



TRI-PA TECHNICAL DATA

TWO COMPONENT PU ADHESIVE

TRI-PA is a two component, room temperature curing, black coloured, odourless, tixotropic polyurethane adhesive mainly oriented to auto body shop and makes possible fast and easy repairs on most of the damage to plastic parts.

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	Tixotropic
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	-

PRODUCT BENEFITS:

- Fast hardening time
- Excellent grinding properties
- High strength
- Easy to apply
- Over pain table
- No marking through
- Suitable for many different material

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AREA OF APPLICATION:

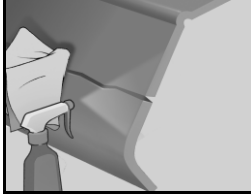
TRI-PA is used to repair plastic parts like bumpers, lights, front grills, blinkers, side protection, etc. whenever rigid parts are damaged.

Suitable substrates are: all thermosetting plastics and most of all thermoplastic such as ABS, PC, PA, PPO, PP, PP+EPDM, SAN.

TRI-PA is also has very good adhesion on many different material as metal, wood, concrete, ceramics and glass.

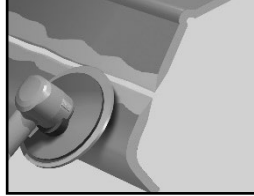
PRODUCT APPLICATION:

TRI-PA is available in bi-component cartridges by 50ml Blending should be made through static MIXERTIP.



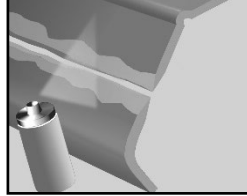
CLEANING

Clean the surface to be repaired using the degreaser and a dry cloth, do not forget to clean the part from both sides. It's very important to remove dust, grease and all contaminants in general.



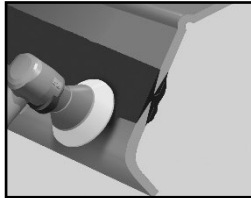
PREPARATION

Grind the damaged part with 80 grit sand paper on both sides. Make a V groove along the damaged area and use 80 grit sand paper on the surrounding area. Sand the back side of the repair area.



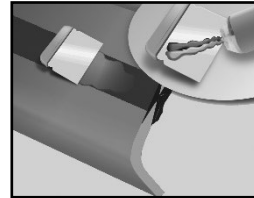
CLEANING AND PRIMING

Clean the sanded surfaces. Wait approximately 2 minutes and then apply Primer and wait 5 minutes before applying the plastic repair product.



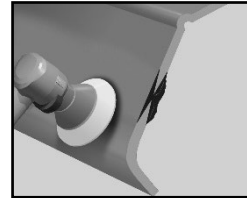
SANDING

After 15 minutes sand the repaired area (use 80 grit sandpaper and finish with 180 grit sand paper with 2-3 grit steps) to a smooth finish avoiding excessive speed and heat.



FINISHING

Clean the surface with degreaser. If necessary, apply a putty for plastics with spatulas to fill minor imperfections of the repaired surface.



REFINISHING

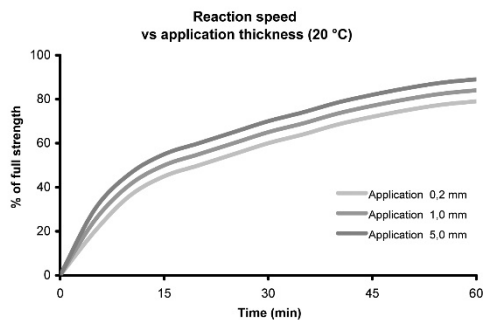
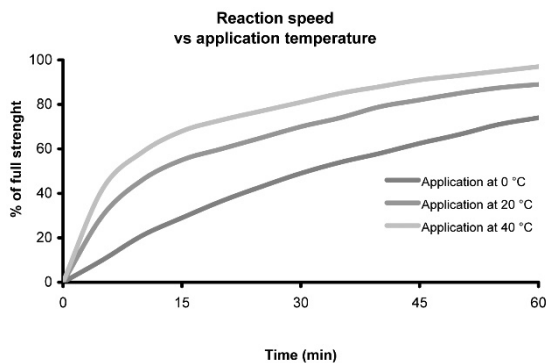
After 15 minutes sand the repaired area with 180-220 grit sanding paper. Clean the area with degreaser. Please refer to the recommendation of the paint manufacturer.

REACTION MECHANISM:

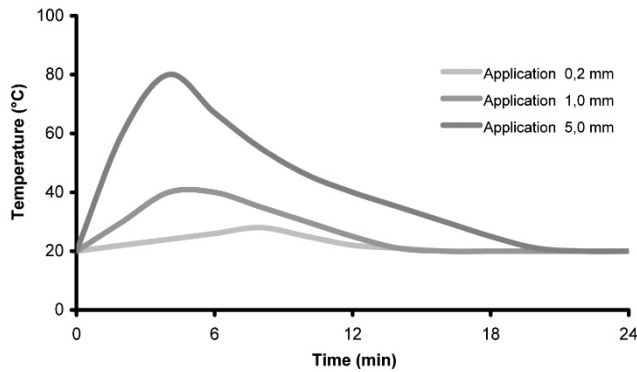
The speed of the harden reaction is mainly influenced by two factors: the application temperature and the application thickness. Being the reaction exothermic, the speed decreases as the thickness and temperature application decreases.

