

**Plastic Repair >> SEMI-RIGID EPOXY ADHESIVE
FILLER**

Product No: XPSAP, XPSAPC, XPSAP

**Product Name: SEMI-RIGID EPOXY ADHESIVE
FILLER**

Tech-Info Data Info:

Features:

- **OEM Approved and Used**
- **One to One mixing ratio**
- **Easy to sand**
- **10 to 12 min. work time @ 75F (22• C)**
- **Sandable in 30 minutes @ 75•F (22• C)**
- **Compatible with all plastics**
- **Multipurpose Adhesive (bonds: glass, metal, wood, fiberglass, SMC, and plastics)**
- **No Pin Holes**
- **Compatible with all top coats (Primers)**
- **Sands to a perfect featheredge**
- **Excellent shelf life**
- **100% solids**

Properties listed below are at 75• F. (22• C.)

- Work time 10-12 min.
- Lap Shear Strength 1800 psi
- Sand 30 min.
- Paint Time After Sanding (30 min)
- Full Cure 24 hours

* Heat may be used to speed the dry & cure

Plastic Instructions:

- 1) Clean damaged area, front and backsides, with Panel Prep (SPD/SPP/BAP) and allow to flash-off completely.
- 2) Sand front and backside, if applicable, of repair area using 80 grit paper on a DA.
- 3) If repairing tears, bond with XPSA Plastic Adhesive Weld Kit. V-grove or Bevel front side repair line +/-50% through plastic.
- 4) Clean front and backside of repair area and let flash-off completely.
- 5) Apply Adhesion Promoter and allow to dry. Use on Flexible and Semi Rigid plastics only.
- 6) Reinforce backside of repair with Fiber Reinforcing Tape (XWT).
- 7) Mix equal parts of part A and B until color is uniform.
- 8) Apply filler to front and backside repair area. Let dry for 30 minutes before sanding.
- 9) Sand to contour with 120-grit sandpaper.
- 10) If applying a second coat of filler repeat

steps 4 & 5, mix material and apply as required.

11) Finish sanding with 180 or 220-grit sandpaper.

12) Clean surface. If bare or uncoated plastic is showing repeat steps 4 & 5 (or follow your paint companies recommended procedures) prior to applying topcoat (Primer).

• If using as an adhesive please see “Instructions for Panel Bonding” prior to use.