



EVO-STIK Hard & Fast Metal Epoxy Putty

TWO PART EPOXY RESIN ADHESIVE PUTTY

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Fact Sheet No.: TDS00492

YOUR SMART ADVANTAGES

- Steel reinforced metal epoxy putty, suitable for use with metals and most other types of material
- Sets steel hard in 10 minutes and can be used underwater
- Can be drilled, tapped, filed, machined, sanded and painted once dry

USES

EVO-STIK Hard & Fast Metal Epoxy Putty is an easily worked, cold setting two-part epoxy resin putty. On curing, the putty provides a tough, durable grey coloured material which is dimensionally stable, resistant to chemical attack and can be painted. The usable life of the mixed putty is up to 3 minutes at 25°C.

EVO-STIK Hard & Fast Metal Epoxy Putty will form a strong bond with most structural materials such as metal, glass, most plastics, wood, and dry concrete.

PRODUCT CHARACTERISTICS

Colour	Resin: Grey Hardener: Black/Grey
Form	Extruded Stick
Specific Gravity	2.0 approx. (when mixed)
Composition	Resin: Epoxy Resin Hardener: Formulated Polyamine
Product Code	30812349 Blister Pack x 6
Storage/Shelf Life	Store for up to 24 months from date of manufacture when stored in original, unopened packaging. Store under dry conditions within the temperature range of +5°C to +30°C.
Solids content	100%

TYPICAL PERFORMANCE DATA (Approx.)

Service Temperature	-40°C to +120°C depending on conditions of use
Water Resistance	Good
Oil & Petrol Resistance	Good
Chemical Resistance	Good
Sandability	Sandable when set. Please wear a dust mask.
Paintability	Good

DIRECTIONS FOR USE

IMPORTANT: Before using EVO-STIK Hard & Fast Metal Epoxy Putty refer to the relevant Health & Safety Data Sheet, available at www.bostik.co.uk.

PREPARATION

1. Always open and use adhesive products over a protected surface, and avoid contact with clothing. Preferably wear gloves to avoid contact with the skin.
2. Make sure surfaces are dry, clean and free from dust, corrosion, dirt and grease. For even better bonding slightly roughen surfaces with sandpaper, and then remove any dust.
3. Following the instructions on the back of the blister card. Twist or cut off the required amount of putty.
4. To mix, knead with fingers (gloves recommended) until the material is uniform in colour and streak free. If mixing is difficult, warm to room temperature.

APPLICATION

5. Apply to a clean, dry surface, firmly working into any gaps.



6. For a smooth appearance, hand rub with water or a damp cloth prior to the material hardening. A simple method to produce a smooth gloss finish is to press polythene sheet onto the tacky surface. Allow the putty to cure and then peel off the sheet.
7. After 5 to 10 minutes the putty will harden like metal and start to form a strong repair. After 30 to 60 minutes the putty is cured and can be drilled or sanded. We recommend eye and respiratory protection if the material is being ground, drilled or sanded.

NB: Exact setting times depend on temperature, quantity mixed and the temperature of the materials being bonded.

CLEANING

8. Uncured resin/hardener mixtures can be cleaned from tools using cellulose thinners, acetone or EVO-STIK Adhesive Cleaner.
9. Please note that solvents may attack some rubbers, plastics, painted surfaces, fabrics etc.
10. Bear this in mind if intending to use solvent to remove excess adhesive, and carry out a preliminary test first.
11. Cured adhesive residues can usually be dissolved from tools by soaking in commercial paint stripper. Refer to the paint stripper manufacturer's instructions for use and safe handling.
12. The adhesive may be removed from the skin using a suitable proprietary hand cleaner. Do not use solvents in contact with the skin.

PRECAUTIONS IN USE

EVO-STIK Hard & Fast Metal Epoxy Putty is not intended for repairing or making items that are used for storing food or drink. It is not suitable for bonding oven doors or car mirrors. Do not use on polyolefin's (e.g. polythene or polypropylene).

For any application not covered please contact Technical Services on +44 (0)1785 272625 or visit www.bostik.co.uk for advice.

Recommendations and suggestions are for guidance only, since conditions of use are completely beyond our control.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet for EVO-STIK Hard & Fast Metal Epoxy Putty, available at www.bostik.co.uk.



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