



PRODUCT DESCRIPTION

A Steel-filled epoxy putty for general maintenance and repairs.
For filling, rebuilding and bonding metal surfaces.

SAS380

INTRODUCTION

- Repairs worn or fatigued metals
- Patches castings
- Making jogs and fixtures
- Rebuilds pump and valve bodies
- Restores bearing journals and races

WHERE TO USE

- Applies easily, needs no special tools
- Bonds to most metals, concrete
- Machinable (see below)
- Resistant to most chemicals
- Qualified under Mil. Spec DOD-C-24176B

APPLICATION DETAILS

Directions for Use:-

Proper surface preparation is essential to the success of any epoxy application. In all cases, the surface should be clean, dry free from oils and rough.

1. Remove all oils, dirt and grease by means of a strong cleaner/degreaser.
2. Roughen the surface by grit blasting (8-40mesh grit) or grinding. A3-5mil profile for most applications.
3. All abrasive preparation should be followed by another cleaning to remove any remnants from that process.
4. Ideal application temperature is 55°F –90 °F. Under cold conditions, heating the repair area to 100°F-1 10°F is recommended.
5. Add hardener to resin and mix thoroughly with a screwdriver or putty knife until a uniform, streak-free consistency is obtained (about 4minutes) Mix Ratio – Resin to Hardener :Weight 9:1, Volume 2.5:1
6. Spread mixed material over the repair and work firmly into the substrate to ensure maximum surface contact.
7. To bridge large gaps or holes, use fibreglass tape, expanded metal or mechanical fasteners.
8. MACHINING Allow material to cure for at least 4 hours before machining. Lathe speed: 150ft/min. Cut: Dry Tools: Carbide Top Rake 6° (+/-2°) – Side/Front 8° (+/-2°) Feed rate (rough): Travel speed 0.020 Rough cut 0.020-0.060 Feed Rate (finishing): Travel speed 0.010 Finish cut 0.010 Polishing: Use 400 to 650 emery paper wet. Material should polish to a 25-50micron finish.

TECHNICAL FEATURES

Colour	Black
Mixed viscosity	Putty
% solids by volume	100
Cured density	2.33 gm/cc
Cure shrinkage ASTM D2566	0.0006 in/in
Specific volume	11.9 in/lb
Pot life	45 mins
Comprehensive strength ASTM D695	8,260 PSI
Adhesive tensile strength EASTMD1002	2,800 PSI
Cured hardness shore D ASTM 2240	85 D
Dielectric strength volts/mil ASTM D149	30
Coverage	48 sq.in/lb @ 1/4"
Temperature resistance	wet - 100°F Dry - 250°F

CHEMICAL RESISTANCE

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

Please consult factory for other chemicals. Epoxies are very good in water, saturated salt solution, 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.

PRECAUTION

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

CURE

Working time is 45 minutes @ 75°F. Functional (75%) cure is achieved in 16 hours @ 75°F. For maximum physical properties, heat cure for 4 hours at 200°F after curing at room temperature for 2.5 hours.