



### 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, TMTS144, 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 (TMTS001) (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 77F	Rigid Ratio 4,575 psi	Flexible Ratio 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.

**NOTE TO USER:** by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

**IMPORTANT:** The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance. goodwill or any indirect or consequential losses arising out of or in connection with product supply.

North America  
+888-HBFULLER  
+888-423-8553

[inquiry@hbfuller.com](mailto:inquiry@hbfuller.com)  
[www.hbfuller.com](http://www.hbfuller.com)



# H.B. Fuller