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MAGIC BOND EPOXY PUTTY

PRODUCT DATA SHEET

A hand kneadable, speciality epoxy putty that mixes in 1 minute for permanent repairs to many substrates

- Contains fading green dye that becomes pure white after mixing.
- May be applied under water (fresh or salt water)
- Bonds to Fibreglass, metal, wood, concrete, ceramic, glass
- Does not go yellow to UV exposure
- Hardens in 10 minutes, back in service in an hour, full strength in 24 hours

RECOMMENDED APPLICATIONS

- Repairing tanks and drums
- Patching holes in pipes
- Stopping leaks
- Repairing porosity holes in castings

PRODUCT DATA

Typical Properties: 7 days cured at 24°C

Colour	Green / white (changes to white after mixing)
Viscosity	Putty / hand kneadable
Pot life @ 24° C	20 minutes
Comprehensive strength ASTM D695	83 N/mm ²
Adhesive Tensile Shear ASTM D1002	5 N/mm ²
Cured hardness shore D ASTM D2240	75
Dielectric Strength Volts/mil, ASTM D149	300
Solids	100%
Temperature Resistance	Wet - 49° C Dry - 121° C

Chemical Resistance: 7 days room temperature cure (30 days immersion @ 24°C)

10% Sulphuric Acid	Fair	Toluene	Very good
10% Hydrochloric Acid	Fair	Ammonia	Very Good
Chlorinated Solvents	Very good	10% Sodium Hydroxide	Excellent
Methanol	Very good	Kerosene	Very good

Epoxies are very good in water, saturated salt solutions, leaded gasoline, mineral spirits, ASTM #3 oil and propylene glycol. Epoxies are generally not recommended for long term exposure to concentrated acids and organic solvents. For immersion applications this product is not recommended.

PLEASE CONTACT FACTORY FOR OTHER CHEMICALS



Certificate No. FM 11623

REF: Y0050 11/96

Registered England No. 559693 Registered Office PO Box 87, Queensway, Forestlath, Swansea SA5 4YE



APPLICATION INFORMATION**Surface applications**

Proper surface preparation is essential to a successful application. The following procedures should be considered:

- First, degrease the surface by using any one of Devcon's Industrial Cleaners. Oil, grease and dirt must be removed before applying any epoxy material.
- All surfaces must be thoroughly roughened 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. This creates increased surface area for better adhesion. A 3-5 mil profile is desired for an application. 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 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)
- All abrasive preparation should be followed by chemical cleaning with any of Devcon's Industrial Cleaners. 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 38°C - 43° 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.
- All prepared surfaces should be repaired as soon as possible, to eliminate any changes or surface contaminants.

MIXING

Twist or cut off required amount from stick. Then Knead with fingers to uniform colour. All green colour dye must be gone and a uniform pure white colour is left.

APPLICATION

Apply to surface to be repaired within 2 minutes of mixing. The mixed epoxy does not show much bond strength at this time, but 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 exotherm starts and adhesion strength starts.

CURE

After 5-10 minutes the epoxy will harden and form a firm bond. Full chemical cure is reached after 60 minutes. For a smooth appearance of cured epoxy hand rub the epoxy with water prior to hardening.

PRECAUTION

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product.

For technical assistance please call 01933 675299

Warranty

Devcon 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.

ORDERING INFORMATION:

<u>Stock No</u>	<u>Unit size</u>
11600	114g

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