



*The Glue People*

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# Tradeweld BLACK

## Plastic repair compound

### General Description

Tradeweld Acrylic BLACK is a two part 'A&B' component system, which sets when mixed via a static mix nozzle at room temperature. It is a high viscosity non-sagging material, making it ideal for repairing many types of plastics found in the caravan and motor home industries (not suitable for polyolefins e.g. polypropylene) Because of its macro structure the bonds show excellent durability, high peel strength (even in big gaps) and excellent solvent and environmental resistance.

### Application

Ground out the crack into a bowl shape as in fig 2, then key the surface of the joint with a 60 or 40 grit sand paper.

Fig1

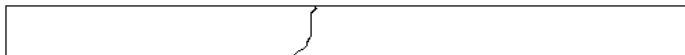


Fig 2



Using a soft, lint free cloth wipe the surface to be bonded with TGP Adhesion Promoter. Allow to flash off, then apply Tradeweld BLACK immediately to prepared surface. For best results use on clean, dry substrates between +15°C and +20°C.

To use, remove the cartridge cap and level the pistons by dispensing a small amount of material, before attaching the mixing nozzle. Attach the mixing nozzle, dispense and discard adhesive until a uniform colour is evident. Apply the mixed adhesive to the prepared substrate and fill joint until slightly proud of the surface - Fig 3.

Fig. 3



It is best to fill the entire joint to give best flexural strength. If any of the crack is visible from the other side, turn plastic over and inject to fill as much as possible.

When cured, Tradeweld BLACK can be sanded and finished in the same way as plastics. i.e use primers\* and paints usually used with plastics.

The cartridge can be re-sealed if only partly used by removing the mixing nozzle, cleaning the two cartridge openings and replacing the cartridge cap.

\*We recommend thorough testing to ascertain the compatibility of any subsequent paint coatings with the Tradeweld BLACK.

## Physical Data

**Typical uncured properties.**

	<b>Adhesive component</b>	<b>Activator component</b>
<b>Adhesive</b>	Methylmethacrylate	Methylmethacrylate
<b>Appearance</b>	Off BLACK gel	BLACK gel
<b>Specific Gravity @ 25°C</b>	1.0	0.97
<b>Viscosity @ 25°C</b> Brookfield DVII, Spindle 7, 2.5rpm	200,000 cps	200,000 cps
<b>Flash Point (TCC)</b>	> 10°C	> 10°C
<b>Operating Temperature</b>	-30°C to +140°C	

**Mixed properties.**

<b>Appearance</b>	Off BLACK paste
<b>Working Time</b>	20 minutes
<b>Fixture Time</b>	30 – 50 minutes
<b>Mix Ratio</b>	1:1

## General Information

**Storage** - Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 25°C unless otherwise labeled. Optimal storage is at the lower half of this temperature range. For specific shelf-life information, contact Trade Grade Products at the above address.

**Important Notice** - Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradeweld BLACK.