

FR 938 QUICK SET STEEL PUTTY

PRODUCT	A metal filled, ambient temperature curing , two-pack Epoxy Paste with outstanding mechanical and thermal properties	
APPLICATION	By spatula	
VISCOSITY / 25 ^o C	Non-sagging Paste	
MIXING RATIO	<u>By Weight</u> :	<u>By Volume</u> :
	100 Parts of Resin	100 Parts of Resin
	11 Parts of Hardener	35 Parts of Hardener
COLOUR	Metallic grey 3	
RECOMMENDED MIXING TIM	- 5 Minutes 3	
<u>GEL TIME / 25^oC</u> (5mm thick film application)	mins	
<u>SETTING TIME / 25^oC</u> (5mm thick film application)	8-10 mins	
SPECIFIC GRAVITY / 25 ^o C		
<u>PHYSICAL CHARACTERISTICS</u>	Resin	: 3,2 g/cm ³
	Hardener	: 1 - 1,15 g/cm ³
	Mixed Compound	: 2,9 g/cm ³
HARDNESS AFTER 24 HOURS CURE / 25 ^o C	Shore D 70 - 75	
FULL CURE / 7 DAYS / 25 ^o C	Shore D 75 - 80	
TEMPERATURE RESISTANCE	90 -100 °C 0,05 -	
	0,1 %	
CURE SHRINKAGE (Cured 7 days / 25 ^o C)		
CO-EFFICIENT OF THERMAL EXPANSION cm/cm / °C	24 x 10 ⁻⁶	
TENSILE STRENGTH (ASTM D638)	45 - 50 MPA 70 -	
	75 MPA	
FLEXURAL STRENGTH (ASTM D790)		

COMPRESSIVE STRENGTH 75 - 80 MPA

IMPACT STRENGTH CHEMICAL 11 kJ/m²

CHARACTERISTICS

(Cured 7 days / 25⁰C)
(Immersion 30 days / 25⁰C)

SULPHURIC ACID 10% CONCENTRATION Good - Satisfactory
HYDROCHLORIC ACID 10% CONCENTRATION Good - Satisfactory

AMMONIA
10% SODIUM HYDROXIDE Very good

WATER AND SALT SOLUTION OIL Excellent

AND GREASE Excellent Good -

PETROL, AROMATIC SOLVENTS Excellent

STORAGE STABILITY 12 months stored under dry and cool conditions in sealed containers

TOXICITY Very low toxicity at ambient temperatures. However, gloves should be worn and adequate ventilation must be ensured during application.

PROPERTIES AND USES Eli-Fil FR913 Steel Putty can be used for emergency and permanent repairs of broken castings, tanks, parts of machinery, to level irregularities and fill blow holes, to build up worn parts and to bond various metals, ie. iron, steel aluminium. The product is also suitable for making tools, jigs, models, etc.

NOTICE The technical specification and/or our technical advice whether verbal, in writing or by trials is given in good faith and based on our test results obtained but without warranty. It does not release the user from the obligation to test the products supplied by us or any third party as to the suitability for the intended application.

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