



TECHNICAL DATA

PLASTIC STEEL 5-MINUTE PUTTY (SF)

Steel-Filled Fast Cure Epoxy Putty

Description

Plastic Steel 5-Minute Putty (SF) is a steel-filled, fast setting epoxy putty for filling, rebuilding and bonding metal surfaces.

Areas of application

- Making jigs or fixtures
- Restores worn or fatigued metals
- Patching of castings
- Rebuilding pump and valve bodies
- Restores bearing journals and races

Features

- Fast Cure (1 hour)
- Applies easily to vertical surfaces
- Bonds to aluminium, steel and many other metals, as well as concrete
- Machinable to metallic finish
- Makes repairs that are non-rusting

Chemical Resistance

(Chemical resistance is calculated with a 7 day, room temperature cure (30 days immersion) @ 24°C)

1,1,1 Trichloroethane	Fair	Phosphoric 10%	Fair
Ammonium Hydroxide 20%	Fair	Potassium Hydroxide 40%	Fair
Cutting Oil	Very good	Sodium Chloride Brine	Fair
Petrol (Unleaded)	Very good	Sodium Hypochlorite	Fair
Hydrochloric 10%	Fair	Sulphuric 10%	Fair
Methyl Ethyl Ketone	Poor	Sulphuric 50%	Poor
Methylene Chloride	Poor	Trisodium Phosphate	Fair
Mineral Spirits	Very Good	Xylene	Poor

The information contained in this Technical Bulletin is as up to date and correct as possible as at the time of issue. The data provided should be used as a guide only as the performance of the product will vary depending on differing operating conditions and application methods.

The sale of any product described in this Technical Bulletin will be in accordance with ITW Polymers & Fluids Conditions Of Sale, a copy of which is available on request. To the extent permitted by law, ITW Polymers & Fluids excludes all other warranties in relation to this product.

Limitations

Not recommended for long term exposure to concentrated acids or to organic solvents.

Technical Data

Typical Physical Properties: Cured 7 days @ 24°C

		Test Method
Colour	Dark Grey	
Mix Ratio (Resin to Hardener)	Weight 1.7:1 Volume 1:1	
Mixed Viscosity	Putty	
Work Time of 500gms minutes @ 24°C	5	
Cure Time	1 hour	
Recoat Time	15-30 minutes	
% Solids by Volume	100	
Specific Volume	440cm ³ /kg	
Specific Gravity	1.96 gm/cm ³	
Cure Shrinkage	0.0006 cm/cm	ASTM D2566
Hardness Shore D	85	ASTM D2240
Adhesive Tensile Shear	16 MPa	ASTM D1002
Tensile Strength	22.2 MPa	ASTM D638
Compressive Strength	71.8 MPa	ASTM D695
Modulus of Elasticity	1672 MPa	ASTM D695
Co-efficient of Thermal Expansion	61 x 10 ⁻⁶ °C ⁻¹	AS TM D696
Thermal Conductivity	2.65 x 10 ⁻³ cal.cm/sec/cm ² .°C	ASTM C177
Dielectric Strength	1181 volts/mm	ASTM D149
Dielectric Constant	35	ASTM D150
Flexural Strength	38.6 MPa	ASTM D790
Maximum Operating Temperature	Dry: 93°C	
Coverage (per coat)	878cm ² /kg @ 5mm	

Directions for use

Surface Preparation

Proper surface preparation is essential to the success of any epoxy application. In all cases the surface should be clean, dry, free from oils, and rough.

1. Remove all oils, dirt and grease by means of a strong cleaner/degreaser (Devcon® Surface Cleaner is suitable for this process).
2. Roughen the surface by grit blasting (8-40 mesh grit) or grinding. A 75-125 micron profile is desired for most applications, including defined edges (do not 'feather edge' epoxy).

Note: For metals exposed to sea water or other salt solution, grit blast and high pressure water blast the area, then leave overnight to allow any salts in the metal to 'sweat' to the surface. Repeat blasting to 'sweat out' all soluble salts. Perform chloride contamination test to determine soluble salt content (should be no more than 40ppm)

3. All abrasive preparation should be followed by another cleaning to remove any remnants from that process.
4. Repair surface as soon as possible to eliminate any changes or surface contaminants.

Mixing

Ideal application temperature is 13°C - 32°C. Under cold conditions, heating the repair area to 38°C - 43°C is recommended to dry off any moisture, contamination, or solvents, as well as to assist epoxy in achieving maximum adhesion properties.

AUSTRALIA

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NEW ZEALAND

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Unit 2, 38 Trugood Drive
East Tamaki 2013, Auckland
Phone (09) 272 1945 Fax (09) 273 6489

Mix Ratio – Resin to hardener: Weight 1.7:1, Volume 1:1

----- It is strongly recommended that full units be mixed, as ratios are pre-measured. -----

1. Add hardener to resin.
2. Mix thoroughly with a putty knife or similar tool (continuously scrape material away from sides and bottom of container) until a uniform, streak free consistency is obtained.

Application

Spread mixed material over the repair area and work firmly into the substrate to ensure maximum surface contact. Plastic Steel 5-Minute Putty (SF) fully cures in 1 hour, at which time it can be machined, drilled, or painted.

For Bridging Large Gaps or Holes

Place fibreglass sheet, expanded metal or mechanical fasteners between repair area and Plastic Steel 5-Minute Putty (SF) prior to application.

For Vertical Surface Applications

Plastic Steel 5-Minute Putty (SF) can be troweled up to 6mm thick without sagging.

For Maximum Physical Properties

Cure at room temperature for 2 ½ hours, then heat cure for 4 hours @ 100°C.

For ±24°C Applications

Applying epoxy at temperatures below 24°C lengthens functional cure and pot life times. Conversely, applying above 24°C shortens functional cure and pot life.

Machining

Allow material to cure for at least 1 hour before machining

- Lathe speed 46 m/minute
- Cut: Dry
- Tools: Carbide top rake 6° (+/- 2°) – Side/front 8° (+/- 2°)
- Feed rate (rough): Travel speed 0.50 mm Rough cut 0.50 mm – 1.5 mm/rev
- Feed rate (finishing): Travel speed 0.25 mm Finish cut 0.25 mm/rev
- Polishing: Use 400 to 650 emery paper wet. Material should polish to a 25-50 micron finish

Compliances

Accepted for use in U.S. meat and poultry plants.

Storage and Shelf Life

Store in dry conditions between 10°C and 40°C, away from sources of heat and naked flames. Protect from frost. When stored in original sealed containers, the minimum shelf life is two (2) years.

Packaging

Plastic Steel 5-Minute Putty (SF) is available in 250gm and 500gm kits.

Ordering Information:

250 gm Kit	#D10250
500 gm Kit	#D10240

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Health & Safety Information

The product is non-hazardous. A Material Safety Data Sheet is available from the ITW Polymers & Fluids Technical Department upon request or available on our website www.itw-devcon.com.au .

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