Minute	220ml 2:1	Gray	1	6
<b>Urethane</b>					
055395-99400	Adhesive – 1 Minute	220 ml 1:1	Black	1	6
055395-99401	Structural Adhesive – 5 Minute	220 ml 1:1	Black	1	6
055395-99402	Structural Adhesive – 15 Minute	220 ml 1:1	Black	1	6
055395-99410	Adhesion Promoter Brush Top	118 ml		1	12
055395-99411	Adhesion Promoter Aerosol	333 g		1	12
<b>Epoxy</b>					
055395-99403	Skim Coat Epoxy Repair/Filler (no tip)	200 ml 1:1	Red	1	6
055395-99406	Epoxy Multi-Bonder	200 ml 2:1	Black	1	6
055395-99407	Epoxy Seam Sealer	220 ml 1:1	Black	1	6
055395-99408	Epoxy Seam Sealer self leveling	220 ml 1:1	Black	1	6
<b>Accessories</b>					
636425-41400	Heavy Duty Manual Gun	200ml or 220ml	1:1 and 2:1	1	1
636425-04628	Mixing Tips 24-element	-	Green	6	60
636425-04632	Nylon Reinforcing Tape	2" x 65'		6	6
636425-06396	Tapered Edge Spreader for #99403	3" x 4" tapered	Black	25	100



**Saint-Gobain Abrasives, Inc.**  
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