



Plastopang PVC & Polyurethane Bonding Cement



- Plastopang two-part cold bonding PVC cement is oil resistant and excellent for belt splicing and PVC and polyurethane belt fabrication, such as bonding V-guides, cleats, and edge walls.
- Plastopang can be used to bond PVC and soft durometer urethanes to metal or rubber. When bonding to metal, PANG Metal Primer should be used. When bonding PVC to rubber, Plastopang should be used in conjunction with Pangofol rubber bonding cement.

PLASTOPANG/ACTIVATOR MIXTURE RATIOS

MIXTURE RATIOS BY VOLUME

Plastopang Container Size	Activator (968F)
8 OZ	7.5cc
PINT (16 OZ)	15cc
QUART (32 OZ)	30cc
GALLON	(2) 60cc
5 GALLON	(10) 60cc
53 GALLON	(106) 60cc

MIXTURE RATIOS BY WEIGHT

Plastopang #1090F
24 parts : 1 part Activator #968F



For Best Results, Use These Products with Plastopang



PLASTOPANG PVC CEMENT (Clear)

Catalog Number	Quantity	Case Quantity
1090F/QT	1 Quart (.95L)	10
1090F/GAL	1 Gallon (3.8L)	4
1090F/5GAL	5 Gallon (19L)	N/A
1090F/53GAL	53 Gallon (200L)	N/A



ACTIVATOR

Catalog Number	Quantity	Case Quantity
968F/15cc	15cc	12
968F/30cc	30cc	12
968F/60cc	60cc	12



PANG METAL PRIMER

Catalog Number	Quantity	Case Quantity
960/QT	1 Quart (.95L)	10
960/GAL	1 Gallon (3.8L)	4



BUFLEX RUBBER & PVC CLEANER

Catalog Number	Quantity	Case Quantity
816F/QT	1 Quart (.95L)	12
816F/GAL	1 Gallon (3.8L)	4
816F/11OZ	11 oz (311 g) Aerosol Can	12

P.O. Box 486, Johnstown, Ohio 43031 USA
 Customer Service: 1-800-705-2206 or 1-740-967-9015 Fax: 740-967-1039
 Web: www.pangindustrial.com



Plastopang Instructions for Use

DESCRIPTION

Plastopang is a clear PVC based flammable two-part cold vulcanizing cement. Plastopang is oil and chemical resistant and will bond to most PVC and Polyurethane compounds.

COVERAGE

Plastopang will cover approximately 33 square feet (3.08 square meters) per quart (945ml) per single coat.

TEMPERATURE RANGE FOR APPLICATION

It is recommended to use Plastopang in temperatures between 50°F (10°C) and 100°F (38°). Temperatures below 50°F (10°C) will dramatically increase drying time. High humidity above 50% will also greatly increase drying time. Plastopang cures to a usable state in 4 to 6 hours at 72°F (22°C).

WORKING TEMPERATURE RANGE

The working temperature range for Pangofol once it is cured is -10°F (-23°C) to 140°F (60°C).

SHELF LIFE

The shelf life of Plastopang is 2 years from the date of manufacture in the sealed container. All cements and solvents should be stored in a cool, dark and dry environment.

AVAILABLE CONTAINER SIZES

Plastopang is available in 1-quart (.95L), 1-gallon (3.8L), 5-gallon (19L) and 55-gallon (200L) containers. Used with 968F/30cc Activator, Plastopang requires 30cc of Activator per quart or 24 parts by weight of Plastopang to 1 part of Activator.

TYPES OF APPLICATION

Plastopang cold bonding PVC cement can be used for the bonding of cleats, V-guides and edge walls as well as belt splicing and fabrication including PVC to metal bonding. Plastopang also works effectively on soft durometer urethanes.



Plastopang Instructions for Use

PROCEDURES

1. Outline the area to be prepared on the belt surface.
2. Buff the outlined area medium grit rasp or wire-brush on a low rpm-buffing tool (maximum 5,000 rpm) to achieve an RMA #2 or #3 buffed texture. Avoid gouging.
3. If the cleat, V-guide or edge walls are not pre-buffed, buff the base with medium grit rasp or cup. Avoid gouging.
4. Stir the can of Plastopang thoroughly before use. Mix thoroughly with the Activator at a mixture of 24 parts of Plastopang to 1 part of Activator by weight. The mixture is usable for 2 to 4 hours in a covered can.
5. Brush off loose debris, and then clean with Bufsol and a clean, lint free cloth.
6. Immediately after cleaning, apply a liberal/uniform coat of the Plastopang/Activator mixture to both surfaces with a brush and allow to dry until tacky.
7. Join the cemented surfaces and stitch or use an air hammer from the center out to the edges. Avoid trapping air between the two surfaces.
8. When applying cleats, V-guides or edge wall, hammer with a mallet or use an air hammer, then stitch down. The belt can be placed back into service in 6 hours.

Recommended Tools

Catalog Number	Description
966	Hand Held Soft Brass Brush
S2022	1½" x 4" 36 Grit Contour Wheel
S2023	1½" x 4" 60 Grit Contour Wheel
T34	Rubber Mallet
S1032	2,800 RPM Air Grinder
939	2" x ¼" Stitcher
S990	Rapid Action Air Hammer
S992	Repair Installation Hammer