



The +PLUSeries System comes with everything you need, 220ml & 50ml cartridges, application tips and dispensing guns.



Product Information

1. 220ml adhesive cartridges are sold 6ea to a case. Adhesive can be purchased in individual quantities.
2. 50ml adhesive cartridges are sold 12ea to a case. Adhesive can be purchased in individual quantities.
3. Static mixing tips are sold in quantities of 6, 72 and 144ea per bag.
4. Dispenser guns are sold 1ea.

Engineered To Exceed Your Expectations

Fabtech Systems +PLUSeries® 25, 60, 90 second and Composite structural adhesives are a versatile and fast two-part urethane system used for bonding and repairing plastics, composites, aluminum, steel, plaster and nearly anything you can think of commonly used in the O&P manufacturing process. Because it's a structural adhesive, it is significantly stronger than brittle, fracture prone acrylics commonly used in our industry today. These urethanes are so strong you can even drill and tap them! We're confident you'll never want to use smelly toxic acrylics again.



+PLUSeries® 25 Second Adhesive

+PLUSeries® 25 Second Cartridge Adhesive System is the fastest curing 2-component urethane known to be on the market. This urethane product is so fast it can often replace Cyanoacrylate "tacking" adhesives. Use this adhesive when you need your job done fast!

Features:

- Tan color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents and chemicals
- 25 Second working time
- 50ml and 220ml sizes



+PLUSeries® 60 Second Adhesive

+PLUSeries® 60 Second Cartridge Adhesive System is our most popular adhesive. The 60 second adhesive gives you all the same features as the 25 second product, but more working time, and it is still incredibly fast! Use this adhesive when you need just a little bit more working time.

Features:

- Tan color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents and chemicals
- 60 Second working time
- 50ml and 220ml sizes



Item #:	Description:
25SS	50ml 25 Second Adhesive
25SL	220ml 25 Second Adhesive

Item #:	Description:
60SS	50ml 60 Second Adhesive
60SL	220ml 60 Second Adhesive



+PLUSeries® 90 Second Adhesive

If 60 Seconds is not enough, then 90 seconds should be just right! +PLUSeries® 90 Second Cartridge Adhesive System gives you all the same features as the 25 and 60 second products, but more working time for some of those jobs that may require more time.

Features:

- Tan color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents and chemicals
- 90 Second working time
- Only available in 220ml size

Item #:	Description:
90SL	220ml 90 Second Adhesive



+PLUSeries® Mixing Tips 50ml

Disposable 50ml mixing tips sold in bags of 6ea, 72ea and 144ea.

Features:

- Easy to apply locking hub design
- Tapered end for precise placement of adhesives
- Disposable

Item #:	Description:
169506	50ml Mixing tips package of 6ea
169572	50ml Mixing tips package of 72ea
1695144	50ml Mixing tips package of 144ea



+PLUSeries® Mixing Tips 220ml

Disposable 220ml mixing tips sold in bags of 6ea, 72ea and 144ea.

Features:

- Easy to apply locking hub design
- Tapered end for precise placement of adhesives
- Disposable

Item #:	Description:
127216	220ml Mixing tips package of 6ea
127272	220ml Mixing tips package of 72ea
1271144	220ml Mixing tips package of 144ea



+PLUSeries® Composite Adhesive

+PLUSeries® Composite Adhesive is a two-part black pigmented urethane adhesive designed for structural bonding of today's high performance composite sockets and bracing systems used in O&P. Combined at a 1:1 ratio like our other PLUSeries products, it has a working time of one minute. As fast as our 60 Second products, our Composite adhesive requires little to no surface preparation while providing high strength and excellent fatigue endurance as well as superior toughness! Because of its black pigmentation, it's the perfect choice to use on carbon devices!

