



PLASTIC REPAIR MEDIUM

GENERAL

CODE	DESCRIPTION
PR02	Plastic repair medium 50 ml



DESCRIPTION

Plastic repair PR02 is a fast curing, easy to use structural 2-part polyurethane adhesive which cures by a chemical reaction of the two components forming a durable polymer resistant to elevated temperature, moisture, fuel, many solvents and chemicals.

Plastic repair PR02 is specially designed for small, quick, durable bonding and repair jobs. The use of Plastic repair PR02 yields a fast turnaround due to early sanding and painting capability.

Plastic repair PR02 shows good sag resistance properties, allowing vertical application and offers excellent gap filling properties. In combination with a reinforcing mesh broken or missing bumper tabs can be rebuilt.

NOMINAL COMPONENT PROPERTIES

	Component A	Component B
Chemical base	Reactive Isocyanate Prepolymer	Reactive Polyol Mixture
Colour	Black	White
Specific Gravity, g/ml	~1,28	~1,21
Viscosity [cps or mPas]	~60.000	~50.000
Appearance	Sag Resistant Paste	Sag Resistant Paste

TYPICAL CURE CHARACTERISTICS

Working time	@ 23° C [sec]/[min]	90 / 1,5
Sanding time	@ 23° C [min]	10
Clamp Time	@ 23° C [min]	5

TYPICAL PROPERTIES OF CURED ADHESIVE

Shore D Hardness	EN ISO 868 @ 23° C	63
Tensile Strength	EN ISO 527 @ 23° C [MPa]	23
Young's Modulus	EN ISO 527 @ 23° C [MPa]	245
Elongation at Break	EN ISO 527 @ 23° C [%]	55
Glass Transition Temperature	ISO 11357 [°C]	65



PLASTIC REPAIR MEDIUM

LAP SHEAR INFORMATION

Substrate	Pre-treatment			Bondline thickness	Expected failure mode	Average strength
	Cleaning	Sanding	Cleaning			
CRS	Acetone	K80	Acetone	1 mm	Cohesive failure	15,3 MPa
SMC	Acetone	-	-	1 mm	Substrate failure	5 MPa
PVC	IPA	K120	IPA	1 mm	Mixed failure	3,3 MPa
PMMA	IPA	K120	IPA	1 mm	Substrate failure	4 MPa
PP	Acetone	K140	Acetone	1 mm	Adhesive failure	1,3 MPa
E-Coat	IPA	K800	IPA	1 mm	Coating failure	9,6 MPa

USE INSTRUCTIONS

Plastic repair PR02 adhesive system has been designed for ease of dispensing with both hand-held manual and pneumatic applicator tools. To assure an on ratio dispense we recommend levelling the pistons by placing the opened cartridge in the dispenser and purge till material starts to flow from both cartridge chambers prior to attaching the mixer. After attaching the mixer tip and loading the cartridge into the dispense tool, pull the trigger at a constant and steady rate to force both prepolymer and curative through the mixer tip. It is recommended to discard the first 25 to 50 mm of dispensed material as it may be off-ratio. Sufficiently mixed on-ratio adhesive has a uniform black colour, is creamy, smooth and glossy.

The material in the mixer will become very difficult or impossible to dispense at about one-half of the open time. Either keep material flowing through the mixer during short periods of time adhesive is not needed or replace the mixer prior restarting dispense.

After having finished dispensing, leave the mixer in place till plastic repair PR02 shall be used again. The remainder of the adhesive will have a shelf life of several weeks if stored properly. To start using plastic repair PR02 again, remove the static mixer and dispose of properly. Carefully clean the cartridge nozzle, the products in the two chambers must be cleanly separated. If there is any black-tan mixing on either side dispense some product out of the openings with no mixer tip attached, until only single component product resides in each chamber. Finally attach a new mixer and start dispensing.



PLASTIC REPAIR MEDIUM

SAFETY

Please observe the information provided with the Material Safety Data Sheet.

MSDSs are provided to you under GERKO's policy of communicating to our customer health, safety and environmental information for safe handling, use and disposal of our products. This information must be made available to health and safety personnel within your organization and to all employees who come in contact with these products.

STORAGE

Unopened containers stored at a dry place indoors at 15 – 32 °C

SHELF LIFE

18 Months in the originally sealed cartridge

PACKAGING

Plastic repair PR02 is packed in 50 ml