

TECHNICAL DATA 3608

BONDING & REPAIR BLACK

► **Commercial description :**
CARTRIDGE BONDING & REPAIR
BLACK 1'

► **Product description :**

High strength structural repair for flexible and rigid application.

► **Field :**

Automotive, industry, joinery, mariner...

► **Technical data :**



Size :	Cartridges 200ml, 50ml or 20ml (see our catalogue).
Colours :	Black
Resin :	Polyurethane
Catalysis :	1/1 static mixer needed
Gel time :	1min 30
Drying time :	20 min at 20°C / 10 min. with IR
Complete drying time :	24h à 20°C
Water resistant :	YES
Solvent resistant :	NO
Temperature resistance :	30°C / +130°C
Storage Unopened :	1 year
Stotrage Opened :	2 month @ 20°C

TECHNICAL DATA

3608

➤ **Uses :**

Repair and / or bond : Plastic, SMC, caoutchouc, wood, aluminium, inox, painted metal.

Such as adhesive.

➤ **Substrate preparation :**

SURFACE MUST BE CLEAN AND DRY

Grind the surface, clean with 36021 or 37021. Dry.

Adhesion promoter 3704 can be used to increase adhesion onto plastic. Drying time 2 - 5 Min.

➤ **Set up Cartridge :**

To initially set up the cartridge, remove the cap and extrude a small amount of product until both chambers flow in equal amounts. Now you can move onto the application process

➤ **Application process :**

1. Using the supplied mixing nozzle (601N / 36012N / 36011N) apply 3608 on the part to be bonded.
2. Make sure both parts are aligned
3. Quickly press both parts together
4. Squeeze together to push out a bit of the product.
5. Hold in place for 20 to 30 second or hang the part if necessary. Do not move the part whilst the compound is setting.

Plastic repair

➤ **Substrate prep. :**

SURFACES MUST BE CLEAN AND DRY

1. Open the crack using a die grinder creating a beveled edge
2. Roughly sand the back of the component (5 centimeters on each side of the crack).
3. Sandown the front area with P120, taking care not to open widely the beveled edge.
4. Clean the component with the 36021 or 37021 cleaner and wipe a clean, dry tag rag. Any surplus moisture can be eliminated using a heat gun.
5. Apply 3704 waterbase Primer on the front and back, making sure to penetrate into the pores of the plastic. Leave to dry for 2-5 minutes (do not accelerate this process).

TECHNICAL DATA

3608

► Application process :

1. Cut two pieces of the repair film to the size of the repair
2. Apply the 3608 Repair compound directly onto the supplied film (never on the part) and ensure the mixer tip is inclined at a 60° angle and always submerged in the compound. You have 5 to 10 seconds to position the film and compound to the back of the damaged part.
3. Immediately after positioning the compound and film on the back, inject 3608 repair compound to the front along the length of the damaged area, applying a sufficient quantity to get the desired thickness (Be careful to always leave the mixer tip immersed in the compound!)
4. Quickly apply the 2nd repair film on top of the compound to spread evenly over the repair. Never use spatula directly on the compound!
5. Use a infra-red dryer to guarantee a long-lasting repair, distance of 40 cm for 20 minutes at a temperature of 60°C. (The product resists heating temperatures of up to 90°C).
6. Once the repair compound has cooled down and fully cured you can start sanding down and leveling any high areas, at this stage try and avoid sanding the actual part being repaired
7. With an orbital sander and using a minimum sanding disc of P120 start finishing of the repair, if you wish a sanding block can also be used to feather out the compound
8. Very important: At this stage we recommend you apply a skim coat of 3689 to remove any small imperfections and give you your desired final shape this will also seal the adhesive compound and guarantee the quality of the repair before the priming and painting process. Never use 3689 on Polyester.
9. 3689 can be sanded using P240 – P800 ready for priming

NOTE :

Information provided in this technical data sheet is based upon our best experience and technical knowledge; it does not absolve the users from carrying out tests and preventive checks in order to verify the suitability for use. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE.

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