



DRIVING SURFACE PERFECTION™

# PLAST X 'B'

90 Second Black Rigid Adhesive for Rapid Repairs & Assembly Operations

TECHNICAL DATA SHEET

## TECHNICAL DATA SHEET & PROCESS GUIDE

PLAST X 'B' is a 90 second Black Adhesive for rapid repair and assembly operations (Brackets, lugs, clips, fixings, trims & emblems & rapid repair of semi-rigid plastic & composite sections.

## PROPERTIES and BENEFITS

- Non-sag
- Non-shrinking
- Can be sanded and over painted
- Excellent gap filling properties
- Once cured, PLAST X 'B' provides a bond of excellent strength and durability
- Bonds to Ferrous Metals & Aluminium, Zinc and Galvanised Metal, GRP / SMC/ Thermoset Composites, Rigid Thermoplastics and Wood
- Reduces risk of fire from the welding process.
- Reduces the risk of panel deformation & distortion due to overheating.
- Reduces corrosion by bonding and sealing in one operation.
- Used to secure dissimilar substrates e.g. steel to SMC.
- Bonding reduces labour time and material costs and does not require a specialist operator.

PLAST X 'B' is suitable for use on the following substrates:

- Ferrous Metals & Aluminium
- Zinc & Galvanised Metal
- GRP/SMC/Thermoset Composites
- Rigid Thermoplastics
- Wood

## APPLICATION GUIDE

- Remove existing coatings/oxidation from all surfaces to be bonded using an abrasive no finer than P180 grit abrasive.
- Thoroughly clean areas to be bonded using S2002/AL (Solvent based degreaser), or S2000 (Water based degreaser) ensuring any residue is removed using a lint free cloth. Plastic substrates should be treated with PLAST X '2' (Adhesion promoter).
- Remove the cartridge and mixing tip from outer packaging & load the cartridge into the dispensing gun.
- Squeeze out a small amount of both parts A + B onto a piece of cloth & discard.
- Attach the mixing tip and cut it to the desired diameter or angle.
- Dispense a small bead of product through the tip (approx 5cm / 2``) & discard - the product is now correctly equalised & ready for use.
- Apply adhesive to one of the surfaces to be bonded working quickly to align the work pieces.
- Hold or clamp the work pieces during cure.
- If sanding or over coating is required, refer to the information below for de-clamping, sanding & over painting time.
- Please Note: The PLAST X range of adhesives may be over coated with most modern paint systems.



### Application and Drying Times

Work Time/Open Time 90 seconds

De-Clamping, Sanding and overpainting time 10 minutes

Optimum cure time 1 hour



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## TECHNICAL DATA SHEET & PROCESS GUIDE STORAGE & VOC INFORMATION



### Shelf Life

1 year from date of manufacture in sealed original sachets. Six months once out of sachet

**Recommended Storage Temperature** 5°C - 25°C

<b>Order Codes</b>		
<b>PLAS/B 50ml cartridge</b>		

**IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.**

This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the U-POL website at WWW.U-POL.COM. U-POL is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits.

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