



## REF

## Repair &amp; Fix

**TWO-PART METHACRYLATE ADHESIVE**

- Excellent shear, peel and impact strength over a wide temperature range
- Non sagging thixotropic formulation
- Will fill gaps of up to 5 mm
- Over paintable
- Resistant to weathering and humidity
- Room temperature cured with short open time
- No surface preparation 100% reactive
- Very good UV-resistance and excellent ageing properties
- Isocyanate-, phthalates-, solvent-, PVC- and silicone free.

**NOTICE**

All information including images are given with the greatest care. Still, it is appropriate to users regardless of the test the suitability of each product for their own purposes. Xintex is not liable for the completeness and accuracy of information and refuses warranty for your specific use. The guarantee, which Xintex products provide, relates only to the standard conditions of sale of this product. In no case Xintex can be held responsible for incidental damages, or damages for improper use or sale of the product to another customer.

**GENERAL INFORMATION**

REPAIR & FIX is a two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal and composite assemblies. REPAIR & FIX is Isocyanate-, phthalates-, solvent-, PVC- and silicone free. REPAIR & FIX can be over-painted with most types of lacquers.

Combined at a 1:1 ratio, it has an open time of 4 to 6 minutes and achieves 75% of ultimate strength in 10 to 20 minutes at room temperature (23°C). REPAIR & FIX offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

**TECHNICAL INFORMATION**

**ADHESIVE:**  
Form: liquid 20°C  
Colour: off-white  
Odour: characteristic  
Flash point (closed cup): 11°C  
Density: 0,97 - 1,03 g/ml  
Viscosity (at 40°C): > 40 mm²/s  
Temperature resistance: -40°C - 125°C  
Tensile strength: 24 Mpa  
Open time: 4-6 min  
Working time: 12-15 min  
Curing time: approx. 20 min on 23°C  
Complete curing: after 24 hours on 23°C

UV- and weather resistance: Excellent  
Grit blasted steel to grit blasted steel - 100% strength retained.  
Shelf life: 12 months from date of manufacture can be expected when stored at room temperature 23°C in the originally sealed cartridge  
Storage: All adhesives should be stored unopened in a cool, dry place (between 5°C and 25°C) when not used for a long period of time. This product should never be frozen!

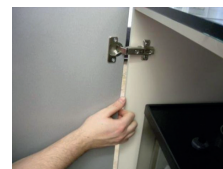
**AKITVATOR:**  
Form: liquid 20°C  
Colour: off-white  
Odour: characteristic  
Flash point (closed cup): 10°C  
Density: 0,95 - 1,01 g/ml  
Viscosity (at 40°C): > 40 mm²/s

**APPLICATION AND USE**

- The surfaces to be bonded should be clean, dry and free from dust and grease.  
Application temperature: Between 15 °C and 25° C.  
In case of doubt of the substrate that must be bonded, test the strength on a small sample of the substrate.
- Mixing:  
Mixing Ratio: 1:1  
Connect the mixertip to the cartridge and press out 2 cm (do not use) to be sure that you have a 100% mixture of the 2 components.  
PLEASE NOTE: Once the product cures in the nozzle it has to be thrown away and a new nozzle used.

- Assembling:  
Open time 4 - 6 minutes @ 23°C.  
After applying the adhesive, assemble the parts (within open time) and immediately clamp or press.  
Movement of the part after the working time has expired can result in bond strengths lower than normal. Ensure that the assembly remains undisturbed until fixture has occurred.
- Curing:  
Curing time: ca. 20 minutes @ 23°C.  
Complete curing: 24 hours @ 23°C.  
Temperatures higher or lower than 23°C will have influence on the open time and curing time.  
The viscosity's of Parts A and B of this adhesive are affected by temperature.

Article nr	Name	Content	Section
X911001	Repair & Fix creme 5 min.	50ml	ADHESIVES AND SEALANTS
X911101	Repair & Fix black 5 min.	50ml	ADHESIVES AND SEALANTS
Y911302	Mixer Tip 50 ml trans.	10 pcs	TOOLS
Y911312	Mixer Tip 50 ml trans fine dosage	10 pcs	TOOLS
Y911600	Reinforcement Tissue 12x360cm	1pc.	TOOLS
Y911601	Contouring Tissue 12x360cm	1pc.	TOOLS

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