


For repairing incorrectly drilled holes, cracks and damage to white rigid PVC, especially in plastic window profiles

Application areas	<p>Two-component product made from powder and liquid</p> <ul style="list-style-type: none">▪ for repairing faulty holes, cracks and damage to white rigid PVC, especially plastic window profiles▪ ideal for window fitters and specialists
Product benefits	<ul style="list-style-type: none">▪ practical portioning, weighing and calculations are no longer necessary▪ quick handling during processing▪ non-dripping▪ hard, impact-resistant adhesive joint▪ solvent-free
Base	2C polymerisation resins based on methyl methacrylate
Processing	<p>This product is for specialist trained personnel.</p> <p>Clean the area to be repaired using Wisaclean R 202. The surrounding area should be protected with masking tape.</p> <p>Component A (liquid) is carefully and completely poured into the container containing Component B (powder) after shaking vigorously, then mixed homogeneously.</p> <p>Smooth out the dry, damaged area within 3 min. Masking tapes must be removed immediately after spraying and smoothing.</p> <p>After just 20 min at room temperature, the filled area is first slowly sanded with a 240 grit and then finely sanded with a 400 grit.</p> <p>The sanding points must not heat up too much during the sanding process (risk of discolouration).</p> <p>Therefore, interrupt the sanding process temporarily if necessary. Remove the sanding dust with Wisaclean R 202.</p> <p>Then soak the cleaning paper THOROUGHLY with Wisatyp RP 55. Smooth the surface of the entire profile length, in the longitudinal direction of the profile, IN ONE PASS.</p> <p>The polishing agent strongly dissolves the PVC. Therefore, do not rub or repeat immediately.</p> <p>If necessary, the polishing process can be repeated as an exception after re-hardening (!!!) the surface of the material. Earliest after ca. 5 min.</p>

Important notes	<ul style="list-style-type: none">▪ Protect the damaged area from the effects of moisture during the entire repair! This is particularly the case on construction sites in wet weather conditions.▪ In the case of profile cracks, a triangular joint must first be made, e.g. with a chisel or milling cutter.▪ PMMA co-extruded and film-laminated profiles can only be levelled, but not sanded due to the sensitive profile surfaces!▪ It is strongly recommended that inexperienced users practice this handcrafted process in the workshop before their first use.
Mixing ratio	13 : 6 (Powder : fluid, based on parts by weight)
Behaviour of the mixture	When mixed, a thixotropic paste is formed which can be worked for approximately 3 - 4 min and sanded after 20 - 25 min (depending on temperature).
Film properties	once cured hard and impact resistant (comparable with rigid PVC)
Processing temperature	from +5 °C up to +30 °C; the processing time is halved at approx. +30 °C and approx. doubled at +10 °C
Grindability	from ca. 25 min (depending on temperature and humidity)
Processing time	ca. 3 min; the processing time is halved at approx. +30 °C and approx. doubled at +10 °C
Pot life	ca. 5 min
Curing time	ca. 120 min up to ca. 90 % ca. 24 h until final strength is achieved
Cleaning agents	Wisaclean R 202 for cleaning non-absorbent adhesive surfaces and fresh product residues. The cured product can normally only be removed mechanically. To wash your hands, please use water and soap. Wisatyp RP 55 to be used as a polishing agent.
Further information	 You can find more information about this product (link to the product on our homepage, safety data sheet, certificates, special enquiries etc.) under the adjacent ISOPIN QR code.
Item no.	RM 332.2K mini
Colour	white (ca. RAL 9016)
Delivery form	packing unit of 6 mixing units of 19 g
Shelf life	In closed original packaging, protected from direct sunlight and stored in a dry place between +15 °C and +25 °C, the official shelf life is 12 months from date of production (the printed expiry date is decisive).

Accessories	Item no.	Brief description
good to know...	RP 2033.12	Wisaclean cleaning paper: white, neither linting nor discolouring, made of 100 % cellulose, two-ply, perforated, embossed, sturdy. On practical small rolls. Delivery form = 12 rolls of approx. 210 sheets each 33x20 cm (LxW)

Safety and disposal: Familiarise yourself with the valid Safety Data Sheets (SDS) for the products used. All applicable safety regulations and disposal instructions must be observed.

Observe: All information is based on careful examinations in the labs and our previous practical experience. They are non-committal notes. Due to the many materials that are marketed and the different processing methods, which we cannot influence, we can, of course, not assume any warranty, including under patent-law, for the result of your work. We recommend performing sufficient own tests to find out if the product meets the respective requirements. In addition, we refer to our terms and conditions of sale, delivery and payment, available at www.wisabax.ch/agb.html. © Wisabax AG - This technical data sheet replaces all older versions.

Have you noticed an unclear formulation or an error? Thank you for your feedback. In case of doubt, the German version of the technical data sheet applies.