



TECHNICAL DATA SHEET

STEELFAST PUTTY

PRODUCT: H-155 6.5 oz (184 grams) Rapid Steel Repair Kit
H-7 2.25 oz (64 grams) Rapid Steel Repair Kit

DESCRIPTION: A two-component epoxy formula highly concentrated with carefully selected steel particles, modified curing agents, and special high quality additives to provide maximum strength, durability and ease of application.

APPLICATIONS: STEELFAST is specially formulated for very fast emergency repairs. This product is not recommended for constant immersion or exposure to water, but for such repairs the STEELFAST can be used to overcome the emergency and then be covered with HY-POXY® STEELBOND®. STEELFAST® is recommended for repairs at low temperatures. For other types of applications, consult your distributor, salesman or write directly to our technical department at PO Box 6988 Hilton Head, SC 29938 U.S.A.

PHYSICAL PROPERTIES:	
Color	Dark Grey
Pot Life 1 lb. @ 24°C (75°F)	5 minutes
Viscosity	Trowelable Paste
Mixed Viscosity	330,000 cps
Cure Shrinkage	0.0007 in/in
Temperature Resistance	205°F (96°C)
Hardness (Shore, ASTM D 1706)	85D
Cured Density	13.2 cu. In. per lb.
Coefficient of Thermal Expansion	50×10^{-6} cm/cm/°C
Compression Strength (ASTM D 695)	7,300 psi (50 MPa)
Tensile Strength (ASTM D 638)	3,800 psi (26 MPa)
Adhesive Tensile Shear (ASTM D 1002)	2,615 psi

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



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DIRECTIONS: Surface area to be repaired must be clean, dry and preferably roughened for maximum adhesion. The working time for STEELFAST is approximately 5 minutes so all preparations must be completed prior to mixing.

Combine equal volumes of hardener and resin. Volume ratio is 1 part hardener to 1 part resin.

Mix thoroughly making certain that all of the hardener comes in contact with all of the resin while scraping 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. Since HY-POXY will not adhere to polyethylene, a piece of that plastic can be placed on the uncured HY-POXY and removed after the material cures to leave a very smooth finish.

CURING TIME: At 75°F (24°C) a ½" (12.5mm) layer of HY-POXY STEELFAST putty will be hard in approximately 4 hours. FULL cure times are as follows:

<u>TEMPERATURE</u>	<u>WORKING TIME</u>	<u>FULL CURE TIME</u>
40°F (4°C)	12 Minutes	5 Hours
60°F (16°C)	7 Minutes	2 Hours
75°F (60°C)	5 Minutes	1 Hours
90°F (32°C)	3 Minutes	1/2 Hours

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

NON-WARRANTY: We cannot accept any responsibility or liability for lack of results because the storage, handling, and application of the compound are beyond our control.

STEELFAST H-155 TDS