Features:

- Black color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents and chemicals
- 1 Minute working time
- 50ml and 220ml sizes

Item #:	Description:
C1SS	50ml Composite Adhesive
C1SL	220ml Composite Adhesive



+PLUSeries® 50ml Dispensing Gun

50ml Dispensing Gun

Features:

- Easy to use design
- Works with any 1:1 50ml size cartridge
- One time purchase

Item #:	Description:
G50	50ml Dispensing Gun



+PLUSeries® 220ml Dispensing Gun

220ml Dispensing Gun

Features:

- Easy to use design
- Works with 200ml and 220ml cartridges
- One time purchase

Item #:	Description:
G220	220ml Dispensing Gun



Product Information

Introduction:

Fabtech Systems +PLUSeries® 25, 60, 90 second and Composite structural urethane adhesives are a versatile and fast two part urethane system used for bonding and repairing plastics, composites, aluminum, steel, plaster and many other items commonly used in the O&P manufacturing process.

Preparation:

1. Remove the cap of the adhesive cartridge by twisting and pulling off for the 50ml size. On the 220ml cartridge pry the uppermost slot with a flat screwdriver. See image 1.
2. Properly place the cartridge into the gun. Prior to attaching the mixing tip, dispense a small amount of adhesive to ensure both sides flow evenly. If the both sides do not flow evenly, using a small poker carefully enlarge the restricted side to ensure full flow.
3. Attach mixing tips by locking tabs on the 50ml size or screwing on for the 220ml size.
4. Apply a generous amount of +PLUSeries® adhesive to the product.
5. Release the pressure on the metal tab located on the back of the applicator gun. This will allow you to easily remove the tip for your next use.
6. Assemble with the mating part within the recommended working time.
7. Allow adhesive to cure per recommendation. See table 1.
8. Sand and buff using industry standard tools.
9. Allow 10 –15 minutes to cure before weight bearing. **Wrap with fiberglass reinforcement tape.**
10. Leave tip on the cartridge to act as a cap.

Recommended Applications:

- Acrylics Aluminum
- Polyesters Wood
- Styrenics CAD Foams
- Vinyl Esters Dry Plaster
- Epoxy Fiberglass
- Urethanes Carbon
- Steel Composite Fibers

Non-recommended Applications:

- Surfaces where much flexibility is required
- Polypropylene
- Polyethylene
- Copolyesters

Shelf Life:

The shelf life for all +PLUSeries® adhesives is 2 years from MFG date. Storage above 23C/74° may reduce shelf life.

Clean Up:

Use a solvent such as acetone before the adhesive cures. For cured adhesive carefully scrape it off. Large spills of un-cured material should be cleaned up with an absorbent material and disposed of following your local policies for chemical disposal.

Caution:

This product contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided, and necessary protective equipment and clothing should be worn. Do not breathe vapor or dust. Use adequate exhaust ventilation.

Warranty:

Fabtech Systems will replace any material found to be defective. Because the storage, handling and application of this material are beyond our control, we can accept no liability for the results obtained.

Important Information:

Refer to the Material Safety Data Sheet (MSDS) for information on safety and handling before use. Fabtech Systems +PLUSeries® cartridge system is sold as a kit, and performance has been verified using the kit contents. Do not attempt to use other mixers in the application of this product. Do not mix the product with-out a mixing tip. This Use Guide and Instructions is incorporated as part of Fabtech Systems Recommendations for Use of +PLUSeries® adhesives by Fabtech Systems. Failure to adhere to recommendations in the Use Guide and Instructions sold with the product voids the Warranty.

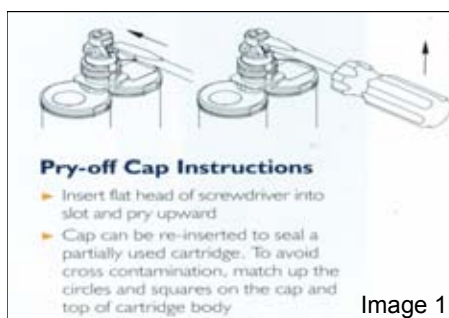


Image 1.

Table 1.

Product	25	60	90	Composite
Work Time	25 seconds	60 seconds	90 seconds	60 seconds
Sand time	1.5-3 minutes	5 minutes	5-7 minutes	5 minutes
Weight Bearing	10-15 minutes	10-15 minutes	10-15 minutes	10-15 minutes

REP

1.800.322.8324

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