



Atlas Minerals & Chemicals, Inc.



DATA SHEET

5-60PI (7-99²)
Supersedes 5-60PI (2-80)



DESCRIPTION AND USES

EPOXYBOND PUTTY is a two part, hand-moldable epoxy of putty consistency that bonds tenaciously to most surfaces. It is supplied in convenient cartridge form that provides simple equal portion mixing without scales or volumetric measuring vessels. When fully cured, it becomes hard enough to machine, drill, saw, tap, file, sandpaper and paint.

EPOXYBOND PUTTY will adhere to glass, metals, concrete, ceramics, wood, reinforced polyester, phenolics, polystyrene, acrylic, cellulose, melamines, urea, nylon, to itself or to any combination of these items. EPOXYBOND PUTTY can be used to stop leaks, set bolts, screws and pins, repair castings and machinery parts, patch ductwork, secure hooks and fittings and seal cracks in concrete, metal, terra-cotta, plaster or hard-board. Electrical cables can be sealed water-tight with EPOXYBOND PUTTY. EPOXYBOND PUTTY will adhere to damp surfaces and fully cure underwater.

PACKAGING

EPOXYBOND ADHESIVE PUTTY

4 x 8-3/4 lb. (4.0 kg.) boxes / carton each containing:

10 x 7 oz. (198 g.) cartridges Resin

10 x 7 oz. (198 g.) cartridges Hardener

EPOXYBOND PUTTY

6 x 45 oz. (1.3 kg.) boxes / carton each containing:

18 x 1-1/4 oz. (35 g.) sticks Resin

18 x 1-1/4 oz. (35 g.) sticks Hardener

AVAILABLE COLORS

EPOXYBOND ADHESIVE PUTTY is available in white or black. EPOXYBOND PUTTY is available in white only.

APPLICATION

1. Surfaces to be bonded should be thoroughly cleaned and all loose particles removed. Slightly roughen surface with sandpaper. No surface priming necessary.
2. After cutting off equal portions of Resin and Hardener, mix together until uniform, approx. two minutes.
3. Use sufficient thickness to obtain good surface wetting action, curing and physical strength (usually 1/8" [3.2 mm.]).
4. Apply EPOXYBOND PUTTY to both surfaces to be bonded or joined and press firmly together.

PHYSICAL PROPERTIES

EPOXYBOND PUTTY exhibits the following properties when completely set:

PROPERTY	TYPICAL VALUE
Dielectric Strength	250 Volts / mil
Compressive Strength	10,000 psi. (68.9 MPa)
Bond Strength	450 psi. (3.1 MPa)
Maximum Use Temperature Intermittent Continuous	275°F (135°C) 212°F (100°C)
Tensile Strength	2,000 psi. (13.8 MPa)
Coefficient of Expansion, in./in./°F (cm./cm./°C)	3.35 x 10 ⁻⁵ (1.86 x 10 ⁻⁵)

5. To aid forming and shaping, gently smooth the surface with a clean sponge or putty knife dampened with water.
6. After application, EPOXYBOND PUTTY should not be disturbed until completely set.

TEMPERATURE	APPROXIMATE SETTING TIME
60°F (16°C)	150 min.
70°F (21°C)	90 min.
80°F (27°C)	60 min.
90°F (32°C)	40-45 min.
100°F (38°C)	30-35 min.
120°F (49°C)	15-20 min.

TYPICAL SETTING TIME

The setting of EPOXYBOND PUTTY results from an exothermic reaction. Curing can be accelerated by placing in an oven or by use of any external heat source. The greater the heat, the quicker the curing but do not heat above 200°F (93°C).

CLEAN-UP AND DISPOSAL

Remove excess material from repaired surface before it begins to harden. Wash hands and skin with soap and water immediately after use. Use a nylon scrub pad to clean mixing tools before material begins to harden. Solvents, such as laquer thinner, paint thinner or alcohol, will have to be used to remove material after it has begun to harden.

Dispose of residues and wastes in accordance with the directions in the Material Safety Data Sheets and government regulations.

STORAGE AND SHELF LIFE

Store all materials in a cool, dry environment. Keep all materials out of direct sunlight. Ideal storage temperature is 75°F (24°C). Protect from freezing. In unopened original containers, the materials referred to in this Data Sheet have a shelf life of approximately one year.

PRECAUTIONS

The materials referred to in this Data Sheet are for Industrial Use Only. They contain materials that present handling and potential health hazards. Consult Material Safety Data Sheets and the container labels for complete precautionary information.

TECHNICAL SERVICES

ATLAS maintains a staff of Technical Service Representatives who are available to assist you with the use of ATLAS products. In the event of difficulties with the application of ATLAS materials, the installation should be stopped immediately and ATLAS' Technical Service Department consulted for assistance.

WARRANTY

ATLAS warrants that its products will be free from defects in workmanship and materials under normal use for a period of one (1) year from the date of shipment by ATLAS (provided the products are installed before the expiration of the shelf life). THERE ARE NO EXPRESS OR IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR THE PURPOSE FOR THIS PRODUCT WHICH EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF. ATLAS' LIABILITY FOR ALLEGED BREACH OF THIS WARRANTY SHALL BE LIMITED TO REPAIR OR REPLACEMENT OF THE DEFECTIVE PRODUCT (BUT NOT INCLUDING REMOVAL OF THE DEFECTIVE PRODUCT OR INSTALLATION OF REPLACEMENT PRODUCTS). ATLAS SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES DURING THE WARRANTY PERIOD OR THEREAFTER. **ATLAS' WARRANTY IS VOIDED IF PAYMENT FOR PRODUCT IS NOT RECEIVED IN FULL.**