



Technical Datasheet

Q 50-400-3040 2K PU Plastic Repair

Characteristics:

50-400-3040 is a two-component, room temperature cure, polyurethane adhesive system. It is fast setting system and has a convenient 1:1 mix ratio by weight and volume. The cured system has excellent abrasion resistance and can be sanded within a few minutes. It is designed for non-structural repairs on EPDM, PP, PUR, RIM, RRIM, SMC, TPO, TPE, and fiberglass. This system has also displayed excellent bond strength to a variety of other substrates including galvanized, galvaneal, or galvalume metals in addition to concrete and wood.

Working Properties:

	PART – A	PART – B	MIXED
Color	Beige	Black	Black
Viscosity @ 25°C	40,000	70,000	---
Weight per gallon, pounds	11.00	11.2	---
Filler type	Non-Abrasive	Non-Abrasive	Non-Abrasive
Gel time (8 gram mass @ 25°C)	---	---	30-50 Sec
Sandable time (8 gram mass @ 25°C)	---	---	3-5 Min
Recoat time	---	---	15-30 Min
Shelf life, Sealed containers	18 Months	18 Months	---

Mix Ratio

	Parts By Weight	Parts By Volume
Part A	1	1
Part B	1	1

Recommended Cure Schedule

1 day at 25° C (77° F)

Typical Cured Physical Properties Hardness Development

	Time	Shore A	Shore D
18 Hours	@ 25°C	--	60 – 70



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Lap Shear Strength (psi) (Tested @ 25°C)

	Sanded	Unsanded
Substrates		
Rockwell 9466	781 (s)	---
Rockwell 9486	853 (s)	828 (s)
Epoxy Laminate	3,046	2,860
Graphite Epoxy Laminate	2,750	2,673
Nylon	550	250
PET-G	700 (s)	630 (s)
ABS	712	311
SMC	---	695
ABS/PVC	575 (s)	529 (s)
Clear PVC	797 (s)	501 (s)
Filled PVC	550 (s)	530 (s)
Polycarbonate	950 (s)	820 (s)
Phenolic Laminate	1,062 (s)	1,035 (s)
Concrete	1200	---

** (s) = Substrate Failure

Sand Blasted MEK, Degreased

Aluminum	2,047	1,685
Cold Rolled Steel	2,432	1,834
Stainless Steel	1,640	----

Al/Al acid etched

	Lap Shear Strength, psi	T-Peel Strength, pli
24 Hours @ 25°C	2,150	52.5
7 Days @ 25°C	2,780	41.3
7 Days @ - 40°C	3,750	---
7 Days @ 82°C 4	50	---

Tensile Strength	2100 psi
Tensile Elongation	200 %
Tear Resistance	400 psi
Cure Shrinkage	0.0014 in/in

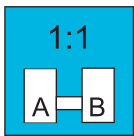


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Storage and Handling:

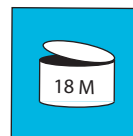
Store indoor in a warm (20 - 25 °C / 70 - 80 °F), dry place. Both these products are moisture sensitive and all containers must be kept sealed when not in use. Products should be blanketed with nitrogen or dry air after use and sealed. These materials are intended for industrial use only and must be handled safely. Material may cause rash or dermatitis when exposed to skin for prolonged time. Eye protection and appropriate glove must be used at all times when handling these materials. If taken internally, consult physician immediately.



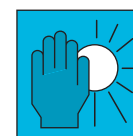
Gel time: 30 - 50 sec
Sandable: 3 - 5 min
Recoatible: 15 - 30 min



Safety:
See MSDS



Shelf life:
18 Month



Store in warm place
20 - 25 °C



This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacturing of our products.

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