



Plastic Steel® 5-Minute® Putty (SF)

Description:	A steel-filled, fast-setting epoxy putty for filling, rebuilding, and bonding metal surfaces.
Intended Use:	Industrial Use: Restores worn or fatigued metals; patches castings; makes jigs and fixtures; rebuilds pump and valve bodies; restores bearing journals and races
Features:	Bonds to aluminum, concrete, and many other metals Resistant to chemicals and most acids, bases, solvents, and alkalis Applies easily to vertical surfaces Machinable to metallic finish
Limitations:	Suitability of product is determined by the end user for their application and process. Not recommended for long term exposure to concentrated acids or to organic solvents

Typical Physical Properties: Technical data should be considered representative or typical only and should not be used for specification purposes.

Cured 7 Days @ 75°F (24°C)

Adhesive Tensile Shear
Coefficient of Thermal Expansion (x10-6)
Compression Strength
Cured Shrinkage
Dielectric Constant
Dielectric Strength
Flexural Strength
Hardness
Modulus of Elasticity
Solids by Volume
Temperature Resistance
Thermal Conductivity (x10-3)

Typical Values

2,026 psi (14.0 MPa)
34 in/in.°F (61.2 cm/cm.°C)
10,400 psi (71.7 MPa)
0.0006 in/in (cm/cm)
35
30 volts/mil (1.2 kV/mm)
7,680 psi (52.9 MPa)
85 Shore D
7.5 psi x10⁵ (5.2 GPa)
100%
Dry: 200°F (93°C)
2.65 cal/s.cm.°C

Standard Tests

Cure Shrinkage ASTM D 2566
Adhesive Tensile Shear ASTM D 1002
Dielectric Strength, volts/mil ASTM D 149
Coef. of Thermal Expansion ASTM D 696
Flexural Strength ASTM D 790
Thermal Conductivity ASTM C 177
Compressive Strength ASTM D 695
Cured Hardness Shore D ASTM D 2240
Dielectric Constant ASTM D 150
Modulus of Elasticity ASTM D 638

Uncured Properties @ 72°F (23°C)

Color
Coverage (1/4" / 6.35mm)
Functional Cure
Mix Ratio by Volume
Mix Ratio by Weight
Mixed Viscosity
Pot Life @ 75F
Recoat Time
Specific Gravity
Specific Volume

Dark Grey
49 in2/lb (697 cm2/Kg)
1 hr
1:01
1.7:1
Putty
5 min.
15-30 min.
2.2
12.2 in3/lb (0.44 cm3/g)

Surface

1. Thoroughly clean the surface with Devcon® Cleaner Blend 300 to remove all oil, grease and dirt.
2. Grit blast surface area with 8-40 mesh grit, or grind with a coarse wheel or abrasive disc pad, to create increased surface area for better adhesion (Caution: An abrasive disc pad can only be used provided white metal is revealed). Desired profile is 3-5mil, 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. Clean surface again with Devcon® Cleaner Blend 300 to remove all traces of oil, grease, dust or other foreign substances from the grit blasting.

4. Repair surface as soon as possible to eliminate any changes or surface contaminants.

WORKING CONDITIONS: Ideal application temperature is 55°F to 90°F (13°C to 32°C). In cold working conditions, directly heat repair area to 100 - 110°F (38°C - 43°C) prior to applying epoxy and maintain at this temperature during any moisture, product cure to dry off contamination or solvents, as well as to achieve maximum performance properties.

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

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

INTERMEDIATE SIZES (1,2,3 lb. units): Place resin and hardener on a flat, disposable surface such as cardboard, plywood or plastic sheet. Use a trowel or wide-blade tool to mix the material as in Step 2 above.

LARGE SIZES: (25 lb., 30 lb., 50 lb. buckets): Use a T-shaped mixing paddle or a propeller-type Jiffy Mixer Model ES on an electric drill. Thoroughly fold putty by vigorously moving paddle/propeller up and down until a homogenous mix of resin and hardener is attained.

Application Instructions:

1. Spread mixed material on repair area and work firmly into substrate to ensure maximum surface contact.
2. Assemble with mating part within recommended working time.
3. Apply firm pressure between mating parts to minimize any gap and ensure good contact (a small fillet of epoxy should flow out the edges to display adequate gap fill.) Plastic Steel® 5-Minute® Putty (SF) fully cures in 16 hours, at which time it can be machined, drilled, or painted.

FOR BRIDGING LARGE GAPS OR HOLES

Place fiberglass 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 ¼" (6.4 mm) thick without sagging.

FOR MAXIMUM PHYSICAL PROPERTIES

Cure at room temperature for 2.5 hours, then heat cure for 4 hours @ 200°F (93°C)

FOR ± 70°F APPLICATIONS

Applying epoxy at temperatures below 70°F (21°C) lengthens functional cure and pot lifetimes. Conversely, applying above 70°F (21°C) shortens functional cure and pot life.

MACHINING:

Allow material to cure for at least one hour before machining.

- Lathe speed: 150 ft/min
- Cut: Dry
- Tools: Carbide Top Rake 6° (+/-2°) – Side/Front 8°F (+/-2°)
- Feed Rate (rough): Travel speed .020 Rough cut .020 - .060
- Feed Rate (finishing): Travel speed .010 Finish cut .010
- Polishing: Use 400-650 grit emery paper wet. Material should polish to a 25-50 micro inch.

Storage:

Shelf life 3 yrs from manufacture. See package label. Store at room temperature, 70 °F (21°C).

Compliances:

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

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

1,1,1-Trichloroethane	Fair
Ammonium Hydroxide 20%	Fair
Cutting Oil	Very good
Gasoline (Unleaded)	Very good
Hydrochloric 10%	Fair
Methyl Ethyl Ketone	Poor
Methylene Chloride	Poor
Mineral Spirits	Very good

Phosphoric 10%	Fair
Potassium Hydroxide 40%	Fair
Sodium Chloride Brine	Fair
Sodium Hypochlorite	Fair
Sulfuric 10%	Fair
Sulfuric 50%	Poor
Trisodium Phosphate	Fair
Xylene	Fair

Precautions:

FOR INDUSTRIAL USE ONLY: Please refer to the appropriate Safety Data Sheet prior to using this product.

Warranty:

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Order Information:

Item No. 10240
Package Size 1 lb. kit (0.45 Kg)

Contacts:

www.itwpp.com

ITW Performance Polymers (EMEA)
Bay 150, Shannon Industrial Estate
Shannon, County Clare, Ireland V14 DF82
TEL: +353 61 771 500
FAX: +353 61 471 285
Email: customerservice.shannon@itwpp.com

ITW Performance Polymers (US)
30 Endicott Street
Danvers, MA 01923 USA
TEL: 855 489 7262
FAX: 978 774 0516
Email: info@itwpp.com

Disclaimer:

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