



EpoxySystems' Product #652

Metal Filled Trowel Grade Epoxy

DESCRIPTION

PRODUCT #652 Metal Filled Trowel Grade is a two-component, 100% solids, metal-reinforced polymeric compound which can be used to repair virtually any metal surface that has been damaged, cracked or worn.

ADVANTAGES

- Excellent adhesion to all metals
- Machineable
- Can be drilled, tapped or sanded
- Chemical-resistance
- Heat resistance up to 400 F
- No shrinkage

WHERE TO USE

- Worn shafts
- Keyways
- Hydraulic rams
- Stripped threads
- Cracked engine blocks
- Pumps & valves

PHYSICAL PROPERTIES

Color	Gray
Mix Ratio	3A:1B
Pot Life	20 mins. @ 75 F
Specific Gravity	1.65
Compressive Strength ASTM D 695/7 days	17,200 psi
Flexural Strength ASTM D 790/7 days	13,500 psi
Shear Strength (tensile: steel to steel)	2,400 psi
ASTM D 1002	

SURFACE PREPARATION

All surfaces to be repaired must be clean of dirt, grease and oil. For best results, remove contamination with abrasive blasting and non-flammable cleaner/degreaser, making sure all dust is removed.

MIXING

Either mix the entire contents of the base and activator or measure three (3) parts of base and one (1) part of activator, by volume, and mix with spatula thoroughly to produce a streak-free material. Scrape mixing board frequently to insure complete mixing.

APPLICATION

Apply by brush or applicator. Material should be worked into the profile of the surface to achieve maximum adhesion. Material can be heat-cured for one (1) hour at 200 F to achieve ultimate properties.

PACKAGING: Available in one (1) kg. units

COVERAGE: One (1) kg unit equals 38 cu. in

LIMITATIONS

Material should be used in 40 to 90 F temperatures and in less than 90% humidity.

SHELF LIFE

One (1) year in closed containers. Store between 60 F and 85 F.

CAUTIONS

"A" Component: Warning! Contains epoxy resin. May cause skin irritation or allergic response. Avoid contact with skin. Avoid breathing vapors when heated. Wear protective gloves, goggles and barrier creams. In case of skin contact, wash thoroughly with soap and water. In case of ingestion, **do not** induce vomiting.

"B" Component: Warning! Danger! Causes severe burns. Contains alkaline amine-strong sensitizer. Avoid skin contact. Avoid breathing vapors when heated. Wear protective gloves, goggles and barrier creams. In case of skin contact, wash thoroughly with soap and water. In case of ingestion, induce vomiting. If irritation persists, seek medical attention.

**FOR INDUSTRIAL USE ONLY
KEEP AWAY FROM CHILDREN**

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