


# Technical Data Sheet

<p><b>General</b></p> <p>Article number: 90672240</p> <p>Description: 2K Plastic Adhesive Medium Fast 3.5 minutes (Black) 50 ml</p>	
<p><b>Specifications</b></p> <p>3.5 minutes medium curing. Powerful 2-component (2K-PU) plastic adhesive. For all-purpose structural bonding of plastic parts. Bonds, fills and repairs small to medium sized cracks and holes of F.I. plastic bumpers and spoilers. Resistant to exposure to elevated temperature, moisture, fuel, many solvents and chemicals. Colour Black. Cartridge of 50 ml. Per piece, with 2 mixing tips.</p> <p><b>Application</b></p> <ul style="list-style-type: none"> <li>• Bonds, fills and repairs small to medium sized cracks and holes in plastic bumpers and spoilers.</li> <li>• Structural and cosmetic repairs of a variety of plastic parts.</li> <li>• In any industry where a fast strong bond is demanded.</li> <li>• Also, excellent bond of many different substrates like plastics, metal, GRP, ceramics, wood etc.</li> </ul> <p><b>Features &amp; Benefits</b></p> <ul style="list-style-type: none"> <li>• One product for structural bonding, filling and repairing.</li> <li>• Handling time is suitable for medium sized repairs of F.I. cracks and holes in bumpers.</li> <li>• Easy to sand.</li> <li>• Stays flexible even under cooler conditions.</li> <li>• Faster and stronger than plastic welding and stapling.</li> <li>• No smell, superior ambient cure.</li> <li>• Excellent gap filling properties.</li> <li>• Cure response is NOT depending on the thickness of the applied adhesive as with most other Polyurethane systems.</li> </ul> <p><b>Technical specifications</b></p> <ul style="list-style-type: none"> <li>• Colour: Black</li> <li>• Packing: 50 ml</li> <li>• Packing unit: 6 units per box</li> <li>• Store: Cool and dry, between +15°C and +32°C; (After opening leave the used mixer tip attached to ensure sealing from humidity, remainder can still be used.)</li> <li>• Shelf life: 24 months</li> <li>• Technical data <ul style="list-style-type: none"> <li>Open time*: 3.5 minutes</li> <li>Handling time*: 15 minutes</li> <li>Sanding time*: 30 minutes</li> <li>Paint time*: 30 minutes (* at 23°C)</li> <li>Cure: Ambient or heat accelerated cure (max 120°C)</li> <li>Optimum Bondline Thickness: 0.5 mm to 1.5 mm</li> <li>Maximum Bondline Thickness: ± 5 mm</li> </ul> </li> </ul>	

Paint Bake:	max. 150°C
Tensile strength MPa @ 23°C:	26 (ASTM D-638)
Young's Modulus MPa @ 23°C:	1102 (ASTM D-638)
Elongation %:	65 (ASTM D-638)
Shore Hardness D:	69 (ASTM D-2240)
Shrinkage %:	<1.0 (ASTM C-733)

### Substrate Range

Substrate	Surface preparation	General Adhesion
SMC, BMC, RTM, Gel Coat, Wood, HPL, PUR-RIM	Sanding	Excellent
Carbon Fiber Reinforced Plastics (CFRP)	Sanding or peel ply	Excellent
Coated or primed Metals and Metal alloys**	None	Excellent
HLU (Hand lay up) , HSU (Hand spray up)	Sanding	Good
Thermoplastics A (ABS, PA, PC/PBT, PPO/PA, PET)	Sanding or solvent wipe	Very Good
Thermoplastics B (PPO, PC/ABS, PP/EPDM)	Solvent, detergent or primer	Good / Fair
Thermoplastics C (PTFE, PP, PE, PVC, PPS, POM)	Physical pre-treatment (flame, plasma, corona)	Limited

### Substrate preparation and processing

- The surface has to be clean, and free of dust, oil and grease.
- Attach the Mixer Tip on top.
- Press out some product ( $\pm 25 - 50$  mm) To make sure that the product is properly mixed.
- Pull the trigger of the 2K Manual Gun at a constant force for an even layer of adhesive.
- Make sure that the top of the Mixer Tip is always in the product, this prevents air from enclosing in the adhesive. Which will form air bubbles when applied.
- When cured (see technical information) sand and refinish when needed.
- After finishing leave the mixer tip in place.
- When using again, remove the mixer tip. Carefully clean the cartridge nozzle. (The products in the two chambers must be cleanly separated.) Attach a new mixer tip and start a new job.

### Paintability

Paintable with the most car repair 1K and 2K paints. Due to the diversity of varnishes and paints we recommend preliminary tests.

### Suggested repair process of a crack (example):

1. Clean with Colad Plastic Cleaner.
2. Model the part and sand it.
3. Apply Colad Plastic Primer to improve the adhesion.
4. Drill and countersink when possible/needed. (user consideration)
5. Cut Contour Film/Reinforcement Film. Apply the adhesive on the film.
6. Apply the film and adhesive. Place at the back of the damaged area. Press softly, spread out evenly.
7. Sand and refinish. Read for more technical information the Technical Data Sheet.

### Related products Colad

Article number: 90672666

Description: Gun for Plastic Adhesive Manual

Article number: 90672980/90672981

Description: Mixing Tips Plastic Repair

**Disclaimer Technical Data Sheet & Material Safety Data Sheet**

It is the responsibility of the user to read understands and apply the information of the TDS. The information about work and environmental safety is available on the material safety data sheet via [www.colad.co](http://www.colad.co). It is the responsibility of the user to read and apply the information.

**Notice**

Products are for professional use. The adhesive could be harmful if improperly handled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn.

The repairs should always be done in accordance with the OEM rules and specifications.

All information is for the user's consideration, investigation and verification. The specific use applications and conditions of use are beyond the control of EMM International B.V.. It is the responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application.

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