



Motorcraft® Body Repair Adhesives Selector Guide

Designed, engineered and recommended by Ford Motor Company.

| Product | FIR # | Components | Applications | Work Time @ 70°F | Handling Strength @ 70°F | Adhesive Sandability @ 70°F | Part Paintability @ 70°F | Adhesive Full Cure @ 70°F | Program |
|---|---------------------------------------|---|--|-------------------------|------------------------------------|-----------------------------|------------------------------|---------------------------|--|
| TA-1 1.7 fl. oz. (50 mL) Metal Bonding Adhesive | 156626 161171 | 1 TA-1 and 1 mixing nozzle | Medium-set adhesive for bonding unprimed metal and aluminum; door skin replacement; weld bonding | 40 to 50 min. | 1.5 to 2 hr. | 1.5 to 2 hr. | 8 hr. | 8 hr. | TSB # 01-18-2, 01-19-6 TSB # 04-17-3, 04-18-11 TSB # 04-24-1, 04-26-16 TSB # 04-26-17 |
| TA-2 10.3 fl. oz. (305 mL) 1K Urethane Seam Sealer/Adhesive | 156144 | 1 TA-2 and 1 mixing nozzle | Duplicating factory look anywhere non-sag, cosmetic seam sealer is required | 45 to 60 min. | N/A | N/A | 10 min. | 72 hr. | TSB # 01-18-2, 04-18-11 TSB # 01-19-6, 02-17-4 TSB # 04-26-4, 04-26-16 |
| TA-9 1.7 fl. oz. (50 mL) Plastic Bonding Adhesive | 159252 159253 | 1 TA-9 and 2 mixing nozzles | Installation and bonding of primed/e-coated metals, SMC, FRP and many other plastics with little surface prep. | 5 to 7 min. | 60 to 90 min. (15 min. @ 140°F) | N/A | 90 min. (15 min. @ 140°F) | 24 hr. | TSB # 01-18-2 TSB # 04-16-4 TSB # 04-19-9 TSB # 05-24-2 |
| TA-12 7.6 fl. oz. (225 mL) Structural Foam Kit | 158751 161228 | 4 cartridges of 1 U2J-19554-DA Structural Foam and 4 mixing nozzles + 1 - 5.5" x 4" x 3" baffle foam block | Replacement of OEM structural foam | 7 to 8 min. @ 100-120°F | 90% @ 30 min. | N/A | N/A | 24 hr. | TSB # 01-21-9 TSB # 03-2-4 TSB # 04-8-2 TSB # 05-24-2 |
| TA-15 10.1 fl. oz. (300 mL) Roof Ditch Sealer | 162993 162994 | 1 TA-15 and 1 mixing nozzle | Replacement of OEM Roof Ditch Sealer. 2 per side required | 8 to 9 min. | N/A | 30 min. | 1 hr. | 24 hr. | TSB # 02-21-4 |
| 501-040 1.7 fl. oz. (50 mL) Manual Gun | Call Rotunda (1-800-ROTUNDA) to order | | | | | | | | |
| TA-10 7.6 fl. oz./10.1 fl. oz. (225/300 mL) Manual Gun | | | | | | | | | TSB # 04-8-2 |
| TA-11 7.6 oz.(225 mL) Pneumatic Gun | | | | | | | | | TSB # 04-8-2 |