



# NUMBER ONE IN O&P

## ENGINEERED TO EXCEED YOUR EXPECTATIONS

Fabtech Systems +PLUSeries™ structural adhesives—available in 25-second, 60-second, and Composite formulations—are a fast, versatile two-part urethane system designed for bonding and repairing plastics, composites, aluminum, steel, plaster, and other common materials in O&P manufacturing. Unlike brittle, fracture-prone acrylics still used in the industry, these structural adhesives provide exceptional strength and durability. They're even tough enough to be drilled and tapped.

- Highest-Strength Structural Adhesive
- No Sag
- Excellent Build-Up Qualities
- Consistent Curing Times
- Resistant To Temperature, Moisture, And Most Solvents & Chemicals
- Odor Free
- Freeze/Thaw Stable
- 3-Year Shelf Life



## ADHESIVES

### +PLUSeries 25 Second Adhesive

The fastest curing 2-component urethane on the market, this product offers an impressive 25-second curing time.


**Features:**

- Tan color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents, and chemicals
- 25 Second working time
- 50ml and 215ml sizes

Item Number	Size	Item Name
25SS	50ml	25 Second Adhesive
25SL	215ml	25 Second Adhesive

### +PLUSeries 60 Second Adhesive

This 60-second adhesive gives you all the same features as the 25-second product but with a 60-second curing time. Use this adhesive when you need a little more time to work.


**Features:**

- Tan color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents, and chemicals
- 60 Second working time
- 50ml and 215ml sizes

Item Number	Size	Item Name
60SS	50ml	60 Second Adhesive
60SL	215ml	60 Second Adhesive

### +PLUSeries Composite Adhesive

A black pigmented urethane adhesive designed for structural bonding of high-performance composite sockets and bracing systems used in O&P. It combines at a 1:1 ratio like other +PLUSeries products, with a one-minute working time. Ideal for carbon devices.


**Features:**

- Black color
- High-strength
- Structural adhesive
- Resistant to elevated temperatures, moisture, most solvents, and chemicals
- 1 Minute working time
- 50ml and 215ml sizes

Item Number	Size	Item Name
CIS	50ml	Composite Adhesive
CIL	215ml	Composite Adhesive

### +PLUSeries Starter Kit (Includes FREE Gun)

If you are new to our +PLUSeries adhesive system (or want to replace your worn out dispenser gun), try our adhesive starter kits. This kit includes our full range of adhesive types & the dispenser gun is FREE!


**Features:**

- Available in 215ml or 50ml sizes
- 1ea 25 Second Adhesive
- 1ea 60 Second Adhesive
- 1ea Composite Adhesive
- 12 Dispensing Tips
- Dispensing Gun

Item Number	Size	Item Name
ASK-P50	50ml	50ml FREE Gun Starter Kit
ASK-P220	215ml	220ml FREE Gun Starter Kit


**IMPORTANT INFORMATION**

This product is intended for professional use only. Users should reference the most current instructions and documentation, which are available online at [fabtechsystems.com](http://fabtechsystems.com). Always follow applicable guidelines and best practices.

215ml adhesive cartridges are sold individually, 6 per box, or 24 per case.

50ml adhesive cartridges are sold individually, 12 per box, or 96 per case.



## ACCESSORIES

### Mixing Tips - 50ml

Disposable mixing tips for dispensing 50ml 2-part urethane adhesives



**Features:**

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

Item Number	Size	Item Name
169506	50ml	Mixing tips package of 6ea
169572	50ml	Mixing tips package of 72ea
1699144	50ml	Mixing tips package of 144ea

### Mixing Tips - 215ml/220ml

Disposable mixing tips for dispensing 215ml/220ml 2-part urethane adhesives



**Features:**

- Easy to apply locking hub design
- Tapered end for precise placement of adhesives
- Disposable
- Short design = less waste

Item Number	Size	Item Name
127216	215ml/220ml	Short mixing tips package of 6ea
127272	215ml/220ml	Short mixing tips package of 72ea
1277144	215ml/220ml	Short mixing tips package of 144ea

