



Loctite UK Ltd

Watchmead, Welwyn Garden City
Hertfordshire. AL7 1JB
Tel +44 (0)1707 358 888
Fax +44 (0)1707 358 910

Technical Data Sheet

Product: Chemical Metal

(PP 1,2,3,4,5,6,7,8,9)

PRODUCT DESCRIPTION

Universal fix-it product, which joins, fills, seals and replaces metal, wood, stone etc. Sets hard in 10 minutes.

Typical applications

Literally thousands of different applications, limited only by the imagination of the user. Exceptionally good adhesion to most materials. Can be drilled and tapped. High chemical resistant.

Properties of uncured material

Component A (Paste)

Chemical type	Unsaturated polyester
Appearance	Dark grey
Density @ 25 °C, kg/dm ³	1,67
Viscosity @ 23 °C, Pa•s	
Brookfield HBF STD F-01	45-55

Component B (Hardener)

Chemical type	Dibensoyl Peroxide
Appearance	Yellow
Density @ 20 °C, kg/dm ³	1,15
Viscosity @ 20 °C, Pa•s	200-600

Typical curing performance

Cure speed vs. Time/temperature

By using 2-3 percent hardener in relation to the amount of paste, the mixture will cure in approx. 10 min. at +20 °C. After a further 10 min. the product can be sanded. Low temperature will prolong setting time.

Performance of cured material

Physical properties

Electrical conductivity (Ω/cm)	10 ¹⁴
Hardness (Shore D)	85-90
Tensile strength (N/mm ²)	~16
Compressive strength (N/mm ²)	~90

Adhesion

Mild steel	< +160 °C
------------	-----------

Chemical resistance

Cured material is resistant to water, salt solutions, organic solvents, diluted acids and alkalis.

General information

Directions for use

For best performance abrade and degrease all surfaces. The two components should be mixed thoroughly, 2-3 percent hardener in relation to the amount of paste. Do not mix more than will be used in 5 min. Apply a thin layer to the area to be filled, making sure it penetrates into any gaps, sanding grooves and surface irregularities. Fill immediately to the required thickness. Best results are achieved in dry conditions above +10 °C.

Setting time

Approximately 10 min. at +20 °C. Sandable after a further 10 min. Start sanding using a 120-240 grit abrasive paper. Clean tools with acetone, ethyl acetate, cellulose thinners or similar immediately after use.

Storage

The product has a storage life of 2 years from date of manufacture. For maximum storage life store in a cool place.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a licence under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

NOT FOR PRODUCT SPECIFICATIONS

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT LOCTITE SWEDEN AB R & D DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR THIS PRODUCT.

GÖTEBORG +46 (0)31 750 54 90