



TECHNICAL DATA

MANUS-BOND 75-AM HIGH GREEN STRENGTH

1. PRODUCT DESCRIPTION:

Manus-Bond 75-AM High Green Strength is an environmentally friendly, VOC compliant adhesive for the transportation industry. Manus-Bond 75-AM High Green Strength is designed to have very high green strength or initial tack to hold parts in place while the adhesive cures. The fast cure, high strength, low temperature flexibility, and ease of a one-part make Manus-Bond 75-AM High Green Strength the perfect choice for both manufacturing and repair.

2. TECHNICAL DATA:

Specific Gravity	1.45 – 1.55
Tack Free Time	Less than 45 minutes @ 77°F/50% RH
Skin Time	Less than 30 minutes @ 77°F/50% RH
Sag	Non-sagging
Tensile Strength	300 psi
100% Modulus	200 psi
Lap Shear	275 psi
Adhesion-in-Peel Strength	30 PLI
Elongation	Approx. 300%
High Temperature Resistance	Up to 350° for short periods
Low Temperature Resistance	Properties retained to -75°F
Shore A	45-50
Corrosive Properties	Non-corrosive
Staining	Non-staining
Primerless Adhesion	100% cohesion failure on most common substrate

3. PACKAGING:

10.1 fl.oz. cartridge, 20 fl.oz. sausage packs, 1 gallon, 5 gallon and 50 gallon containers

4. SURFACE PREPARATION:

Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying 75-AM. Testing a small area for compatibility is recommended.

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 containers at temperatures not exceeding 80°F.

7. **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 SDS for additional information. **KEEP OUT OF REACH FROM CHILDREN.**

8. **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.

9. **LIMITED WARRANTY:**

Any goods proved 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.

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