

ALUMINIUM PUTTY (F)

PRODUCT INFORMATION

	<u>Stock No.</u> 10611	<u>Package Size</u> 500g
Description	Aluminium-filled epoxy putty, use for rust free and effective repair work.	
Recommended Applications	• Use on applications requiring an aluminium, non-rusting finish • Repairing aluminium castings, parts and equipment • Patching aluminium castings	

PRODUCT DATA

Typical Physical Properties	Colour	Aluminium		
	Mix Ratio by Volume	4:1		
	Mix Ratio by Weight	9:1		
	% Solids by Volume	100		
	Pot life at 25°C/ mins	60		
	Specific Volume CC/Kg	632		
	Cured Shrinkage cm/cm	0.0008		
	Specific Gravity	1.58		
	Temperature resistance / °C	Dry 120°C		
	Coverage	1262cm ² /kg @ 5mm		
	Cured Hardness / Shore D	85 D		
	Dielectric Strength KV/mm	3.9		
	Adhesive Tensile Shear / MPa	18		
	Compressive Strength MPa	58		
	Coefficient of Thermal Expansion x10 ⁻⁶ cm/cm/°C	52		
	Thickness per Coat / mm	As Required		
	Functional Cure Time /Hours	16		
	Recoat Time /Hours	4		
Mixed Viscosity /cps (where applicable)	Putty			
Chemical Resistance	7 days room temperature cure (30 days) - Testing carried out 30 days immersion at 21°C			
	Ammonia	Poor	Methylene Chloride	Poor
	Cutting Oil	Very Good	Sodium Hypochlorite 5% (Bleach)	Very Good
	Isopropyl Alcohol	Poor	Sodium Hydroxide 10%	Poor
	Gasoline (Unleaded)	Very Good	Sulphuric Acid 10%	Very Good
	Hydrochloric Acid 10%	Very Good	Xylene	Fair
	Methyl ethyl Ketone (MEK)	Poor		
	Excellent = +/- 1% weight change			
	Very Good = +/- 1-10% weight change			
	Fair = +/- 10-20% weight change			
Poor = > 20% weight change				

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APPLICATION INFORMATION

Cure	A 12mm thick section of Devcon Epoxy will harden at 22°C in 4 hours. The material will be fully cured in 16 hours. The actual cure time of epoxy is determined by the mass used and the temperature at the time of repair.
Surface Preparation	Proper surface preparation is essential to a successful application. The following procedures should be considered: • All surfaces must be dry, clean and rough. • If surface is oily or greasy use MEK, Acetone, IPA or similar to degrease the surface. • Remove all paint, rust and grime from the surface by abrasive blasting or other mechanical techniques. • Aluminium repairs: Oxidation of aluminium surfaces will reduce the adhesion of an epoxy to a surface. This film must be removed before repairing the surface, by mechanical means such as grit-blasting or chemical means. • Provide a "profile" on the metal surface by roughening the surface. This should be done ideally by grit blasting (8-40 mesh grit), or by grinding with a coarse wheel or abrasive disc pad. An abrasive disc may be used provided white metal is revealed. Do not 'feather edge' epoxy materials. Epoxy material must be 'locked in' by defined edges and a good 75 - 125 microns profile. • Metal that has been handling sea water or other salt solutions should be grit blasted and high pressure water blasted and left overnight to allow any salts in the metal to 'sweat' to the surface. Repeat blasting may be required to 'sweat out' all the soluble salts. A test for chloride contamination should be performed prior to any epoxy application. The maximum soluble salts left on the substrate should be no more than 40 p.p.m. (parts per million). • Chemical cleaning with MEK, Acetone, IPA or similar should follow all abrasive preparation. This will help to remove all traces of sandblasting, grit, oil, grease, dust or other foreign substances. • Under cold working conditions, heating the repair area to 30°C - 40° C immediately before applying any of Devcon's Metal-filled Epoxies is recommended. This procedure dries off any moisture, contamination or solvents and assists the epoxy in achieving maximum adhesion to the substrate. • Always try to make the repair as soon as possible after cleaning the substrate to avoid oxidation or flash rusting. If this is not practical, a general application of FL-10 Primer will keep metal surfaces from flash rusting.
Mixing	Aluminium Putty is formulated to be a dense mix that can be applied easily to overhead and vertical surfaces without running or sagging. Add the hardener to resin and mix thoroughly on a mixing board using a spatula. Do not mix in the containers.
Application	Spread epoxy over prepared surface with a putty knife or similar tool. Press material firmly into all cracks and voids to ensure maximum surface contact and avoid trapping air. Apply a minimum of 1.6mm thickness. Do not feather edge. Use butt joints.
Shelf life & Storage	A shelf life of 3 years from date of manufacture can be expected when stored at room temperature (22°C) in their original containers
Precaution	For complete safety and handling information, please refer to Material Safety Data Sheets (MSDS) prior to using this product.
Warranty	ITW Devcon will replace any material found to be defective. As storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.
Disclaimer	All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data. For product information visit www.devconeurope.com alternatively for technical assistance please call +353 61 771501 (Ireland) or +49 (0) 431 71791-0 (Germany)