

PLASTIC STEEL 5 MINUTE PUTTY (SF)

PRODUCT INFORMATION

	<u>Stock No.</u> 10241	<u>Package Size</u> 500g
Description	A fast curing, steel-filled epoxy putty for dependable emergency repairs and quick maintenance work.	
Recommended Applications	<ul style="list-style-type: none"> Repairs cracks and breaks in equipment, machinery or castings Patches and rebuilds blow holes or pits in castings Rebuilds worn equipment, pump and valve bodies Restores bearing journals and races 	

PRODUCT DATA

Typical Physical Properties	Colour	Dark Grey		
	Mix Ratio by Volume	1:1		
	Mix Ratio by Weight	1.7:1		
	% Solids by Volume	100		
	Pot life at 25°C/ mins	5		
	Specific Volume CC/Kg	455		
	Cured Shrinkage cm/cm	0.009		
	Specific Gravity	2.2		
	Temperature resistance / °C	Dry 90°C		
	Coverage	909cm ² /Kg @ 5mm		
	Cured Hardness / Shore D	86 D		
	Dielectric Strength KV/mm	1.18		
	Adhesive Tensile Shear / MPa	14		
	Compressive Strength MPa	72		
	Coefficient of Thermal Expansion x10 ⁻⁶ cm/cm/°C	61		
	Thickness per Coat / mm	As Required		
	Functional Cure Time /Hours	1		
	Recoat Time /Minutes	15-30		
	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%	Fair
	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



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APPLICATION INFORMATION

Cure	A 12.7mm thick section of Devcon Plastic Steel® Putty (SF) will harden at 22°C in 1 hour. The material will be fully cured in 16 hours at which time the material can be machined, drilled or painted. 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 suitably keyed for the best results. • If surface is oily or greasy use MEK, Acetone, IPA or similar to degrease the surface. • Remove all old material from the surface by abrasive blasting or other mechanical means. • Aluminum repairs: Oxidation of aluminum surfaces will reduce the adhesion of an epoxy to a surface. This film must be removed before repairing the surface, by mechanical means such as abrasive blasting or by chemical means. • Provide a profile on the metal surface by roughening the surface. This should be done ideally by abrasive 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. Epoxy material should be 'locked in' by defined edges and a good 75 - 125 micron 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 blasting, 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	<p>Plastic Steel 5 Minute 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 resin and mix thoroughly on a mixing board using a spatula. Do not mix in the containers.</p> <p>Remember you only have a 5 minute pot life in total.</p>
Application	For best results, product should be kept and applied at room temperature. Plastic Steel 5 Minute Putty can be applied when temperatures are between 10°C and 50°C. Spread the 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, expanded metal or other mechanical fasteners.
Shelf life & Storage	A shelf life of 3 years from date of manufacture can be expected when stored unopened at room temperature (22°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 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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