

# FMT6340 PLASTIC REPAIR KIT

## Technical Data Sheet

### Product information

FMT6340 is a two component, room temperature curing, black coloured, odourless, thixotropic polyurethane adhesive specially designed for structural bonding of a wide range of materials as thermosetting and thermoplastic materials, steel, aluminum, concrete, wood and glass.

#### Product Data:

Properties	Component A	Component B	Mixed
Chemical base	Polyol	MDI	Polyurethane
Cure mechanism	-	-	Polyaddition
Mixing ratio by volume	1,00	1,00	-
Mixing ratio by weight	0,89	1,00	-
Colour	black	amber	Black
Appearance	liquid	liquid	Thixotropic
Viscosity	1000 mPas	800 mPas	50000 mPas
Relative density	1,04	1,20	1,12
Application temperature	+10/ +30 °C	+10/ +30 °C	-
Flashpoint	>200 °C	230 °C	-
Vapour pressure	Very Low	0.000004 mmHg	-
Solubility in water	Insoluble	Insoluble	-
Shelf life	12 month	12 month	-

#### Processing:

The strength and durability of bonded joints are dependent on proper pre-treatment of the surfaces to be bonded. Joint surfaces should be cleaned with a good degreasing agent in order to remove all traces of dust, dirt, oil and grease.

Pre-treatment of thermoplastics materials such as PVC, polycarbonate, polypropylene, PMMA, etc., can use iso-propanol. Use of strong solvents is not recommended due to the risk of damage to the plastic surface.

Petrol or other solvents should never be used.

Where possible abrade the surface to remove paint (where necessary) to increase strength and holding of Bond. Allow the surface to dry before applying the adhesive.

#### Product application:

Mixing should be made through static mixer supplied with the product. Static mixers are one time use only.

Twin component cartridges can be dispensed via manual or specific pneumatic tools, based on capacity and cartridge shape.

For continuous process applications, automatic dosage system for low viscosity materials can be used. Base on specific needs our technical service is available to offer advice for the correct machinery to use with specific requirements.

The mixture must be applied directly from the mixer on the pre-treated dry surface. The optimal layer of adhesive that will guarantee the highest resistance for the joint should have at least 0.2 mm of thickness. The components have to be assembled within the first minute of extrusion of the adhesive and sealed with a steady pressure over the gluing area.



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## **Reaction mechanism:**

The speed of the hardening reaction is mainly influenced by two factors: the application temperature and the application thickness. Being an exothermic reaction, the speed decreases as the thickness and temperature application decreases. The substrate influences the speed of reaction, even in a small measure. Materials with a high coefficient of thermal conductivity will tend to slow down the reaction. The maximum temperature of the reaction will be reached in a 5 mm application thickness and will always be lower than 90°C.

## **Product storage:**

FMT6340 has a shelf life of 12 months from the initial production as long as it is stored in a cool and dry place, between +10°C and 25°C.

Once opened, the cartridges will last until the expiry date (as long as the above conditions are met) leaving the last mixer used on the cartridge.

## **Product handling cautions:**

FMT6340 products are generally quite harmless to handle provided that certain precautions are normally taken when handling chemicals are observed.

The uncured materials must not be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected.

Impervious rubber / plastic gloves should be worn. Eye protectors should be worn.

The skin should be thoroughly cleaned at the end of each working period by washing with soap and warm water. The use of solvents should be avoided. Paper towels should be used to dry the skin.

Adequate ventilation of the working area is recommended.

These precautions are described in greater detail in the safety data sheet for the individual products and should be referred to for further information.

end.



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