Even in smaller measure, the substrate influences the speed reaction. Materials with a high coefficient of thermo conductivity will tend to slow down the reaction.

The maximal temperature of the reaction will be reached in 5 mm. application thickness and is always lower than 90°C.



**Temperature curve of reaction
for applications at 20°C**



**TYPICAL REACTION PROPERTIES
10 gr of product at 20 °C**

Property	Value
Open time	1 min
Bonding time	5 min
Fully cured time	240 min
Temperature of exothermic reaction	80 °C

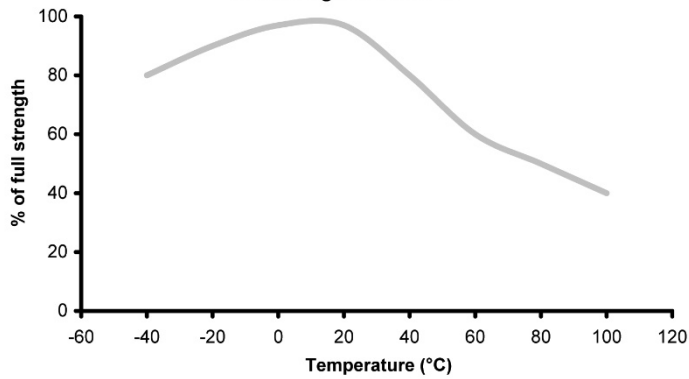
TECHNICAL CHARACTERISTICS OF CURED PRODUCT:

The below properties have been obtained through standard samples tests, made bonding by overlapping samples of different materials of dimensions 100 × 20 × 20 mm with an adhesion area of 20 × 20 mm.

The values obtained with standard methods on typical lots, are exclusively provided as technical information, and not as product specific .

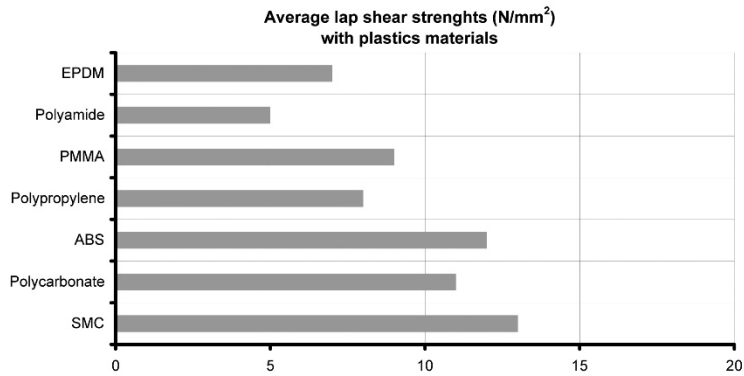
In any case, it will be up to the user to test the product for a specific situation and then give his final approval.

**Average lap shear strenght
vs temperature
Hardening 24 h at 20 °C**

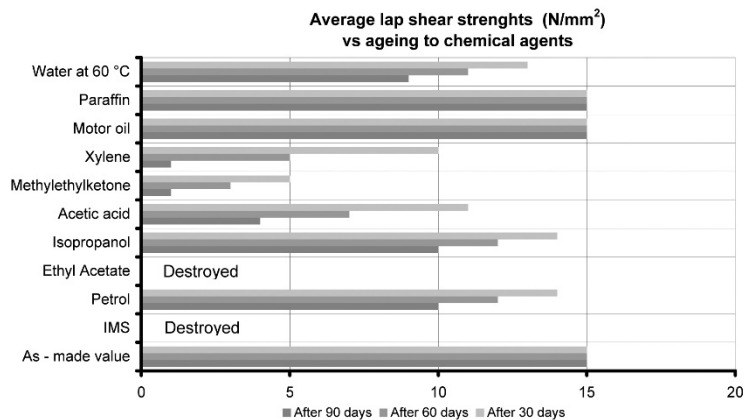


TYPICAL PROPERTIES AT 20 °C

Property	Value
Hardness	80 D
Tensile strength	22 N/mm ²
Elongation	15%
Resistivity	1,2x10 ¹⁵ Ωxcm
Service Temperature	-36 / +100 °C



The tests have been conducted at 20° C on plastic to plastic joints, which have been hardened for 24 hours at 20°C. Pre-treatment has been made by abrading and degreasing with iso- propanol.



If not specified, the tests have been conducted at 20 °C after immersion for 30, 60 and 90 days at 20 °C on steel to steel joints which have been hardened for 48 hours at 20 °C

Even if not UV resistant, due to the black colour the samples that have been used for the aging test have not shown any chromatic variation.

PRODUCT STORAGE:

TRI-PA 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. Expiry date is indicated on the label.

The cartridges have to be kept in a sealed plastic bag and protected from light and heating sources inside the original packaging

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

PRODUCT HANDLING CAUTIONS:

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.

The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection.

The skin should be thoroughly cleaned at the end of each working period by washing with soap and warm water. The use of solvents has to be avoided. Disposable paper 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.

NOTE:

The information, and, in particular, the recommendations relating to the application and end-use of TRI-PA are given in good faith based on Trident's current knowledge and experience of the products when properly stored, handled and applied under normal conditions.

We cannot assume responsibility for the results obtained by others over whose methods we have no control.

It is the user's responsibility to determine suitability for the user's purpose of any production method mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof.

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Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned copies of which will be supplied on request