

## Audurra™ Plastic Repair System

### Plastic Repair

**Description:**

The Audurra 2K-PU Plastic Repair System is a fast curing, micro emission, and easy to use structural 2-component polyurethane adhesive. It cures by a chemical reaction of the two components forming a durable polymer resistant to elevated temperature, moisture, fuel, many solvents, and chemicals. Audurra 2K-PU Plastic Repair System is specially designed for small, quick, durable bonding and repair jobs. The use of Audurra 2K-PU Plastic Repair System yields a fast turnaround due to early sanding and painting capability. Audurra 2K-PU Plastic Repair System shows good sag resistance properties, allowing vertical application and offers excellent gap filling properties. In combination with a reinforcing mesh broken or missing bumper tabs can be rebuilt.



- available in Black, White and Transparent
- different specific reaction time
 

Black	30 / 90 / 210 sec.
White	90 sec
Transparent	50 sec



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Language Package 1 (on the label) : GB / DE / FR / IT / NL / SE

Article Number	Content		
D15403377	50 ml	cartridge	Audurra Plastic Repair ME 30 Sec. Black
D15403378	50 ml	cartridge	Audurra Plastic Repair ME 90 Sec. Black
D15403379	50 ml	cartridge	Audurra Plastic Repair ME 210 Sec. Black
D15403380	50 ml	cartridge	Audurra Plastic Repair ME 90 Sec. White
D15403381	50 ml	cartridge	Audurra Plastic Repair ME 50 Sec. Clear
D15403382	200 ml	Aerosol	Audurra Plastic Repair Primer
D15403383	500 ml	bottle	Audurra Plastic Repair Cleaner
D15403303	1	-	Audurra Reinforcing Fabric
D15403304	1 bag	10 EA	Audurra Mixer-Tip Smart
D15403305	1	-	Audurra Application -Gun
D15403306	1	-	Audurra Reinforcing Foil





## Technical

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##### USE INSTRUCTION:

Audurra 2K-PU Plastic Repair System cartridges can be used by a manual or pneumatic driven applicator tool. After attaching the mixer tip (use only the mixer tips included in the package; additional mixer tips can be ordered separately) and loading the cartridge into the dispense tool, pull the trigger at a constant and steady rate to force both prepolymer and curative through the mixer tip. It is recommended to discard the first 25 to 50 mm of dispensed material as it may be off-ratio. Sufficiently mixed on-ratio adhesive has a uniform black color, is creamy, smooth and glossy. The material in the mixer will become very difficult or impossible to dispense at about one- half of the open time. Either keep material flowing through the mixer during short periods of time adhesive is not needed or replace the mixer prior restarting dispense. After having finished dispensing, leave the mixer in place till Audurra Plastic Repair System material shall be used again.

The remainder of the adhesive will have a shelf life of several weeks if stored properly. To start using Audurra Plastic Repair System material again, remove the static mixer and dispose of properly.

Carefully clean the cartridge nozzle, the products in the two chambers must be cleanly separated. If there is any black-tan mixing on either side dispense some product out of the openings with no mixer tip attached, until only single component product resides in each chamber. Finally attach a new mixer and start dispensing.



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#### Typical Cure Characteristics:

	Working Time 23°C [sec]/[min]	Sanding Time 23°C [min]
Audurra Plastic Repair ME 30 Sec. Black	30 / 0,5	5
Audurra Plastic Repair ME 90 Sec. Black	90 / 1,5	10
Audurra Plastic Repair ME 210 Sec. Black	210/3,5	30
Audurra Plastic Repair ME 90 Sec. White	90/1,5	10
Audurra Plastic Repair ME 50 Sec. Clear	50 / 0,8	10

#### Properties of Cured Adhesive:

Shore D Hardness	EN ISO 868	23° C	73
Tensile Strength	DIN 53504	23° C [MPa]	26
Young's Modulus	DIN 53504	23° C [MPa]	210
Elongation at Break	DIN 53504	23° C [%]	58
Glass Transition Temperature	ASTM E-1640	[°C]	47

#### SAFETY NOTE:

Please observe the information provided with the Material Safety Data Sheet. MSDS are provided to you under Axalta policy of communicating to our customer health, safety and environmental information for safe handling, use and disposal of our products. This information must be made available to health and safety personnel within your organization and to all employees who has contact with these products.

#### STORAGE:

Unopened containers stored at a dry place indoors at 15 – 32 °C

#### SHELF LIFE:

24 Months in the originally sealed cartridge



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#### Audurra Plastic Repair Cleaner:

This product is a special designed water based cleaner which will clean any plastic surface. Spray a thin layer of the Audurra Plastic Repair Cleaner directly onto the plastic surface. Residence time is approx. 1 minute. Then wipe with a clean cloth in one direction then take another piece of clean cloth and then wipe again in one direction. Repeat this until you have cleaned the complete surface.

#### Audurra Plastic Repair Primer:

Shake well before use. Spray a thin layer of Audurra Plastic Repair Primer directly onto the prepared parts. Keeping the aerosol can in a vertical position. The product favours a subsequent effective adhesion of paints, glues, inks. Apply in strictly necessary quantities to avoid drippings and waste of product.

Wait for at least 10 minutes 23°C before applying the adhesive.

**Substrate: PP PMMA PVC ABS Carbon PP/EPDM PA6 ABS/PC E-Coat GfK**

#### CERTIFICATES:

