

Technical Data Sheet

Plasto-Mend Rigid Plastic Repair, #1478, is a high strength, epoxy-based, adhesive designed to work on all rigid substrates such as PC, SMC, BMC, and fiberglass. Most common repairs include: rejoining cracked or broken panels, sectioning rigid parts, or as a filler material for repairing cracks, holes, and gouges.

SUITABLE SUBSTRATES

Substrate	Substrate	Substrate	Substrate
Bare Steel	Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching
Bare Galvanized	Raw Plastic - Flexible (ABD, PPO) +		Primer - 1K
Bare Aluminum	Raw Plastic - Soft (PUR) +		Primer - 2K
OEM E-Coat**	Plastic Part - Primed ++		OEM Finish & Old Paint Work - Reversible
Fiberglass/SMC Gel Coat	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible

*** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.*

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: 1:1

FLASH TIMES/DRY TIMES



Work time: 5 minutes
 Tack free: 15 minutes
 Sand time: 20 minutes
 Paintable: 30 minutes
 Full cure time: 24 hours

SURFACE PREPARATION



Depending on surface, see surface preparation for sanding recommendations.
 Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

* For more information on surface prep and application refer to next page.

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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SURFACE PREPARATION

Cleaning: Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and dry thoroughly

Sanding: Prepare surface with 80 grit sandpaper. Clean out any gouges, deformations, loose or protruding material. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter 1021 to the repair area and allow to dry a minimum of 20 minutes.

MIXING & APPLICATION

Mixing: Remove tip of 200ml package by bending the attached cap back and forth until broken. Insert into Easy Mix Dual Cartridge Dispenser Gun (#4450) or other dual cartridge dispenser gun, equalize the tubes and attach a static mixer with the tip cut off. Dispense one static mixer length of material to equalize the mixer.

Application: For repairs through a substrate or ripped substrate, prepare the back of the substrate with 80 grit sand paper. With a lint-free cloth clean, the repair area using SCAT, Speedi SCAT or Aqua SCAT 2 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter 1021 to the repair area and allow to dry a minimum of 20 minutes. Smooth a piece of plastic repair tape onto the back repair area. Apply one smoothed coat of #1478 over the plastic repair tape. Let cure 20 minutes. Apply #1478 to the prepared repair area to fill the repair depth and outward 2" - 4" from the repair. Smooth with an application spreader leveling away from the center of the repair and smoothing to a taper on the substrate. Smooth across the repair and remove excess material.

Finishing: After 20 minutes cure time, sand 1478 smooth with 180 grit sanding paper and finish with 220 grit or 320 grit sanding paper. Clean surface before priming. With a lint-free cloth, clean the repair area using SCAT, Speedi SCAT, Aqua SCAT 2 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter to any bare plastic and allow to dry a minimum of 20 minutes. Prime with Transtar Hydroflex Waterborne Primer 1231 or Transtar Hydroflex Super Hi Build Waterborne Primer 1221/1225.

Storage After Use: When finished using the product, leave the static mixer attached. Material will harden in the mixer and will seal the cartridge until the next use. In order to use the cartridge again, remove the static mixer and attach a new one. Dispense one static mixer length of material to equalize the mixer.

PRODUCT SPECIFICATIONS

Color: Black	Shelf Life: 1 year
RTU Solids: 100%	Size: 7 fl oz (207 ml)

REGULATORY

Category: Adhesive			
VOC Actual	0.01#/gal (2 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	0.01#/gal (2 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	0.24	Density of Material #/gal	13.53
Weight % of Water	0.1		