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PRP21

POWER REPAIR 21

TWO-PART METHACRYLATE ADHESIVE

- Excellent shear, peel and impact strength over a wide temperature range
- Non sagging thixotropic formulation
- Will fill gaps of up to 5 mm
- Over paintable
- Resistant to weathering and humidity
- Room temperature cured with short open time
- No surface preparation 100% reactive
- Very good UV-resistance and excellent ageing properties
- Isocyanate-, phthalates-, solvent-, PVC- and silicone free.



General Information

POWER-REPAIR 21 is a two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal and composite assemblies.
POWER-REPAIR 21 is PVC- and silicone free.
POWER REPAIR 21 can be over-painted with most types of lacquers.
Combined at a 1:1 ratio, it has a open time of 4 to 6 minutes and achieves 75% of ultimate strength in 10 to 20 minutes at room temperature (23°C).
POWER-REPAIR 21 offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

Technical Information

ADHESIVE:
Aggregate State: Paste
Colour: yellow/black
Odour: characteristic
Flammability: Combustible
pH: 4,5 - 5,5
Initial boiling point and boiling range: 101 °C
Flash point: 10 °C
Upper/lower flammability or explosive limits: 2,1 - 12 Vol-%
Vapour pressure: 28 mm Hg (20 °C)
Vapour density: 3,5
Relative density: 0,96 (20 °C)
Dynamic viscosity: 55 Pa* s
Temperature resistance: -40°C – 125°C
Tensile strength: 24 Mpa
Open time: 4-6 min
Working time: 12-15 min
Curing time: approx. 20 min on 23°C
Complete curing: after 24 hours on 23°C

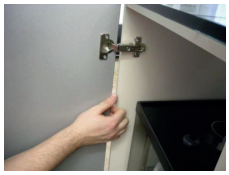
ACTIVATOR:
Aggregate State: Paste
Colour: whitish
Odour: characteristic
Flammability: Combustible
pH: 3,5 - 5,5
Initial boiling point and boiling range: 101 °C
Flash point: 10 °C
Upper/lower flammability or explosive limits: 2,1 - 12 Vol-%
Vapour pressure: 28 mm Hg (20 °C)
Vapour density: > 1
Relative density: 1,03 (20 °C)
Dynamic viscosity: 40000 - 60000 cP (25 °C)
UV- and weather resistance: Excellent
Grit blasted steel to grit blasted steel - 100% strength retained.
Storage: All adhesives should be stored unopened in a cool, dry place (between 5°C and 25°C) when not used for a long period of time.
This product should never be frozen!

Application and Use

- The surfaces to be bonded should be clean, dry and free from dust and grease.
  Application temperature: Between 15 °C and 25° C.
  In case of doubt of the substrate that must be bonded, test the strength on a small sample of the substrate.
- Mixing:
  Mixing Ratio: 1:1
  Connect the mixertip to the cartridge and press out 2 cm (do not use) to be sure that you have a 100% mixture of the 2 components.
  PLEASE NOTE: Once the product cures in the nozzle it has to be thrown away and a new nozzle used.
- Assembling:
  Open time 4 - 6 minutes @ 23°C.
  After applying the adhesive, assembly the parts (within open time) and immediately clamp or press.
  Movement of the part after the working time has expired can result in bond strengths lower than normal. Ensure that the assembly remains undisturbed until fixture has occurred.
- Curing:
  Curing time: ca. 20 minutes @ 23°C.
  Complete curing: 24 hours @ 23°C.
  Temperatures higher or lower then 23°C will have influence on the open time and curing time.
  The viscosity's of Parts A and B of this adhesive are affected by temperature.

Article nr	Name	Content	Shelf Life	Catalog
T911200	Power Repair 21 creme 5 min. 50ml	50ml	see imprint + 12 months	ADHESIVES AND SEALANTS
T911205	Power Repair 21 black 5 min. 50ml	50ml	see imprint + 12 months	ADHESIVES AND SEALANTS
T911400	Power Repair 21 creme 5 min. 400ml	400ml	see imprint + 6 months	ADHESIVES AND SEALANTS





Notice

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