

**Plastic Repair >> FLEXIBLE EPOXY ADHESIVE
FILLER (OEM Approved)**

Product No: XPST, XPSTC, XPSTB

**Product Name: FLEXIBLE EPOXY ADHESIVE
FILLER (OEM Approved)**

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**
- **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.**
- **Sand 30 min.**
- **Paint Time After Sanding (30 min)**

• Heat may be used to speed the dry & cure times

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-groove 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.

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).