



68422 BUMPER REPAIR

TECHNICAL DATA SHEET

Description

68422 BUMPER REPAIR adheres to substrates other repair materials cannot. Historically, bonding repair materials to polypropylene and other olefin-based plastics, EPDM, TPO and similar substrates has been difficult. This unique formulation takes the “problem” out of problem plastic repair.

Features

- State of the art epoxy technology
- Superior adhesion
- Does not shrink or pinhole
- Zero VOC
- Excellent sanding and feather edge
- No adhesion promoter necessary

Typical Properties

Container	1 oz. MINI-MAX cartridge
Color when mixed	Green
Working time	3-5 minutes @70°F (21°C)
Set time	5-10 minutes @70°F (21°C)
Cure time	15-20 minutes @70°F (21°C)

Handling and Application

PREPARATION: Suitable substrates- ABS, PP, PPO, EPDM, TPO, TPE and TEO.



1. Clean with **3833() SCUFF & CLEAN** and red scuff pad. Rinse with water and dry.
2. Clean with **3835() PLASTIC/LEATHER PREP**. Apply per directions.
3. Sand with 80 grit paper 2-3 inches around damaged area.
4. “V” groove damaged area with a 24 grit disc. Grind slowly. Excess heat may seal the pores of the plastic making adhesion difficult.
5. Re-clean with **3835()**.

MIXING:



Remove cap between pistons. Cut off cartridge tips at perforation. Dispense material and mix until uniform.

APPLICATION:



1. Reinforce large holes and damaged areas from the back side with **70006 PLASTIC REPAIR REINFORCING TAPE**. In such cases, clean the back side of the area with **3833()** and **3835()**. Grind with a 24 grit disc at low RPM. Place **70006** over the repair. Apply **68422** and spread firmly.
2. Apply **68422** to the repair area. Press firmly to eliminate air pockets. Apply higher than surrounding area to allow for sanding.
3. After **68422** has cured for 15-20 minutes, sand first with 80 grit, then finish with 180 grit paper.
4. For slight imperfections, reapply a skin coat of **68422** or use **39482 FLEXIBLE POLYESTER GLAZE**.
5. To fill sand scratches and prepare surface for painting, apply **3913() FLEXIBLE PRIMER SURFACER**, **420()3 HIGH BUILD PRIMER SURFACER** or **39624 WORLD CLASS™ FLEXIBLE PRIMER SURFACER**.

NOTE: For larger repairs, **39767 PROBLEM PLASTIC REPAIR MATERIAL** in the 7 oz. **DUAL-MIX** cartridge and **39768 PROBLEM PLASTIC REPAIR MATERIAL** in the 10 oz. kit are also available.

STORAGE:



68422 BUMPER REPAIR should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **68422** is 1 year when stored under normal conditions.

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 Material Safety Data Sheet (MSDS) 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 MSDS and product label are available upon request.

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