



TOTALBOAT 52 MILLION MARINE ADHESIVE SEALANT

- Professional-Grade Marine Adhesive Sealant
- Fast cure polyurethane creates permanent, high-strength bonds designed to withstand high stresses and high loads
- Safe for Use Above and Below the Waterline
- Fits into Most Standard Caulking Guns

TotalBoat 52 Million is a fast-cure marine adhesive sealant with a professional-grade polyurethane formula for the toughest jobs on boats and RVs. Creates strong, flexible, permanent bonds above and below the waterline. Use 52 Million on just about every surface; fiberglass, gelcoat, wood, metal, glass, and even some plastics. Perfect for hull-to-deck joints, thru-hulls, keel joints, strakes, and other critical, high-stress areas.

SURFACE PREPARATION SOLVENT: Acetone

CLEANUP: Wipe up excess 52 Million with a clean, cotton rag before it has become tack-free. Remaining residue can be cleaned with acetone. Once cured, it must be removed mechanically.

THINNER/REDUCER: Do not thin this product.

PRODUCT USE: Bedding hardware, hatches, thru hulls, deck joints, keel joints, railings, other fittings when a flexible but permanent bond is desired.

NOT RECOMMENDED FOR: Applications that will need periodic disassembly, teak deck sealant/caulk, windows or other hatches that are not mechanically fastened with screws or bolts, applications that may be exposed to excessive heat above 190°F

SAFETY AND PERSONAL PROTECTIVE EQUIPMENT:
Always use proper safety equipment, clothing, and PPE in accordance with the Safety Data Sheet for this product and any surface preparation materials. Use this product with adequate ventilation.

SURFACE PREPARATION

Acceptable Substrates: Fiberglass, Gelcoat, Metals, Glass, Wood, Some Plastics — ALWAYS PERFORM A TEST FOR PROPER ADHESION TO PLASTICS, OR IF UNSURE ABOUT THE BOND STRENGTH BEFORE USING IT ON THE FINAL PROJECT

Plastics with Good Adhesion: ABS, Acrylic, Epoxy, Nylon, Polycarbonate, Polyester, Polystyrene, PVC, UHMW

Plastics with Poor Adhesion: HDPE, LDPE, Polypropylene

General Surface Preparation for All Substrates:

- All amine blush, dirt, dust, grease, oil, water, and wax must be removed from the bond surfaces.

IMPORTANT!

- Acetone is the recommended surface preparation solvent for 52 Million. Take extra care to only use it on substrates that can tolerate this solvent.
- Do not use oily solvents for surface prep as they may leave a residue that prevents 52 Million from bonding to the substrate properly.
- Avoid using alcohol-based solvents to perform surface preparation. Any contact with alcohol can prevent 52 Million from curing properly if it has not evaporated completely.
- The bond strength to any substrates can be improved by abrading the bond surface with 180- or 220-grit sandpaper before applying 52 Million.
- Remove all sanding residue with a vacuum and/or an air hose.
- Wipe the surface clean with a clean, lint-free cotton rag dampened with acetone.
- It may be desirable to use masking tape around fittings to prevent surfaces from coming in contact with 52 Million.

APPLICATION CONDITIONS

- The recommended application conditions for this product are 40-95°F and 50-70% relative humidity. Application outside of these conditions may lead to significantly faster or shorter working and/or cure times.
- Do not apply this product when dew, rain, or other contaminants may be present, as they may affect the cure of this product.
- Avoid applying this product in direct sunlight to maximize its working time.

APPLICATION

Fitting in the Gun

- Apply 52 Million with a standard hand or pneumatic caulk gun that fits 10oz caulk tubes.
- Before inserting into the gun, remove the ring pull lid from the bottom of the tube. Under the lid is a small ball that can be disposed of. It is there to help prevent moisture from reacting with the product before it is opened, allowing for the longest product storage.
- Cut tip to desired diameter and shape for application.
- Make sure the tip is threaded onto the tube securely.
- Puncture a hole in the foil seal at the base of the tip with a pin or nail (many caulk guns have a puncturing tool for this purpose).
- Insert into the gun and dispense as desired.



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Dispensing

- Dispense 52 Million to the bond surface as desired.
- If mechanical fasteners are being used, take care not to overtighten them as it may squeeze the 52 Million out of the bond joint.
- A tool such as a stir stick, epoxy spreader, or finger (ONLY with gloved hands) can be used to tool or manipulate the bead of 52 Million before it becomes tack-free.
- When bonding hardware that is mechanically fastened with nuts and bolts, only snug the nuts hand tight until the 52 Million has cured. Once cured, snug the nut up with the proper torque for the given application without allowing the bolt to turn.
- Excess 52 Million can be wiped away with a clean, cotton rag before it has become tack-free. Clean up uncured 52 Million with acetone.
- Cured material must be removed mechanically.
- 52 Million will become tack-free in 10-60 minutes under normal application conditions.
- The cure rate of 52 Million is dependent on how thick it was applied. This product cures from the exposed surface first and works inward.
- The full cure time for most applications is 3-5 days under normal application conditions.
- Once cured, extra 52 Million adhesive sealant can be carefully trimmed back with a razor blade if needed.
- Once fully cured, 52 Million can be primed and painted, however, it is more flexible than many marine paints, which may lead to the coating's failure when stressed.
 - Not all single-part topside paints will achieve a proper cure when applied over 52 Million. Always test this prior to applying any paint to the final project.
- 52 Million is UV stable, but it may eventually yellow slightly over time if a wide bead experiences intense, prolonged UV exposure.

APPLICATION DATA:

Material Consistency:	Paste, thixotropic
Application Method:	Standard caulking gun
Sag Resistant:	Yes
Working Time:	5-30 Minutes (under normal application conditions)
Tack-Free Time:	10-60 Minutes (under normal application conditions)
Cure Rate:	Greater than 1/10" per day
Full Cure Time:	3-5 Days for most applications (under normal application conditions)
Application Conditions:	40-95°F, 50-70% relative humidity
Cleanup:	Acetone. Once cured, it must be removed mechanically

PHYSICAL DATA:

Components:	One
Density:	1.45g/cm ³
Cure Type:	Moisture Cure
Solids Percentage:	≥97%
Service Temperature Range:	-40 to 190°F
Color:	White
Shelf Life/Stability:	9 Months Minimum
Hardness:	45-50 (Shore A)
Tensile Strength:	≥435psi (typical)
Elongation at Breakage:	≥400%

STORAGE

Storage: Keep tightly sealed in the original container in a cool place under 77°F. Keep protected from moisture and sun exposure. This product will store much longer if unopened.

Shelf Life: The shelf life of this product is a minimum of 9 months from the date of manufacture under proper storage conditions if it is unopened. Under most circumstances with proper storage, this product will store much longer. This product is still perfectly usable if it comes out of the tube at the proper consistency.