

ProFix

Liquid Weld – Plastic Repair Kit

Instructions for Use

Product Description:

ProFix is a thermosetting liquid acrylic repair material specially formulated for repairing rigid plastics such as PMMA (Plexiglass, Lucite), PC, ABS, Lexan, PA (nylon), HIPS, SMC, PET, PVC and fiberglass. ProFix “melts” into the substrate and bonds on a molecular level with the parent plastic. This molecular bonding results in a repair as strong as the original material.

Directions for Use:

1. Bond surfaces should be prepared first by cleaning prior to ProFix application for best performance. Surfaces may be lightly sanded if required followed by a thorough cleaning with ProTech Plastic Wax & Grease Remover (PP500). Alternately, you may use any good quality water-based cleaner/degreaser to clean bond surfaces.
2. Pour the required amount of ProFix A (liquid) into the measuring cup provided (cups are marked in ml's) and stir in the recommended amount (use .25 ml Plastic Micro Spoon Part# PF03SP) of ProFix B (catalyst powder). Stir just enough to dissolve the powder in the liquid. Excessive stirring can cause air bubbles in the mix.

<u>Work Time Required</u>	<u>Part A (liquid)</u>	<u>Part B (powder)</u>
5 Minutes	5 ml	2 level spoon
8 to 10 Minutes	5 ml	1 level spoons
15 Minutes	10 ml	1 level spoon

FOR LARGER QUANTITY: MIXING RATIO BY WEIGHT

<u>Work Time Required</u>	<u>Part A (liquid)</u>	<u>Part B (powder)</u>
5 Minutes	10 : 1	
8 to 10 Minutes	20 : 1	
15 Minutes	40 : 1	

Standard Mix Ratio is 20 Parts A to 1 Part B for a 8 to 10 minute work time

For a thicker consistency, you can add our ProFix Thickening Agent Part# PF20TA to the mix for your desired application.

****ProFix Thickening Agent will not alter the cure time or affect the structural strength.****

Instructions for Use (cont'd)

3. Position the piece to be repaired on a flat, horizontal surface. The piece should be clamped or use our Aluminum Tape Part# PF04AT to hold the repair in place. Apply ProFix as required to the repair area. The piece should not be handled or moved until the ProFix has set hard (20 minutes approximately).
If the part being repaired has a piece missing you can make a mold by using our Aluminum Tape Part# PF04AT to make a form.
4. For repairing vertical surfaces, you can hold the ProFix in place with a thin sheet of plastic (PE), such as plastic bag or saran wrap.
5. Large repairs or thick sections should be filled in 2 or 3 applications; this will help to eliminate problems with shrinkage and bubbles. Cracks should be “V’d” out with a die grinder or file before application. When filling cracks use our Aluminum Tape Part# PF04AT on the back of the repair to prevent leakage.
When using multiple layers of ProFix insert one or two pieces of our Aluminum Reinforcing Screen Part# PF05AS between layers of ProFix for extra strength.
6. ProFix has a gel time of 5 - 15 minutes and is cured hard in 20 – 30 minutes at 77°F (20°C). Cure will be complete in 24 hours at which time the material will have developed full strength and resistance properties.
7. Excess material can be wiped up with a damp rag. This should be done prior to material set-up/gelling.

Storage:

ProFix should be stored in the original containers in a cool, dry location. Storage temperature should be maintained at 46-70°F (8-21°C) for best shelf life. Consult the product MSDS sheet for additional health and safety information.

Caution: ProFix contains Methacrylate Monomers. Care must be taken in the handling and use of this product. Use in a well ventilated area.

