



PREMIUM PU REPAIR 3.5 MINUTES

A medium fast curing, easy to use structural 2-part polyurethane adhesive specially designed for small, quick, durable bonding and repairs on plastics and many other substrates.



Features & Benefits

- Bonds most plastics, metals, wood, etc. - universal
- 3.5 minute open time – longer working time
- Excellent filling properties - doesn't sag while curing
- Doesn't bubble while curing – neat finish
- Doesn't peel off - easy sanding
- Very good flexibility - doesn't crack
- Ultra small mixing nozzles - less waste of product

P/N	Product	S/C	Packaging
86432	Premium PU Repair	PPR210	50 ml cartridge + 2 mixing nozzles
86392	6 mixing nozzles	TPRN6	6 mixing nozzles
86393	50 mixing nozzles	TPRN50	50 mixing nozzles
84005	Dispensing gun	PRGII	1 piece

Application

Premium PU Repair 3.5 minute allows small repairs to be made in a very limited time, such as filling small cracks, holes and scratches, but also small assembly operations. Bonds most plastics, metals, wood, etc.

Instructions for use

1. Clean repair area with KENT Acrysol or Soft Surface Cleaner and allow to dry.
 2. Using 80 grit wet / dry disc, sand both the surrounding areas of the repair.
 3. Re-clean repair areas with KENT Acrysol or Soft Surface Cleaner and allow to dry.
 4. For more difficult-to-bond plastics, apply KENT Plastic Adhesion Promoter in several thin cross layers to both sides of the repair and allow to dry.
 5. Place the opened cartridge in the dispenser and purge until material starts to flow from both cartridge chambers. Fit the supplied mixer tip to the cartridge, extrude and dispose of first 2 – 3 cm of product then directly proceed with the repair. The material in the mixer will become very difficult or impossible to dispense at about 2 minutes after starting to extrude, in which case a new mixer tip should be used.
 6. For an assembly operation, bring both components together and apply uniform pressure within 3 minutes. Clamping time is approx. 10 minutes at 23°C, after which a tensile strength of 1.5 N/mm² is achieved. For a scratch or crack repair, spread the bead over the scratch or the crack within 3 minutes respecting a thickness of max. 3 - 4 mm. The thinner the layer, the slower the product will cure.
 7. After 30 - 40 minutes, depending on temperature, sand the repair area to a smooth finish if required. Avoid excessive speed, care must be taken not to overheat the plastic.
 8. Allow 1 hour at 23°C between product application and painting. More waiting time is needed at lower temperatures.
 9. Removal of Premium PU Repair – uncured material may be removed from tools and equipment with KENT Acrysol. Within the first hour, the repair can be removed by peeling it off. Once fully cured, it's almost impossible to remove.
- N.B.: The curing speed can be slowed down by applying Premium PU Repair in thinner beads/layers. Curing time will vary according to ambient temperature (cold = slower, hot = faster). Always store an open cartridge with mixer tip in place.



Technical Information

Base Part A:	Reactive polyol mixture
Base Part B:	Reactive isocyanate prepolymer
Consistency:	Sag resistant paste
Colour:	Black (Part A and B mixed)
Shelf life:	12 months
Custom tariff code:	3506 9900
VOC:	0 g/l

Cure mechanism:	Moisture cure	Application temp:	+10°C to +30°C
Specific gravity:	Part A: 1.21 g/ml Part B: 1.28 g/ml	Temp resistance :	- 30°C to +100°C
Skin forming time:	Not applicable	Green strength:	Not determined
Open time:	3.5 minutes (23°C)	Tensile strength:	23 MPa (ISO 527) or 235 kg/cm ²
Clamp / fixture time:	Approx. 10 - 15 min. (23°C)	Tensile strength (at break):	Not determined
Sanding time:	Approx. 30 - 40 min. (23°C)	Elongation at break:	55% (ISO 527)
Paint over time:	Approx. 60 min. (23°C)	Shear stress:	Not determined
Full cure:	24 hours (23°C)	Tear propagation:	Not determined
Shore D:	63 (ISO 868)	Glass transition temperature	65°C
Volume change:	Not determined		

Chemical Resistance:

Sulphuric acid 24%:	Good (battery acid)	Water:	Excellent
Hydrochloric acid 37%:	Fair / good	Salt water:	Excellent
Ketones:	Fair	Brake fluids:	Very good
Diesel:	Excellent	Motor Oils:	Excellent
Petrol:	Excellent	Information provided here is for reference only. The bonds tested were under laboratory conditions. Adhesive performance depends upon the specific chemicals tested, substrates bonded, surface preparation and environmental conditions in processing.	
Alcohol:	Excellent		
Glycols:	Excellent		



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KENT (United Kingdom) Ltd, Forsyth House, Pitreavie Drive, Pitreavie Business Park, Dunfermline, Fife KY11 8US Tel : 0800 136925 or 01383 723344 between 08:30-17:30
Monday-Thursday, 09:00-15:00 on Fridays'. For out of hours queries please Fax us on 01383 735829 or Email: kentinfo.uk@kenturope.com

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