



Plasto-Mend Universal Plastic Repair 1468-G

Plasto-Mend Universal Plastic Repair, 1468-G, is an epoxy-based, easy-to-sand adhesive with superior feather edging qualities. 1468-G was specially designed for basic cosmetic repairs of all types of plastics including: ABS, TPO, PP, PU, and others. 1468-G is also excellent for repairs to body panels, grills, composite bumpers, headlamp housings, interior plastics and more.



Mix Ratio

1:1



Suitable Substrates

- Raw plastic - flex (ABD, PPO)
- Raw plastic - soft (PUR)
- Raw plastic - primed

Note: Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

Note: Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.



Surface Prep & Application

Cleaning: Clean with Aqua SCAT 2 1391/1394 and dry thoroughly.

Sanding: Prepare surface with 80 - 180 grit sandpaper. Clean out any gouges, deformations, loose or protruding material. With a lint-free cloth, clean the repair area using Aqua SCAT 2 1391/1394 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter 1021 or Mul-TIE Adhesion Promoter 1031/1033/1034 to the repair area and allow to dry a minimum of 20 minutes.

Mixing: Remove tip of 200 ml package by bending the attached cap back and forth until broken. Insert into Easy Mix Dual Cartridge Dispenser Gun (4440) or other dual cartridge dispenser gun, equalize the tubes and attach a static mixer with the tip cut off. Dispense one static mixer length of material to equalize the mixer.

Application: For repairs through a substrate or ripped substrate, prepare the back of the substrate with 60 - 80 grit sand paper. With a lint-free cloth, clean the repair area using SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter 1021 or Mul-TIE Adhesion Promoter 1031/1033/1034 to the repair area and allow to dry a minimum of 20 minutes. Smooth a piece of plastic repair tape onto the back repair area. Apply one smoothed coat of 1468-G over the plastic repair tape. Let cure 20 minutes. Apply 1468-G to the prepared repair area to fill the repair depth and outward 2"- 4" from the repair. Smooth with an application spreader leveling away from the center of the repair and smoothing to a taper on the substrate. Smooth across the repair and remove excess material.

Finishing: After 20 minutes cure time, sand 1468-G smooth with 180 grit sanding paper and finish with 220 grit or 320 grit sanding paper. With a lint-free cloth, clean the repair area using Aqua SCAT 2 and dry thoroughly. Apply one (1) coat of Plasto-Mend TPO Adhesion Promoter or Mul-TIE Adhesion Promoter to any bare plastic and allow to dry a minimum of 20 minutes. Prime with Transtar Hydroflex Waterborne Primer 1235 or Transtar Hydroflex Super Hi Build Waterborne Primer 1221/1225.

Storage after use: When finished using the product, leave the static mixer attached. Material will harden in the mixer and will seal the cartridge until the next use. In order to use the cartridge again, remove the static mixer and attach a new one. Dispense one static mixer length of material to equalize the mixer.



Flash Times/Dry Times

Work time.....	5 min
Tack free.....	15 min
Sand time.....	20 min
Paintable.....	30 min
Full cure time.....	24 hr



Product Specifications

Color.....	Gray	Size.....	7 fl oz
Shelf life.....	1 year	RTU solids.....	100%

Regulatory

Category.....	Adhesive	Wt % of volatiles.....	<1
VOC actual.....	0.00 #/gal (0 g/l)	Wt % of water.....	0
VOC regulatory.....	0.00 #/gal (0 g/l)	Wt % of exempt compound.....	0
Density.....	14.5 #/gal	Vol % of exempt compound.....	0



Limitations & Precautions

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.
- See Addendum B for more detailed product application.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.