### PowerMixer™ Tips - 215ml/220ml

Disposable mixing tips for dispensing 215ml/220ml 2-part urethane adhesives



**Features:**

- New Integrated Nut
- Compact Design-Half the size of standard tips
- Eco-Friendly 75% less waste

Item Number	Size	Item Name
PM1006	215ml/220ml	Mixing tips package of 6ea
PM1072	215ml/220ml	Mixing tips package of 72ea
PM1144	215ml/220ml	Mixing tips package of 144ea

### Adhesive Dispenser Guns

Adhesive cartridge dispensing guns. Durable & reusable, these guns are required for adhesive dispensing



**Features:**

- Easy to use design
- One-time purchase/re-usable
- Also works for Bondtek™ adhesives

Item Number	Size	Item Name
G50	50ml	50ml Adhesive Dispenser Gun
G220	215ml/220ml	215ml/220ml Adhesive Dispenser Gun



#### IMPORTANT INFORMATION

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215ml adhesive cartridges are sold individually, 6 per box, or 24 per case.

50ml adhesive cartridges are sold individually, 12 per box, or 96 per case.



## PREPARATION & APPLICATION

### ⚠ IMPORTANT INFORMATION

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### PREPARING FOR APPLICATION

#### 1. CARTRIDGE SETUP

##### Opening the Cartridge:

- For 50ml cartridges, twist and pull off the cap.
- For 215ml cartridges, pry the uppermost slot with a flathead screwdriver (see Figure 1).

##### Placing in Applicator Gun:

- Insert the cartridge into the gun.
- Before attaching a mixing tip, dispense a small amount of adhesive to confirm both sides are flowing evenly.
- If one side is restricted, carefully enlarge the opening with a small poker.

#### 2. ATTACHING THE MIXING TIP

- Secure the mixing tip by locking the tabs (50ml) or screwing it on (215ml).

#### 3. SURFACE PREPARATION

- Ensure bonding surfaces are clean, dry, and free from dust, oils, or waxes.
- For stronger adhesion, roughen smooth surfaces before applying the adhesive.

#### 4. APPLICATION

1. Apply a generous amount of +PLUSeries<sup>®</sup> adhesive to the surface.
2. Join the parts within the recommended working time (see Figure 2).
3. Allow the adhesive to cure 10-15 minutes\*.
4. Once cured, sand and buff using standard tools.

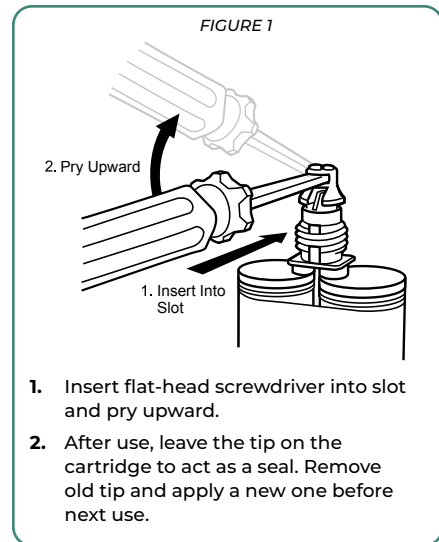


Figure 2	Timing Metric	+PLUSeries™ 25	+PLUSeries™ 60	+PLUSeries™ Composite
	Work Time	25 seconds	60 seconds	60 seconds
	Sand Time	1.5-3 minutes	5 minutes	5 minutes
	Full Cure Time*	10-15 minutes	10-15 minutes	10-15 minutes

#### \*SPECIAL INSTRUCTIONS FOR WEIGHT-BEARING APPLICATIONS

- ⚠ Minimum cure time: 15 minutes before use in load-bearing applications.
- Reinforcement needed: Always apply fiberglass cast wrap or similar structural support for added durability.



## HANDLING, USAGE & SAFETY

### STORAGE & USAGE

#### SHELF LIFE

- Fabtech has certified a 3 year shelf life on Pluseries Adhesives when stored properly
- Storage above 74°F (23°C) may reduce shelf life.

