



### 4193HD Pressure Sensitive Mastic Patch

4193HD is a pressure sensitive mastic usually laminated to a plastic film or foil to facilitate installation. It can be die-cut into simple or complex shapes as required by the application. When the appropriate film or foil is used this material can be applied before paint with no negative impact during bake cycles.

Technology / Base	Butyl
Type of Product	Sealant Patch
Appearance / Color	Black
Consistency	Film-Backed Patch

#### Features and Benefits

- Withstands automotive bake cycles
- Adheres to most clean dry substrates for easy installation
- Can be used BIW or in the Trim Shop

#### Technical Data

Property	Typical Value	Test Method
Specific Gravity	1.8	ASTM D71
Cone Penetration (dmm)	75	ASTM D217, 150g added Load
Non-Volatile Content	>95%	ASTM D2834, 3hrs at 100°C
Adhesion Initial		MS-CD-614
(Galvanized)	Cohesive Failure	
(Galvanneal)	Cohesive Failure	
(E-Coat)	Cohesive Failure	
Adhesion aged 20 min @163°C (325°F)		MS-CD-614
(Galvanized)	Cohesive Failure	
(Galvanneal)	Cohesive Failure	
Adhesion Aged: Condensing Humidity Salt Spray Heat Heat Aging 250hrs @ 79°C Environmental Cycle	No loss of adhesion	MS-CD-629



## Typical Applications

4193HD is ideal for sealing holes in auto bodies. It is very aggressive and can be used on a variety of substrates such as:

- E-Coat
- Oily Metal
- Powder Coat
- Phosphate Coated Metal

## Specifications

Meets requirements of:  
Ford WSB-M4G109-A2

## Typical Packaging

Available as patches or die cut sheets. Contact your H.B. Fuller representative for specific requirements.



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## Storage and Shelf Life

Store material in original unopened packaging at temperatures between 10°C to 50°C (50°F to 120°F). Shelf life is 24 months when stored as recommended.

## Safety and Disposal

Prior to working with this or any product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions and disposal considerations.

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