MAGIC BOND EPOXY PUTTY

PRODUCT INFORMATION

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Package Size</th>
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<tbody>
<tr>
<td>DE 600</td>
<td>114g Stick</td>
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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: 1053cm²/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

<table>
<thead>
<tr>
<th>7 days room temperature cure (30 days) - Testing carried out 30 days immersion at 21°C</th>
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<tbody>
<tr>
<td>Ammonia</td>
</tr>
<tr>
<td>Cutting Oil</td>
</tr>
<tr>
<td>Isopropyl Alcohol</td>
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<tr>
<td>Gasoline (Unleaded)</td>
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<tr>
<td>Hydrochloric Acid 10%</td>
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<td>Methyl ethyl Ketone (MEK)</td>
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Excellent = +/- 1% weight change
Very Good = +/- 1-10% weight change
Fair = +/- 10-20% weight change
Poor = > 20% weight change
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 38ºC - 43ºC 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 (22ºC) 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).