

# Repair Stick Plastic



plastic-filled  
NSF approval  
can be used in drinking water areas

Especially for the permanent repair of plastic components and composite materials with residual elasticity such as window and door frames, panelling and bumper bars.



## Technical Data

Composition	Epoxy resin and plastic-filled
Composition	pasty
Colour after curing	light-blue
Mixing ratio by volume resin/hardener	1:1
Density of the mixture	1,6 g/cm <sup>3</sup>
Gap bridging max.	15 mm
Processing temperatur	+10 to +40 °C
Curing temperature	+6 to +40 °C
Polt life for 25gr preparation and +20°C (+68°F)	20 min.
Handling strength (35%) after	40 min.
Mechanical loads (50% strength) after	180 min.
Final strength (100%) after	36 h
Pressure (DIN 53281-83)	65 N/mm <sup>2</sup>
Medium shear strength after 7 days at +20°C (+65°F) DIN 532832 at	PVC sanded: 2,4 N/mm <sup>2</sup>

Shore hardness D	65
Thermal conductivity (ASTM D 257)	0,4 W/m.K
Linear shrinkage	<1 %
Electrical resistance (ASTM D 149)	5•10 <sup>11</sup> Ohm/cm
Dielectric strength (ASTM D 149)	3,0 kV/mm
Thermal expansion coefficient (ISO 11359)	30-40 x 10 <sup>-6</sup> K <sup>-1</sup>
Temperature resistance	-50 to +120 briefly +150 °C
ISSA-Code	75.530.08/09
IMPA-Code	81 29 73/74

## Surface pre-treatment

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner).

## Processing

WEICON Repair Sticks cover gaps of max. 15 mm per procedure. The pot life given is for a material quantity of 25 g at room temperature. If larger quantities are used, the curing time will be faster due to the typical reaction heat of epoxy resins (exothermic reaction). Similarly, higher ambient temperatures shorten the cure time (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time). Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

## Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, WEICON Repair Sticks will keep for at least 18 months. Avoid direct sunlight.

## Safety and health

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

## Available sizes:

10536057	Repair Stick Plastic 57 g
10536115	Repair Stick Plastic 115 g

## Accessories:

11202400	Sealant and Adhesive Remover, 400 ml
11207400	Surface Cleaner, 400 ml
11850200	Hand Protective Foam, 200 ml

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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