

Product Information

Introduction:

Fabtech Systems +PLUSeries® 25, 60, 90 second and Composite structural urethane adhesives are a versatile and fast two part urethane system used for bonding and repairing plastics, composites, aluminum, steel, plaster and many other items commonly used in the O&P manufacturing process.

Preparation:

1. Remove the cap of the adhesive cartridge by twisting and pulling off for the 50ml size. On the 220ml cartridge pry the uppermost slot with a flat screwdriver. See image 1.
2. Properly place the cartridge into the gun. Prior to attaching the mixing tip, dispense a small amount of adhesive to ensure both sides flow evenly. If the both sides do not flow evenly, using a small poker carefully enlarge the restricted side to ensure full flow.
3. Attach mixing tips by locking tabs on the 50ml size or screwing on for the 220ml size.
4. Apply a generous amount of +PLUSeries® adhesive to the product.
5. Release the pressure on the metal tab located on the back of the applicator gun. This will allow you to easily remove the tip for your next use.
6. Assemble with the mating part within the recommended working time.
7. Allow adhesive to cure per recommendation. See table 1.
8. Sand and buff using industry standard tools.
9. Allow 10 –15 minutes to cure before weight bearing. **Wrap with fiberglass reinforcement tape.**
10. Leave tip on the cartridge to act as a cap.

Recommended Applications:

- Acrylics Aluminum
- Polyesters Wood
- Styrenics CAD Foams
- Vinyl Esters Dry Plaster
- Epoxy Fiberglass
- Urethanes Carbon
- Steel Composite Fibers

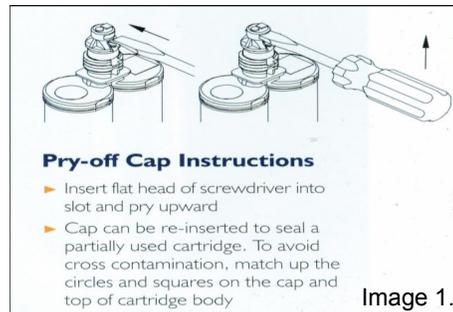


Image 1.

Non-recommended Applications:

- Surfaces where much flexibility is required
- Polypropylene
- Polyethylene
- Copolyesters

Shelf Life:

The shelf life for all +PLUSeries® adhesives is 2 years from MFG date. Storage above 23C/74° may reduce shelf life.

Clean Up:

Use a solvent such as acetone before the adhesive cures. For cured adhesive carefully scrape it off. Large spills of un-cured material should be cleaned up with an absorbent material and disposed of following your local policies for chemical disposal.

Caution:

This product contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided, and necessary protective equipment and clothing should be worn. Do not breathe vapor or dust. Use adequate exhaust ventilation.

Warranty:

Fabtech Systems will replace any material found to be defective. Because the storage, handling and application of this material are beyond our control, we can accept no liability for the results obtained.

Important Information:

Refer to the Material Safety Data Sheet (MSDS) for information on safety and handling before use. Fabtech Systems +PLUSeries® cartridge system is sold as a kit, and performance has been verified using the kit contents. Do not attempt to use other mixers in the application of this product. Do not mix the product with-out a mixing tip. This Use Guide and Instructions is incorporated as part of Fabtech Systems Recommendations for Use of +PLUSeries® adhesives by Fabtech Systems. Failure to adhere to recommendations in the Use Guide and Instructions sold with the product voids the Warranty.

Product	25	60	90	Composite
Work Time	25 seconds	60 seconds	90 seconds	60 seconds
Sand time	1.5-3 minutes	5 minutes	5-7 minutes	5 minutes
Weight Bearing	10-15 minutes	10-15 minutes	10-15 minutes	10-15 minutes

Table 1.

REP

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