2107 West Blue Heron Blvd.
Riviera Beach, FL 33404
Phone: 561-845-2425
Toll Free: 800-327-6880
www.itwconsumer.com

Plastic Steel/ Steel Weld Epoxy

2 oz. tubes
Technical Data Sheet

Rev 02/08

PRODUCT DESCRIPTION: Plastic Steel/Steel Weld Epoxy is a two part, fast curing, high strength, general purpose epoxy. A cold welding compound, when fully cured it can be drilled, threaded, machined, tapped or filed. Contains a steel alloy that does not rust.

WORKS BEST ON: All metals, steel, stainless steel, aluminum, brass, iron, pewter.. Does not bond to polyethylene or polypropylene plastics. **DO NOT USE ON AREAS THAT WILL COME IN CONTACT WITH FOOD RELATED ITEMS.**
USE ON: Household, industrial, automotive and crafts that require a high-strength, high quality bond. Can be use to repair cracked housings, cover and cylinder heads, gas tank leaks, radiator leaks, torn keyways, stripped threads, worn pulleys, toys, broken furniture, tools, appliances. Fills holes and voids.

PRODUCT FEATURES:

Tensile Strength: 2,500 psi
Color: Black (dark gray)
Non-Flammable
Water Resistant
Working Time: 90 Minutes (2 Hours)
Can Be Handled in: 4 – 6 Hours
Full Bond: 16 – 24 Hours
Temperature Range: Constant: 200ºF (Temperatures below 60ºF (15ºC) slows the curing time)
Intermittent: 250ºF
Chemical Solvent Resistance*: gasoline, diesel and kerosene.
* **Epoxies are generally not recommended for long term exposure to chemicals and solvents,**
Storage: Store in a cool, dry environment.

SURFACE PREPARATION: Protect work area from accidental spills. Slightly roughen repair area. Clean surface by solvent-wiping to remove grease, oil, dirt or other contaminants.

REMOVAL METHODS: (test inconspicuous area of item to be sure chemicals do not harm surface)
Before epoxy is allowed to dry, remove excess immediately with damp cloth. Can also use mineral spirits or isopropyl alcohol.
After cure:
Metal/Ceramic/Glass: Heat in excess of 350ºF, this will weaken the bond. Solvents that can be used: isopropyl alcohol, acetone, methylene chloride or other solvent. For thick applications, drill holes to weaken the repair, then chisel from surface.
Fabric: Before epoxy cures, immediately flush fabric with warm water or wipe with a damp cloth. Once epoxy is cured, it is not possible to remove it from the fabric.
Wood: Sand the cured material from the wood.

HELPFUL HINTS: Heat is generated while the epoxy mixture cures; the more epoxy and hardener that is mixed together, the more heat that is generated causing the epoxy mixture to cure faster. Only mix the amount of epoxy and hardener together that can be used within the working time.

Equal portions of the hardener and resin must be thoroughly mixed together in order for this product to cure properly. The most common problem with a two-part epoxy product is not mixing it thoroughly; it will not cure and will remain tacky. It is recommended that these epoxies be mixed on a clean surface (such as a paper cup, in the inside of the blister it is packaged on or etc.); do not mix it directly on the surface to be repaired. Once the product is thoroughly mixed, it can be applied to the repair area(s). *Please note, during the mixing process, be sure to scrape the sides and bottom into the mixture so that you are mixing all of the epoxy resin and hardener together*.

Removable tape is good for putting on an area that you don't want any adhesive/epoxy to get on. Before the epoxy cures, remove the tape. Plastic Steel/Steel Weld will not bond to a greasy surface; you can use vaseline or oil to coat areas you do not want the epoxy to adhere to.

See MSDS for more complete information, safe handling instructions and first aid.

Non-Regulated

Part Number(s): 45209, 52345