

Technical Data Sheet

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Properties:

AKEMI® PR Speed 1 Min is a fast drying 2K-polyurethane adhesive suitable for permanent bonding of many different surfaces including metal, wood, most plastics, etc.

The product is characterized by the following qualities:

- solvent-free
- fast initial strength
- fast workability time
- excellent chemical resistance
- resistant to weathering and ageing

Application Area:

AKEMI® PR Speed 1 Min has been formulated for the permanent bonding and repair of many different surfaces. Typical applications are the filling of holes, tears and joints in metal, wood, stone and concrete and for the repair of most types of plastics, including repairing of splits, or replacing missing pieces in all damaged plastics (thermoset and thermoplastic) such as

- bumpers
- skirts headlamp casings
- door mirrors
- spoilers
- grills

Instructions for Use:

1. The surface must be clean, dry and free of grease.
2. Using P80 grit sand both the surrounding areas of the repair and re-clean.
3. Insert PR Speed 1 Min into 50 ml 1:1 applicator gun.
4. Balance A + B part.
5. Attach the static mixer nozzle.
6. Apply PR Speed 1 Min to one surface only and within 60 seconds bring both components together.
7. Can be treated after 10 - 30 minutes. This includes milling, drilling, tapping, etc.

Plastic Repair

1. Apply Catalfer SG-A Eco anti-static cleaner to repair area to ensure any contaminants are removed.
2. Drill crack end and carefully groove the sides of the damaged area to a 30 - 40° angle.
3. Using P80 grit sand both the surrounding areas of the repair.
4. Blow away the sanding dust with compressed air and re-clean repair areas with Catalfer SG-A Eco anti-static cleaner.
5. Cut PR Backing Film to cover length of repair and overlap by about 2 cm.
6. Insert PR Speed 1 Min into applicator gun and equalize A + B components before use.
7. Fit static mixer tip to the cartridge and apply a ball or bead of PR Speed 1 Min onto the PR Backing Film or onto surface of the repair area.
8. Within 60 seconds apply PR Speed 1 Min with PR Backing Film with uniform pressure to spread product evenly over rear of repair so product extrudes through the front of repair area.
9. For bonding together broken plastics such as lugs and mounting brackets it is recommended to apply adhesive around of breakage.
10. Hold the component in final required position for a minimum of 1 minute.

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11. At 20 - 25°C, after 10 - 15 minutes the repair area sanded to a smooth finish if required.
12. Avoid excessive speed, care must be taken not to overheat the plastic.
13. Removal of adhesive - uncured material may be removed from tools and equipment with a suitable cleaner, e.g. afin® Acryclean. Once cured the adhesive must be removed mechanically.

Special Notes:

- For professional use only.
- Attention: contains diisocyanates. May cause an allergic reaction. As from August 24, 2023, adequate training is required before industrial or commercial use.
- For proper waste disposal the container must be completely emptied.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

Technical Data:

Base:	2-K polyurethane based on MDI and ether ester polyols
Colour:	black
Dichte:	Comp. A: 1.02 g/cm ³ (23°C/50% RH) Comp. B: 1.19 g/cm ³ (23°C/50% RH)
Viscosity:	~ 50.000 MPa
Temperature resistance:	- 40°C up to + 120°C short term up to +140°C
Shore D hardness (DIN 53505):	70 (23°C/50% RH)
Working temperature:	+17°C up to +25°C (material)
Working temperature:	+5°C up to +30°C (ambient)
Elongation / elasticity:	~ 30%
Max. gap:	~ 5 mm
Volume change:	< 1 %
Open time:	~ 1 minute (23°C/50% RH)
Tack free:	~ 1.5 minutes (23°C/50% RH)
Re-workability:	10 to 30 minutes (23°C/50% RH)
Fully cured time:	~ 2 hours (23°C/50% RH)
Elongation at break:	> 30 MPa

Storage:

If stored in cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production.

Health & Safety:

Read Material Safety Data Sheet before handling or using this product.

Important Notice:

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.

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