



## Aluminum Putty (F)

**Description:** Aluminum-filled epoxy putty for dependable nonrusting repairs to aluminum castings, machinery, and equipment widely used in HVAC applications

**Intended Use:** Industrial Use: Patch aluminum castings; make jigs, dies, and holding fixtures

**Features:** **Can be machined, drilled, or tapped using conventional metalworking tools**  
**Bonds to aluminum, concrete, and many other metals**  
**Fills voids or pores in castings**

**Limitations:** Not recommended for long-term exposure to concentrated acids and organic solvents

**Typical Physical Properties:** Technical data should be considered representative or typical only and should not be used for specification purposes.

### Cured 7 Days @ 75°F (24°C)

Adhesive Tensile Lap Shear (GBS)  
Coeff. of Thermal Expansion x 10-6  
Compressive Strength  
Cured Shrinkage  
Dielectric Constant  
Dielectric Strength  
Hardness  
Modulus of Elasticity  
Solids by Volume  
Temperature Resistance  
Thermal Conductivity (x10-3)

### Typical Values

2,600 psi (17.9 Mpa)  
29 in/in.°F (52 cm/cm.°C)  
8,420 psi (58.3 Mpa)  
0.0008 in/in (0.0008 cm/cm)  
21.4  
100 volts/mil (3.94 Kv/mm)  
85 Shore D  
8.0x10<sup>5</sup> psi (5.5 GPa)  
100  
Wet: 120°F (49°C); Dry: 250°F (121°C)  
1.73 cal/sec.cm.°C

### Standard Tests

Compressive Strength ASTM D 695  
Cured Hardness Shore D ASTM D 2240  
Dielectric Constant ASTM D 150  
Modulus of Elasticity ASTM D 638  
Cure Shrinkage ASTM D 2566  
Adhesive Tensile Shear ASTM D 1002  
Dielectric Strength, volts/mil ASTM D 149  
Coef. of Thermal Expansion ASTM D 696  
Flexural Strength ASTM D 790  
Thermal Conductivity ASTM C 177

### Uncured Properties @ 72°F (23°C)

Color  
Coverage (1/4" / 6.35mm)  
Flexural Strength  
Functional Cure  
Mix Ratio by Volume  
Mix Ratio by Weight  
Mixed Viscosity  
Pot Life @75F (24C)  
Recoat time  
Specific Gravity  
Specific Volume

Aluminum  
70 in<sup>2</sup>/lb (996 cm<sup>2</sup>/Kg)  
6,760 psi (46.6 Mpa)  
16 hours  
4:1  
9:1  
Putty  
60 min  
2-4 hrs.  
13.2lb/Gal (1.58 g/cm<sup>3</sup>)  
17.5 in<sup>3</sup>/lb (0.632 cm<sup>3</sup>/g)

**Surface Preparation:**

1. Thoroughly clean the surface with Devcon® Cleaner Blend 300 to remove all oil, grease and dirt.
2. Grit blast surface area with 8-40 mesh grit, or grind with a coarse wheel or abrasive disc pad, to create increased surface area for better adhesion (Caution: An abrasive disc pad can only be used provided white metal is revealed). Desired profile is 3-5mil, including defined edges (do not "feather-edge" epoxy).

Note: For metals exposed to sea water or other salt solution, grit-blast and high-pressure-water-blast the area, then leave overnight to allow any salts in the metal to "sweat" to the surface. Repeat blasting to "sweat out" all soluble salts. Perform chloride contamination test to determine soluble salt content (should be no more than 40ppm).

3. Clean surface again with Devcon® Cleaner Blend 300 to remove all traces of oil, grease, dust or other foreign substances from the grit blasting.
4. Repair surface as soon as possible to eliminate any changes or surface contaminants.

**WORKING CONDITIONS:** Ideal application temperature is 55°F to 90°F (13C to 32C) . In cold working conditions, directly heat repair area to 100 to 110°F (38 to 43C) prior to applying epoxy and maintain at this temperature during product cure to dry off any moisture, contamination or solvents, as well as to achieve maximum performance properties.

**Mixing Instructions:** **It is strongly recommended that full units be mixed, as ratios are pre-measured.**

1. Add hardener to resin.
2. Mix thoroughly with screwdriver or similar tool (continuously scrape material away from sides and bottom of container) until a uniform, streak-free consistency is obtained.

**INTERMEDIATE SIZES:** (1, 2 & 3 lb / 0.5, 0.9, & 1.4 Kg) containers. Place resin and hardener on a flat, disposable surface such as

cardboard, plywood or plastic sheet. Use a trowel or wide-blade tool to mix the material as in Step 2 above.

**LARGE SIZES:** (25, 30 & 50 lb / 11.4, 13.6, & 22.7 Kg) buckets: Use a T-shaped mixing paddle or a propeller-type Jiffy Mixer Model ES on an electric drill. Thoroughly fold putty by vigorously moving paddle/propeller up and down until a homogenous mix of resin and hardener is attained.

**Application Instructions:**

Spread mixed material on repair area and work firmly into substrate to ensure maximum surface contact. Aluminum Putty (F) will fully cure in 16 hours, at which time it can be machined, drilled, or painted.

**FOR BRIDGING LARGE GAPS OR HOLES**

Place fiberglass sheet, expanded metal, or mechanical fasteners between repair area and Aluminum Putty (F) prior to application.

**FOR VERTICAL SURFACE APPLICATIONS**

Aluminum Putty (F) can be troweled up to 1/4" thick without sagging.

**FOR MAXIMUM PHYSICAL PROPERTIES**

Cure at room temperature for 2.5 hours, then heat cure for 4 hours @ 200°F (93°C).

**FOR ± 70°F (21°C) APPLICATIONS**

Applying epoxy at temperatures below 70°F lengthens functional cure and pot life times. Conversely, applying above 70°F (21°C) shortens functional cure and pot life.

**MACHINING:** Allow material to cure for at least four hours before machining.

- Lathe speed: 150 ft/min (46 m/min)

- Cut: Dry

- Tools: Carbide Top Rake 6° (+/-2°) – Side/Front 8°F (+/-2°) 14°C (+/-1), -13°C (+/- 1)

- 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 400-650 grit emery paper wet. Material should polish to a 25-50 micro inch.

**Storage:**

Shelf life 3 yrs from manufacture. See package label. Store at room temperature, 70 °F (21°C).

**Compliances:**

None

**Chemical**

**Resistance:**

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

1,1,1-Trichloroethane	Very good
Ammonia	Very good
Cutting Oil	Very good
Gasoline (Unleaded)	Very good
Hydrochloric 10%	Very good
Kerosene	Very good
Methanol	Fair
Methy Ethy Ketone	Poor

Methylene Chloride	Poor
Phosphoric 10%	Very good
Sodium Chloride Brine	Very good
Sodium Hydroxide 10%	Fair
Sulfuric 10%	Very good
Sulfuric 50%	Poor
Trisodium Phosphate	Very good
Xylene	Fair

**Precautions:**

**FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate Safety Data Sheet prior to using this product.

**Warranty:**

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

**Order Information:**

**10610 1 lb. (0.45 Kg) kit**  
**10620 3 lb. (1.36 Kg)**

**Contacts:**

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