

Technical Data Sheet

Page 1 of 2

Properties: AKEMI® Plastic Repair Adhesive is a gel-like, solvent-free 2-component adhesive based on epoxy resins containing a modified special hardener.

The product is characterized by the following qualities:

- very rapid hardening
- easy dosing and mixing by use of cartridge system
- extremely low shrinkage during the hardening process and therefore low tensions in the bonding layer
- good dimensional stability of the bonding layer
- small tendency to fatigue
- excellently suited for bonding gas-impermeable materials as it is a solvent-free product
- good electrical insulating property
- suited for bonding materials which are sensitive to solvents (e.g. expanded polystyrene, acrylonitrile butadiene styrene)
- the product is not liable to crystallize, therefore no problems in storing and processing

Application Area: AKEMI® Plastic Repair Adhesive is an universal adhesive for durable repair of various plastics parts (e.g. bumpers). In combination with AKEMI® Plastic Adhesion Promoter Spray the adhesive has a good / very good adhesion on various synthetic materials (rigid PVC, polyester, PP, PE). Due to its gel-like consistency the product has a good vertical stability. The rapid hardening time makes the product suitable for assembly work and is fast workable (grinding, over painting).

Instructions for Use:

- without mixing nozzle: dosing apparatus only
- with mixing nozzle: dosing and mixing apparatus at the same time

1. Drill out the crack ends with a 2 - 3 mm drill bit and chamfer the crack in a V-shape. Sand the repair area with P120, clean with AKEMI® Smooth Surface Cleaner and let it dry.
2. Spray a thin layer of the underground with AKEMI® Plastic Adhesion Promoter Spray and let it dry.
3. Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle.
4. Both components must be thoroughly mixed when working without mixing nozzle.
5. Apply adhesive onto the area to be repaired. If necessary, use a glass fiber fabric for reinforcement (also grind and clean the surface).
6. The mixture remains workable for approx. 3 - 4 min (20°C). After approx. 45 min. the adhesive has a good initial stability, which is sufficient to be worked (drilling, grinding, milling). After 24 hours (20°C) the adhesive has its max. stability.
7. The hardening process is accelerated by heat and delayed by cold.
8. Tools can be cleaned with AKEMI® Nitro-Thinner.

Special Notes:

- For professional use only.
- The product is not suited for bonding which are exposed to permanent moisture.

- AKEMI® Plastic Repair Adhesive is paintable with AKEMI® Paint

TDS 12.25

Technical Data Sheet

Page 2 of 2

Sprays for plastic parts. Incompatibility reactions with other lacquers are not yet known.

- An adhesive which is already thickened or just gelling should not be used anymore. Once hardened, the adhesive can no longer be removed by solvents. Removal is only possible mechanically.
- In case of job interruption for a longer time, the adhesive in the mixing nozzle hardens. Then it is no longer possible to press the gun and the mixing nozzle must be changed. Do not work the grip if the adhesive is hardened in the mixing nozzle, because the gun or the cartridge can be damaged.
- At temperatures below 10°C the product should not be used anymore as there is no sufficient hardening.
- When being worked correctly, the hardened adhesive is not damaging to health.
- Use only the original AKEMI® gun and mixing nozzle.
- For proper waste disposal, the container must be completely emptied.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

Technical Data:

Colour: component A	black
component B	glassy, milky-white
Working time: mixture of	75 g comp. A + 75 g comp. B
at 10°C	8 - 9 minutes
at 20°C	3 - 4 minutes
at 30°C	2 - 3 minutes
at 40°C	1 - 2 minutes

Storage:

If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 24 months from production.

Health & Safety:

Read Safety Data Sheet before handling or using this product.

Important Notice:

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.

TDS 12.25