

MAGIC BOND EPOXY PUTTY

PRODUCT INFORMATION

	<u>Stock No.</u> DE 600	<u>Package Size</u> 114g Stick
Description	A two colour speciality epoxy putty 'stick' which is ease to mix by hand. Use for permanent repairs to various substrates.	
Recommended Applications	• Repairing tanks, drums and containers • Patching holes and gouges in pipes • Stopping leaks quickly • Repairing porosity holes in castings	

PRODUCT DATA

Typical Physical Properties	Colour	White		
	Mix Ratio by Volume	N/A		
	Mix Ratio by Weight	N/A		
	% Solids by Volume	100		
	Pot life at 25°C/ mins	15		
	Specific Volume CC/Kg	526		
	Cured Shrinkage cm/cm	N/A		
	Specific Gravity	1.90		
	Temperature resistance / °C	Wet 49°C Dry 121°C		
	Coverage	1053cm ² /Kg @ 5mm		
	Cured Hardness / Shore D	75 D		
	Dielectric Strength KV/mm	12		
	Adhesive Tensile Shear / MPa	6.3		
	Compressive Strength MPa	83		
	Coefficient of Thermal Expansion x10 ⁻⁶ cm/cm/°C	N/A		
	Thickness per Coat / mm	As Required		
	Functional Cure Time /Hours	1		
Recoat Time /Hours	N/A			
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	Fair	Methylene Chloride	Poor
	Cutting Oil	Very Good	Sodium Hypochlorite 5% (Bleach)	Fair
	Isopropyl Alcohol	Poor	Sodium Hydroxide 10%	Fair
	Gasoline (Unleaded)	Very Good	Sulphuric Acid 10%	Poor
	Hydrochloric Acid 10%	Fair	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				

Magic Bond

APPLICATION INFORMATION

Cure	After 5-10 minutes the epoxy will harden and form a firm bond. Full cured strength is in 24 hours. For a smooth appearance of cured epoxy, hand -rub the epoxy with water prior to hardening.
Surface Preparation	Proper surface preparation is essential to a successful application. The following procedures should be considered: • If surface is oily or greasy, use Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 to degrease the surface. • Remove all paint, rust and grime from the surface by abrasive blasting or other mechanical techniques. • 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 3 - 5 mil 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 Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 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 38°C - 43° C immediately before applying any of Devcon's Epoxies is recommended. This procedure dries off any moisture, contamination or solvents and assists the epoxy in achieving maximum adhesion to the substrate. • All prepared surfaces should be repaired as soon as possible, to eliminate any changes or surface contaminants.
Mixing	Simply twist or cut off the required amount for the repair from stick. Knead the putty with your fingers until the green colour disappears. All green colour must be gone and a uniform pure white colour is left which takes approx. one minute.
Application	Apply the mixed epoxy to the surface to be repaired within 2 minutes of mixing. The mixed epoxy does not show much bond strength at this time, and can be kneaded or formed into any cracks or holes to be filled. When applying to a damp, wet surface or slow leaking area, work the material forcefully into the surface until the exothermic process starts and adhesion strength starts.
Shelf life & Storage	Magic Bond Epoxy Putty should be stored in a cool, dry place when not used for a long period of time. A shelf life of 1 year 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 the appropriate Material Safety Data Sheets prior to using this product.
Warranty	ITW Devcon will replace any material found to be defective. As the 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 +44 (0) 870 458 7388 (UK) or +49 431 718830 (Germany).