

BRONZE PUTTY (BR)

PRODUCT INFORMATION

<u>Stock No.</u> 10261	<u>Package Size</u> 500g
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Description Recommended Applications	Bronze-filled epoxy for repairing, rebuilding and maintaining bronze parts and equipment.
	<ul style="list-style-type: none"> Repairs cracks, dents and breaks in equipment, machinery or castings Rebuilds parts and equipment Rebuilds shafts, trays and chutes Repairs to food processing equipment

PRODUCT DATA

Typical Physical Properties	Colour	Bronze		
	Mix Ratio by Volume	3:1		
	Mix Ratio by Weight	9:1		
	% Solids by Volume	100		
	Pot life at 25°C/ mins	35		
	Specific Volume CC/Kg	447		
	Cured Shrinkage cm/cm	0.001		
	Specific Gravity	2.24		
	Temperature resistance / °C	Dry 121°C		
	Coverage	894cm ² /Kg @ 5mm		
	Cured Hardness / Shore D	85 D		
	Dielectric Strength KV/mm	1		
	Adhesive Tensile Shear / MPa	18		
	Compressive Strength MPa	59		
	Coefficient of Thermal Expansion x10 ⁻⁶ cm/cm/°C	59.4		
	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		Very Good	Methylene Chloride	Poor
Cutting Oil		Very Good	Sodium Hypochlorite 5% (Bleach)	Very Good
Isopropyl Alcohol		Poor	Sodium Hydroxide 10%	Very Good
Gasoline (Unleaded)		Very Good	Sulphuric Acid 10%	Poor
Hydrochloric Acid 10%		Poor	Xylene	Very Good
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	<p>Proper surface preparation is essential to a successful application. The following procedures should be considered:</p> <ul style="list-style-type: none"> • 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. • Provide a 30° 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 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	Bronze 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 the resin and mix thoroughly on a mixing board using a spatula. Do not mix in the containers.
Application	For best results, product should be kept and applied at room temperature. Bronze Putty can be applied when temperatures are between 10°C and 50°C. Spread Bronze Putty over prepared surface with a putty knife. Press firmly to ensure maximum surface contact and avoid trapping air. To bridge large gaps or holes use fibreglass, sheet metal or wire mesh.
Shelf life & Storage	A shelf life of 3 years from date of manufacture can be expected when stored at room temperature (21°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 the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.
Disclaimer	<p>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.</p> <p>For product information visit www.bigagroup.com / www.devconeurope.com alternatively for technical assistance please call +385 52 880 882 or send an e-mail to biga@biga.hr.</p>



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