



FLEET LINE™ 3 MINUTE GENERAL PURPOSE ADHESIVE

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

A two-component, black, urethane adhesive with a three minute working time for general purpose bonding and repairing of plastic, steel, aluminum, glass, SMC and fiberglass parts.

FEATURES

- High strength and sandable
- Bonds multiple substrates
- 3 minute working time
- Non-sag formula

SUITABLE SUBSTRATES

- Plastic
- Steel
- Aluminum
- Glass
- SMC
- Fiberglass

TYPICAL PROPERTIES

Part:	Product Name:	Color:	
43310	3 Minute General Purpose Adhesive	Black	10 oz.
Cartridge			

Working Time:	3 minutes at 70°F (21°C)
Set Time:	30 minutes at 70°F (21°C)
Cure Time:	24 hours at 70°F (21°C)
Lap Shear at 70°F (21°C):	2400+ ASTM D 1002

HANDLING AND APPLICATION



PREPARATION:

FOR PLASTIC:

1. Clean with Scuff & Clean and a gray scuff pad, then rinse with water.
2. Clean with Plastic & Leather Prep or **XXX Universal Surface Cleaner**.



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- Sand area to be repaired with 24 – 36 grit paper and blow off dust.

Note: For application on TPO, EPDM, PP and other similar thermoplastics, use Plastic Adhesion Promoter or XXX Adhesion Promoter per instructions.

FOR METAL:

- Clean with SEM Solve or **XXX Universal Surface Cleaner**.
- Sand with 80 grit paper and blow off dust.
- Re-clean with SEM Solve or **XXX Universal Surface Cleaner**.

MIXING:

Remove cap by inserting a flat head screwdriver into slot and prying upward, then place cartridge into Fleet Line™ **Manual Applicator** or Fleet Line™ **Pneumatic Applicator**. Equalize cartridge by dispensing product until both parts flow equally. Install **Static Mixer**. Cut tip to desired application size. Dispense 2 - 3 inches of test material to be sure color is uniform.

Note: For cap replacement, match circles and squares, then snap back into place.

STATIC MIXERS:

Part:	Product Name:	For:	Container:
70011 6 Pack	Integral Nut Square Static Mixers	7 or 10 oz.	Cartridges
70012 50 Pack	Integral Nut Square Static Mixers	7 or 10 oz.	Cartridges



APPLICATION

GENERAL PURPOSE BONDING:

- Dry fit parts to ensure proper alignment.
- For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied.

Note: Do not allow 3 Minute General Purpose Adhesive to flow over masked area or onto painted surface.

- Apply 3 Minute General Purpose Adhesive to either surface.
- Quickly bond the two surfaces. Hold or clamp together until set.

FOR TAB REPAIR USING PLASTIC REPAIR CONTOURING TAPE:

- Prepare surface as outlined in **Preparation** section.
- For excessive damage, drill 1/8" holes approximately 1/2" apart into the repair area. This will help lock the repair material in place.



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3. Cut a piece of Plastic Repair Contouring Tape twice the length of the repair.
4. Dispense 3 Minute General Purpose Adhesive onto Plastic Repair Contouring Tape. Quickly apply both to the repair area and mold into shape using your hands or a spreader.
5. Allow the repair material to set before removing the Plastic Repair Contouring Tape film.
6. Sand with 80 – 180 grit paper to desired shape and drill as needed.

Caution: 3 Minute General Purpose Adhesive will get hot while curing.



STORAGE

3 Minute General Purpose Adhesive should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for 3 Minute General Purpose Adhesive is 1 year when stored at 40 – 77°F (4 – 25°C). Exposure above room temperature will reduce shelf life.

RELATED PRODUCTS

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart
70007	Plastic Repair Contouring Tape	15' Roll
70011	Integral Nut Square Static Mixers	6 Pack
70012	Integral Nut Square Static Mixers	50 Pack
70059	Fleet Line™ Pneumatic Applicator	1 Each
71139	Fleet Line™ Manual Applicator	1 Each
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Quart



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Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.