

# STRONGHOLD 904

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

<b>Description &amp; Uses</b>	<b>STRONGHOLD 904</b> 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.						
<b>Benefits</b>	<ul style="list-style-type: none"> <li>• Non-sag</li> <li>• Non-shrinking</li> <li>• Can be sanded and over painted</li> <li>• Excellent gap filling properties</li> <li>• Once cured, Stronghold provides a bond of excellent strength &amp; durability.</li> <li>• Bonds to Ferrous Metals &amp; Aluminium, Zinc &amp; Galvanised Metal, GRP / SMC / Thermoset Composites, Rigid Thermoplastics &amp; Wood</li> </ul>						
<b>Advantages of Using Stronghold over Welding</b>	<ul style="list-style-type: none"> <li>• Reduces risk of fire from the welding process.</li> <li>• Reduces the risk of panel deformation &amp; distortion due to overheating.</li> <li>• Minimises the removal of trims and upholstery.</li> <li>• Reduces corrosion by bonding and sealing in one operation.</li> <li>• Used to secure dissimilar substrates e.g. steel to SMC.</li> <li>• Bonding reduces labour time and material costs and does not require a specialist operator.</li> </ul>						
<b>Instructions For Use &amp; Application</b>	<ol style="list-style-type: none"> <li>1. Remove existing coatings/oxidation from all surfaces to be bonded using an abrasive no finer than P180 grit abrasive.</li> <li>2. Thoroughly clean areas to be bonded using <b>SH801/UP8010</b> (Stronghold Aerosol Metal Cleaner), or <b>SH803/UP8030</b> (Stronghold water based Plastic Cleaner) ensuring any residue is removed using a lint free cloth. Plastic substrates should be treated with <b>SH802/UP8020</b> (Stronghold adhesion promoter).</li> <li>3. 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 &amp; complexity of the repair.</li> <li>4. Remove the cartridge, mixing tip &amp; locking nut from outer packaging &amp; load the cartridge into the dispensing gun.</li> <li>5. Holding the gun &amp; cartridge vertically up, remove the "break off tip" located at the top of the cartridge using either a set of pliers or similar equipment.</li> <li>6. Squeeze out a small amount of both parts A + B onto a piece of cloth &amp; discard.</li> <li>7. Attach the mixing tip using the locking nut. If required, cut mixing tip to the desired diameter or angle.</li> <li>8. Dispense a small bead of product through the tip (approx 5cm / 2") &amp; discard - the product is now correctly equalised &amp; ready for use.</li> <li>9. Apply a bead of adhesive to one of the surfaces to be bonded and smooth the adhesive to a thin film using an applicator.</li> <li>10. Now apply a second bead of adhesives to the same surface. Bead thickness should be approximately 5mm.</li> <li>11. The panels may now be aligned in preparation for clamping and curing.</li> <li>12. Any adjustments to alignments must be carried out immediately by sliding the panels against each other.</li> </ol> <p><b>DO NOT ATTEMPT TO SEPARATE THE PANELS ONCE CONTACT HAS BEEN MADE.</b></p> <ol style="list-style-type: none"> <li>13. Apply any clamps and/or retaining devices as necessary. Remove any excess adhesive using a lint free cloth.</li> </ol> <p><b>Please Note</b> - Cure time may be accelerated with infra red or low bake facilities.</p>						
<b>Applications</b>	<p><b>STRONGHOLD 904</b> is suitable for use on the following substrates:</p> <ul style="list-style-type: none"> <li>• Ferrous Metals &amp; Aluminium</li> <li>• Zinc &amp; Galvanised Metal</li> <li>• GRP/SMC/Thermoset Composites</li> <li>• Rigid Thermoplastics</li> <li>• Wood</li> </ul>						
<b>Work Time/Open Time</b>	45 Minutes						
<b>De-Clamping Sanding &amp; Over-Painting Time</b>	3 Hours						
<b>Optimum Cure Time</b>	24 Hours						
<b>Storage After Use</b>	Any remaining adhesive in the cartridge can be stored in a cool dry place with the mixing tip on. To re-use, remove and discard the old mixing tip and repeat the adhesive preparation instructions as described above.						
<b>Product Code</b>	<table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">50ML Cartridge</td> <td style="width: 33%; text-align: center;"><b>UK Re-Order Code</b> - SH9041</td> <td style="width: 33%; text-align: center;"><b>USA Re-Order Code</b> - UP9041</td> </tr> <tr> <td>200ML Cartridge</td> <td style="text-align: center;"><b>UK Re-Order Code</b> - SH9042</td> <td style="text-align: center;"><b>USA Re-Order Code</b> - UP9042</td> </tr> </table>	50ML Cartridge	<b>UK Re-Order Code</b> - SH9041	<b>USA Re-Order Code</b> - UP9041	200ML Cartridge	<b>UK Re-Order Code</b> - SH9042	<b>USA Re-Order Code</b> - UP9042
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\* **PLEASE NOTE** – PRODUCT CODES STARTING WITH 'SH' ARE UK SPECIFIC & ALL CODES COMMENCING WITH 'UP' ARE USA SPECIFIC.

**Disclaimer & Warranty**

The results of tests carried out by us, are provided in good faith and are considered to be accurate. Recommendations for use of U-POL products, whether given by us in writing, verbally, or implied from test results are made upon the condition that the Buyer shall remain responsible for satisfying himself that the products as supplied by U-POL are suitable for his particular use.

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