



### RESIWELD™ FE7004

#### Type of Adhesive

Most versatile two component adhesive in our line.

#### Product Benefits

Easy product to mix by hand or meter/mix equipment. Features high shear strength with high impact, chemical and water resistance. Service temperatures can range from -100 deg. F to 200 deg. F with blending ratios from 1/1 by volume (flexible) to 2/1 by volume (rigid).

#### Typical Applications

Typical applications include wood lamination for sporting goods, potting small parts for electronics and as an all-purpose adhesive.

#### Suitable Substrates

Most metals and rigid plastics, (including Delrin®), rubber, concrete, wood, ceramics and most other fabricating materials.

#### Typical Properties

| Property   | Part A    | Part B    | Blend   |
|--|-----------|-----------|---------|
| BLENDING RATIO BY VOLUME   | 100       | 50        |         |
| BLENDING RATIO BY WEIGHT   | 100       | 42        |         |
| COLOR  | WHITE     | AMBER     | AMBER   |
| COLOR MODIFIER   | MILKY     | DARK      |         |
| DENSITY, ASTM D0792, WEIGHT PER U.S. GALLON (lb-mass/gal)                                      | 9.5 – 9.7 | 7.9 – 8.1 | 9 – 9.2 |
| ELECTRICAL CONDUCTIVITY, ASTM D0150, DIELECTRIC CONST, 100 KHZ, 23 DEG C (23C) ((deg. K)(ohm)) |           |           | 2.88    |
| ELECTRICAL CONDUCTIVITY, ASTM D0150, DIELECTRIC CONST., 60 HZ, 23 DEG. C (23C) ((deg. K)(ohm)) |           |           | 3.01    |
| GEL TEMPERATURE, TMMS144, GEL TIME TEMPERATURE (F.) (deg. F)                                   |           |           | 76 – 78 |
| GEL TIME, GEL TIME IN MINUTES (3 FL.OUNCES MIN: 2.8 MAX: 3.2) (minute)                         |           |           | 50 – 70 |
| ODOR   | SWEET     | AMMONIA   |         |
| SHELF LIFE (year)  | 1         | 1         |         |
| SOLID CONTENT (NON-VOLATILES), TMWB052, SOLIDS (percent)                                       | 100       | 100       | 100     |
| VISCOSITY (TMMS001) (cP)   | 3,500     | 5,000     | 13,500  |



|                                 |     |       |
|---------------------------------|-----|-------|
| GOVERNMENT SPECIFICATION NUMBER | WS  | 3490  |
| GOVERNMENT SPECIFICATION NUMBER | WS  | 17351 |
| GOVERNMENT SPECIFICATION NUMBER | WS  | 11539 |
| GOVERNMENT SPECIFICATION NUMBER | MIS | 20163 |
| GOVERNMENT SPECIFICATION NUMBER | WS  | 11540 |

### Application Instructions

**SURFACE PREPARATION:** Surfaces must be clean, dry and free from grease, oil, paint, wax and weak oxide films and other surface contaminants. Chemical etching, sanding or grit blasting often give the best results.

**PROPORTIONING AND MIXING:** Just prior to using, blend the two components, Part A and Part B, in the ratio above. Stir the two components together thoroughly, being certain to scrape in all material from the walls and bottom of the mixing container. Materials can be hand stirred. Mechanical mixing is preferable, but should be carried out at slow speeds (about 300 rpm), taking as little air as possible into the adhesive batch.

**APPLICATION:** Spread a thin layer of the mixed adhesive on one or both of the parts to be bonded. Once the adhesive is applied, no open time is necessary. The surfaces can be assembled immediately. Parts should be assembled while the adhesive is still wet to the touch and before it sets. The individual parts, the ambient temperature as well as the adhesive itself will dictate the open time permitted.

**CURE SCHEDULE:** 10-14 days at 77F

3-4 hours at 158F\*

1-2 hours at 200F

\* Allow additional time for parts to warm up to curing temperature.



### Typical Performance Characteristics

|                                   |                          |                             |
|-----------------------------------|--------------------------|-----------------------------|
| Lap Shear Tensile Strength<br>77F | Rigid Ratio<br>4,575 psi | Flexible Ratio<br>5,200 psi |
| Hardness: Shore D                 | 70-85                    | 65-80                       |

### Typical Packaging

Please contact your local Sales Office for available packaging options.

### Storage Conditions

Store material in a closed container in a cool, dry place. If crystallization occurs in the containers of this product's part A, warm the product to 120F to 140F and it will return to its original liquid state. However, stir before using. Refer to the MSDS for detailed information.

### Disposal Advice

Please refer to the MSDS for disposal instructions.

### Safety Advice

Please refer to the MSDS for safety advice.

### Export Advice

This product is a Defense Article as defined in the International Traffic in Arms Regulations (Volume 22 Code of Federal Regulations Parts 120-130). As such, any export of this product or items containing this product may be prohibited by or require a license issued by the U.S. Department of State, Directorate of Defense Trade Controls. Contact H.B. Fuller Company by phone at 651-236-5858 or by email at [reg.request@hbfuller.com](mailto:reg.request@hbfuller.com) for further information.

## Our Focus is Clear. Perfecting Adhesives.

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