

SEM[®] FLEET LINE™ FLEXIBLE PLASTIC REPAIR

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

A two-component, 15 minute sandable epoxy for repairing most flexible plastic parts without requiring an adhesion promoter.

FEATURES

- Exceptional sanding and feather edging
- Remains flexible after cure
- No adhesion promoter necessary
- Compatible with all polyester glazes and putties

SUITABLE SUBSTRATES

- PUR
- TPUR
- RIM
- ABS
- PP
- PPO
- TPO
- TPE
- TEO

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
43210	Flexible Plastic Repair	Gray	10 oz. Cartridge

Working Time:	7 minutes at 70°F (21°C)
Sand Time:	15 minutes at 70°F (21°C)
Top Coat Time:	20 minutes at 70°F (21°C)
Cure Time:	1 hour at 70°F (21°C)

HANDLING AND APPLICATION

PREPARATION:

1. Clean with **Scuff & Clean** and a gray scuff pad. Rinse with water and dry.
2. Clean with **Plastic & Leather Prep**. Apply and remove per directions.



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3. Sand with 80 grit paper 2 – 3 inches around the damaged area.
4. "Dish" the damaged area with a 24 or 36 grit disc. Grind at low speed. Excess heat may seal the pores of the plastic making adhesion difficult.
5. Blow off area and re-clean with **Plastic & Leather Prep**, if necessary.

MIXING:

Remove cartridge tip and place cartridge into **Fleet Line Manual Applicator** or **Fleet Line Pneumatic Applicator**. Prior to installing **Static Mixer**, equalize cartridge by dispensing product until both parts flow equally. Install **Static Mixer** and cut tip to desired bead size. Dispense 2 – 3 inches of test material to make certain color is uniform prior to applying to job.

STATIC MIXERS:

Part:	Product Name:	For:	Container:
70011	Integral Nut Square Static Mixers	7 oz. or 10 oz. Cartridges	6 pack
70012	Integral Nut Square Static Mixers	7 oz. or 10 oz. Cartridges	50 pack

APPLICATION:

BACKSIDE REPAIR:

1. Reinforce large holes and damaged areas that could affect the structural integrity of the part from the back side with **Plastic Repair Reinforcing Tape** or **Plastic Repair Contouring Tape**. In such cases, clean the back side of the area with **Scuff & Clean** and **Plastic & Leather Prep**.
2. Grind 3 – 4 inches beyond the damaged areas with a 24 – 36 grit disc at low RPM.
3. Place **Plastic Repair Reinforcing Tape** or **Plastic Repair Contouring Tape** over the repair.
4. Apply **Flexible Plastic Repair** and spread firmly.

Note:

Remove plastic film from **Plastic Repair Contouring Tape** before applying **Flexible Plastic Repair**.

FRONTSIDE/COSMETIC REPAIR:

1. Apply **Flexible Plastic Repair** to the repair area. Press firmly to eliminate air pockets. Apply higher than surrounding area to allow for sanding.
2. After **Flexible Plastic Repair** has cured for 15 minutes, sand first with 80 grit, then finish with 180 grit paper.
3. For slight imperfections, reapply a skim coat of **Flexible Plastic Repair** or use **Bumper Bite™ Flexible Glaze**.

Note: Adhesion promoter, while not required, can aid in the feather edge sanding of **Flexible Plastic Repair** when used as a skim coat over larger areas of olefin-based plastics. **Plastic Adhesion Promoter** and **XXX Adhesion Promoter** are approved for use in this application. Follow instructions on the adhesion promoters label or **Technical Data Sheet** for appropriate spray and flash times.

4. To fill sand scratches and prepare surface for painting, apply **Flexible Primer Surfacer, High Build Primer**



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Surfacer, World Class™ Waterborne Flexible Primer or other flexible primer.

STORAGE:

Flexible Plastic Repair should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Flexible Plastic Repair** is 2 years when stored at 40 – 77°F (4 – 25°C). Exposure above room temperature will reduce shelf life.

RELATED PRODUCTS:

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Quart
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
39131	Flexible Primer Surfacer	Gallon
39133	Flexible Primer Surfacer	16 oz. Aerosol
39134	Flexible Primer Surfacer	Quart
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Cone Quart
40482	Bumper Bite™ Flexible Glaze	16 oz. Tube
42003	High Build Primer Surfacer - Black	20 oz. Aerosol
42013	High Build Primer Surfacer - Gray	20 oz. Aerosol
42023	High Build Primer Surfacer - Beige	20 oz. Aerosol
42033	High Build Primer Surfacer - Rose	20 oz. Aerosol
42043	High Build Primer Surfacer - White	20 oz. Aerosol
50184	World Class™ Waterborne Flexible Primer	Quart
70006	Plastic Repair Reinforcing Tape	36' Roll
70007	Plastic Repair Contouring Tape	15' Roll
70011	Integral Nut Square Static Mixers	6 Pack
70012	Integral Nut Square Static Mixers	50 Pack
70059	Fleet Line™ Pneumatic Applicator	1 Each
71139	Fleet Line™ Manual Applicator	1 Each
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Quart



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Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.