

## HARDBOND WARRANTY

When used according to directions, Tifco guarantees that all HARDBOND products will perform to specifications. This warranty covers reasonable costs for labor, loss of use of the vehicle, parts and materials only and excludes consequential or incidental damages.

A copy of this completed document must be retained with the repair file and submitted with any claims.

VIN # \_\_\_\_\_

Vehicle Make/Model # \_\_\_\_\_

Product used for repair \_\_\_\_\_

Lot number(s) on cartridges(s) used for repair \_\_\_\_\_

This warranty is made in lieu of and excludes any and all other warranties expressed or implied.



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HIGH PERFORMANCE AUTOMOTIVE  
ADHESIVE SYSTEM



## 7743 SELF-LEVEL SEAM SEALER

NOTE: PRIOR TO APPLYING 7743 VEHICLE TEMPERATURE SHOULD BE 70°F FOR AT LEAST 1 HOUR.

1. Make certain vehicle is level.
2. Remove OEM sealer material from channel. Clean surface with residue free solvent to remove any remaining sealer residue or soil. Blow off and tack wipe channel to remove lint and dust.
3. Use masking tape to form a dam at the forward end of channel to prevent 7743 SEAM SEALER from running out.
4. To remove cap, insert flat head screwdriver into slot and pry upward. NOTE: For cap replacement, match circles and square, and snap back into place.
5. Place cartridge into 7752 Universal Manual Gun. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired application size. CAUTION: Dispense 2-3 inches of test material to make certain color is uniform prior to applying to job. Avoid marbling.
6. Dispense 7743 in the center of the entire length of channel. 7743 will flow out and self level. Allow to cure for 20-30 minutes.
7. Remove and cut away the dam tape with a razor knife. If necessary, sand or trim dammed end and contour to maintain required roof channel depth. USE CAUTION NOT TO SEPARATE 7743 FROM BASE OF CHANNEL.
8. While product is still wet, remove excess by wiping with a small amount of cleaning solvent.

NOTE: 7743 has a 5-10 minute work time, 15-20 minute set time and is ready for sanding or painting in 30 minutes.

## 7745 (50ml) & 7747 PLASTIC REPAIR

NOTE: USE AT TEMPERATURES ABOVE 70°F.

1. Clean with plastic safe solvent and scuff area to be repaired.
2. Cut or grind away ragged edges. Sand with 80 grit paper 2 - 3 inches around damaged area. "V" groove damaged area with 24 grit disc at low RPM. Excess heat may seal the pores of the plastic making adequate adhesion difficult. Blow off the entire area to be repaired to remove dust and clean again.
3. Place cartridge into 7752 or 7750 (50ml) Universal Manual Gun. Cut off cartridge tips at perforation. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired bead size. CAUTION: Dispense 2-3 inches of test material to make certain color is uniform prior to applying to job. Avoid marbling.
4. Reinforce large holes and damaged areas that could affect the structural integrity of the part with reinforcement tape. In such cases, clean the back side of the damaged area. Cut or grind away ragged edges. Grind 3-4 inches beyond the damaged areas with 24 grit disc at low RPM. Dispense 7745/7747. Apply 2-3 inches beyond the damaged area. Before 7745/7747 sets, lay the reinforcement tape on the material and tamp. Cover the tape with another layer of 7745/7747 before first coat dries.
5. Dispense a sufficient amount of 7745/7747 to fill the repair area, and use a putty knife or spreader to distribute mixture. Press firmly into repair area to eliminate air pockets. Apply repair material higher than surrounding surface to allow for sanding.
6. After 7745/7747 has cured 15-20 minutes, sand first with 80 grit paper then finish with 180 grit paper. For slight imperfections, reapply a skin coat of 7745/7747 and resand with 180 grit paper and clean.
7. To fill sand scratches and prepare surface for painting, apply a flexible bumper primer.

NOTE: 7745/7747 has a 3-5 minute work time, sets in 5-10 minutes and is ready for sanding or painting in 15-20 minutes.

## 7749 PANEL BOND

NOTE: 7749 is intended for full panel replacement only. Use at temperatures above 70°F.

1. Clean first with a residue free solvent. Remove all loose paint, scale and rust from surfaces to be bonded.
2. Grind all surfaces to be bonded with a 36 grit disc and blow off. NOTE: To insure proper alignment and clearance, dry fit panels before applying adhesive.
3. Clean again with solvent.
4. Remove retaining nut and red insert. To maintain product quality, replace after use.
5. Place cartridge into 7752 Universal Manual Gun with included 2:1 pushnut installed. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired bead size. CAUTION: Dispense 2-3 inches of test material to make certain color is uniform prior to applying to job. Avoid marbling.

### When following OEM resistance weld bonding recommendations:

1. Apply a 1/4" - 3/8" bead to both the replacement panel and to the parent panel. Tool the adhesive evenly with a spreader.
2. Properly position the new panel while maintaining evenly distributed pressure to all areas. Do not over clamp. Too much pressure on the bonded areas will inhibit proper bonding. Remove excess adhesive.
3. Proceed with resistance welding according to OEM specifications.

### When following traditional welding methods:

1. Apply a 1/4" - 3/8" bead to both the replacement panel and to the parent panel. Tool the adhesive evenly with a spreader.  
NOTE: Keep adhesive 1-2 inches away from welding areas.
2. Properly position the new panel while maintaining evenly distributed pressure to all areas. Do not over clamp. Too much pressure on the bonded areas will inhibit proper bonding. Remove excess adhesive.
3. Apply screws or rivets in hard to clamp areas and proceed with welding along gapped areas. Clamps may be removed after four hours.  
NOTE: 39747 has a 90 minute work time and sets in 4 hours. To enhance cure time, heat at 120°-140°F for 1 hour. Allow 7749 to cure for 24 hours before returning the vehicle to service.  
NOTE: Bonding applications are intended for secondary structures only. Please see your crash guide for vehicle recommendations.



## 7741 NON-SAG SEAM SEALER

NOTE: PRIOR TO APPLYING 7741 VEHICLE TEMPERATURE SHOULD BE 70°F FOR AT LEAST 1 HOUR.

1. Clean joints and seams thoroughly with residue free solvent. Blow off and tack wipe to remove lint and dust.
2. To remove cap, insert flat head screwdriver into slot and pry upward. NOTE: For cap replacement, match circles and square, and snap back into place.
3. Place cartridge into 7752 Universal Manual Gun. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired application size. CAUTION: Dispense 2-3 inches of test material to make certain color is uniform prior to applying to job. Avoid marbling.
4. Apply 7741 into joint or seam. Work in or finish with finger, putty knife or spreader.
5. While product is still wet, remove excess by wiping with a small amount of lacquer thinner.

NOTE: 7741 has a 5-10 minute work time, sets in 15-20 minutes and is ready for sanding or painting in 30 minutes.