

Technical Data Sheet

Plasto-Mend Universal Plastic Repair, 1468-G, is an epoxy-based, easy-to-sand adhesive with superior feather edging qualities. 1468-G was specially designed for basic cosmetic repairs of all types of plastics including: ABS, TPO, PP, PU, and others. 1468-G is also excellent for repairs to body panels, grills, composite bumpers, headlamp housings, interior plastics and more.

SUITABLE SUBSTRATES

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 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 Aqua SCAT 2 1391/1394 and dry thoroughly

Sanding: Prepare surface with 80 - 180 grit sandpaper. Clean out any gouges, deformations, loose or protruding material. With a lint-free cloth, clean the repair area using Aqua SCAT 2 1391/1394 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter 1021 or Mul-TIE Adhesion Promoter 1031/1033/1034 to the repair area and allow to dry a minimum of 20 minutes.

MIXING & APPLICATION

Mixing: Remove tip of 200 ml package by bending the attached cap back and forth until broken. Insert into Easy Mix Dual Cartridge Dispenser Gun (4440) 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 60 - 80 grit sand paper. With a lint-free cloth, clean the repair area using SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter 1021 or Mul-TIE Adhesion Promoter 1031/1033/1034 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 1468-G over the plastic repair tape. Let cure 20 minutes. Apply 1468-G 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 1468-G smooth with 180 grit sanding paper and finish with 220 grit or 320 grit sanding paper. With a lint-free cloth, clean the repair area using Aqua SCAT 2 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter or Mul-TIE Adhesion Promoter to any bare plastic and allow to dry a minimum of 20 minutes. Prime with Transtar Hydroflex Waterborne Primer 1235 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: Gray	Shelf Life: 1 year
RTU Solids: 100%	Size: 7 fl oz (207 ml)

REGULATORY

Category: Adhesive			
VOC Actual	0.00#/gal (0g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	0.00#/gal (0 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	0	Density of Material #/gal	14.5
Weight % of Water	0		