



# TECHNICAL DATA SHEET

## ALUMBOND-ALUMINUM PUTTY

**PRODUCT:** H-400 1 lb. Repair Kit Stock Number 00400  
H-450 8oz. Repair Kit Stock Number 00450

**DESCRIPTION:** A two-component epoxy formulation highly filled with carefully selected pure aluminum particles, modified curing agents, and special high quality additives to provide maximum strength, durability, and ease of application.

**APPLICATIONS:** ALUMBOND is especially formulated for repairing HVAC pipes, tanks, valves, pumps, castings, water jackets, radiators, etc., where non-rusting, non-magnetic aluminum finish is desired.

<b>PHYSICAL PROPERTIES:</b>	
Color	Grey
Pot Life 1 lb. @ 24°C (75°F)	45 minutes
Viscosity	Non-sagging Paste
Mixed Viscosity	330,000 cps
Cure Shrinkage	0.0005 in/in
Temperature Resistance	250°F (121°C)
Hardness (Shore, ASTM D 1706)	83D
Cured Density	17.5 cu. in. per lb.
Coefficient of Thermal Expansion	$40 \times 10^{-6}$ cm/cm/°C
Compression Strength (ASTM D 695)	8,600 psi (59 M Pa)
Tensile Strength (ASTM D 638)	3,500 psi (24 M Pa)

<b>CHEMICAL RESISTANCE:</b>	
Hydrochloric Acid 10%	Very Good
Hydrochloric Acid 50%	Good
Sulfuric Acid 10%	Very Good
Sulfuric Acid 50%	Good
Water	Very Good
Ammonia	Very Good
Sodium Hydroxide 10%	Very Good
Gasoline, Oil, Kerosene	Very Good
Mineral Spirits	Very Good
Toluene	Good
Methanol	Fair
MEK	Fair
Propylene Glycol	Very Good



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**DIRECTIONS:** Surfaces must be clean, dry, and preferably roughened for maximum adhesion.

Add all of the hardener to all of the resin in the resin container. For smaller portions, dole out 1 part hardener to 5 parts resin by volume (1 to 9 parts by weight).

**For the H-450, squeeze out equal volumes of resin and hardener.**

Mix thoroughly for 6 minutes, making certain that all of the hardener comes in contact with all of the resin. While mixing be sure to scrape the sides and bottom of the container.

Apply the mixed compound with putty knife, spatula, or similar tool. The tool may be moistened with water to provide a smooth finish to the HY-POXY.

**COVERAGE:** 1lb. covers approximately 140 square inches at 1/8" thickness.

**CURING TIME:** At 75°F (24°C) a 1/2" (12.5mm) layer of HY-POXY ALUMBOND putty will be hard in approximately 45 minutes. FULL cure times are as follows:

<u>TEMPERATURE</u>	<u>WORKING TIME</u>	<u>FULL CURE TIME</u>
60°F (16°C)	90 Minutes	32 Hours
75°F (60°C)	45 Minutes	16 Hours
90°F (32°C)	25 Minutes	8 Hours

**HY-POXY ALUMBOND will not cure properly below 40°F (4°C).**

**NON-WARRANTY:** We can accept no responsibility or liability for lack of results because the storage, handling, and application of the compound is beyond our control.

ALUMBOND H-400 & H-450 TDS