

**RoHS
Compliant**

Description

A steel filled epoxy adhesive for general maintenance and repairs. Can be used to repair work or fatigues metals, patch castings, making jigs and fixtures, rebuild pumps and valve bodies.

Applications

Repairs work or fatigued metals.
Patch castings.
Making jigs and fixtures.
Rebuilds pump and value bodies.
Restores bearing journals and races.

Cure

Working time is 45 minutes at 24°C functional (75%) cure is achieved in 16 hours at 24°C. For maximum physical properties, heat cure for 4 hours at 34°C after curing at room temperature of 2.5 hours.

Specifications

Colour	: Grey when mixed
Mixed Viscosity	: Paste
Solids by Volume	: 100 %
Cured Density	: 2.33 gm/cc
Cure Shrinkage ASTM D2566	: 0.0006 in/in
Specific Volume	: 11.9 in/lb
Working Time	: 4-6 mins
Comprehensive Strength ASTM D695	: 8.260 PSI
Adhesive Tensile Strength EASTMD1002	: 2.800 PSI
Cured Hardness Shore D ASTM 2240	: 78-80
Dielectric Strength volts/mil ASTM D149	: 50-90
Coverage	: 48 sq.in/lb@ 1/4"
Temperature Range	: -40°C to 121°C

Chemical Characteristics

Kerosene	: Very Good
Toluene	: Fair
Ammonia	: Very Good
10% Sulphuric acid	: Very Good
10% Hydrochloric acid	: Very Good
10% Sodium Hydroxide	: Very Good
Methanol	: Unsatisfactory
Chlorinated solvent	: Very Good

Part Number Table

Description	Part Number
Steel Epoxy Resin, Putty, 25ml	MP-SER13-25

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