#### SPILL CLEANING INSTRUCTIONS

- Before curing: Use acetone or another appropriate solvent such as **Fabtech +Pluseries Cleaning Wipes**.
- After curing: Scrape off hardened adhesive carefully.
- Large spills: Absorb with a suitable material and dispose of per local chemical disposal regulations.

#### STORAGE TIPS

- Leave the mixing tip attached after use to act as a seal.



Try our **Solvent Replacement Cleaning Wipes**, specially formulated for use with +PLUSeries™ adhesives. A safer alternative to acetone and other harsh solvents, these wipes help maintain a cleaner, healthier work environment.  
ITEM#: 70CW

### ⚠ SAFETY

- Avoid skin and eye contact. Wear appropriate protective gear.
- Do not inhale vapors or dust. Work in a well-ventilated area.
- This product is intended for professional use only. Users should reference the most current instructions and documentation, which are available online at [fabtechsystems.com](http://fabtechsystems.com). Always follow applicable guidelines and best practices.
- **For any application involving weight-bearing or ambulation, always reinforce the adhesive product and connector with fiberglass cast wrap or structural lamination for added durability.**

### PRODUCT WARRANTY & USAGE GUIDELINES

- Fabtech Systems will replace any material found to be defective within the warranty period.
- Storage, handling, and application are beyond our control, so we do not accept liability for the final results.
- Always use the provided mixing tips—performance is only guaranteed when using the complete Fabtech Systems cartridge system.
- Failure to follow these instructions voids the product warranty.

### MATERIAL COMPATIBILITY

#### RECOMMENDED FOR USE ON:

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

#### ✗ NOT RECOMMENDED FOR USE ON:

Polypropylene  
Polyethylene  
Copolyesters



## HANDLING, USAGE & SAFETY

### I. POLICY ON THE APPROPRIATE USE OF FABTECH MATERIALS IN MEDICAL DEVICE MANUFACTURING

#### DEFINITION OF MEDICAL DEVICE MANUFACTURER

For the purposes of this policy, the Medical Device Manufacturer is defined as the person, company, clinician, or other educated and certified individual responsible for fabricating, modifying, and delivering a medical device for patient use. This includes professionals with the requisite knowledge, skills, and certifications necessary to ensure proper application and functionality of the medical device.

#### RESPONSIBILITY OF THE MEDICAL DEVICE MANUFACTURER

It is the sole responsibility of the Medical Device Manufacturer to determine the suitability of all new raw materials, products, and components, including any Fabtech products, to ensure that the final end-use product:

- Is safe for its intended use.
- Performs or functions as intended.
- Complies with all applicable legal and regulatory requirements.

The Medical Device Manufacturer is solely responsible for:

- Conducting all necessary tests and inspections.
- Evaluating the medical device under actual end-use requirements.
- Adequately advising and warning purchasers, users, and/or learned intermediaries (such as Orthotic/Prosthetic professionals) of pertinent risks.
- Fulfilling any postmarket surveillance obligations.

Any decision regarding the appropriateness of a particular Fabtech material in a specific medical device must be based on the judgment of the Medical Device Manufacturer, seller, competent authority, and treating professional.

#### WARRANTIES

FABTECH SYSTEMS WILL NOT WARRANT THAT ITS PRODUCTS ARE SUITABLE FOR USE IN ANY MEDICAL DEVICE OR MEDICAL APPLICATION.

### II. COMPLIANCE AND LIABILITY DISCLAIMER



Warning: This adhesive is not intended to function as a standalone structural component. It is specifically designed for use as a filler material to be fully encapsulated by an external permanent structural layer—such as carbon fiber composite or thermoplastic—during device fabrication.

Use outside of these parameters may compromise device performance. The practitioner/technician is solely responsible for verifying the suitability, application technique, and final outcome of the device.

For more detailed information, please refer to our [Appropriate Use Policy](#) (Section I) or visit our website for the most up-to-date resources.

