



TECHNICAL DATA SHEET

ALUMFAST H-455 & H-55 PUTTY

PRODUCT: H-455 6.5oz. Rapid Aluminum Repair Kit
H-55 2oz. Rapid Aluminum Repair Kit

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

APPLICATIONS: ALUMFAST is specially formulated for HVAC copper pipes, HVAC condenser coils, tanks, valves, pumps, castings, water jackets, radiators, etc., where a fast and strong, non-rusting aluminum repair is desired and where there is not constant exposure to water. After it cures, ALUMFAST can be drilled, machined and/or painted.

| PHYSICAL PROPERTIES: | |
|--|------------------------------|
| Color | Grey |
| Pot Life 1 lb. @ 24°C (75°F) | 4 minutes |
| Viscosity | Non-sagging Paste |
| Mixed Viscosity | 330,000 cps |
| Cure Shrinkage | 0.0007 in/in |
| Temperature Resistance | 205°F (96°C) |
| Hardness (Shore, ASTM D 1706) | 83D |
| Cured Density | 17.5 cu. In. per lb. |
| Coefficient of Thermal Expansion | 50×10^{-6} cm/cm/°C |
| Compression Strength (ASTM D 695) | 6,600 psi (45 M Pa) |
| Tensile Strength (ASTM D 638) | 3,600 psi (25 M Pa) |
| Maximum Line Pressure (after 5 hours application time) | 650 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: Surfaces must be clean, dry, and preferably roughened for maximum adhesion. The working time is only four minutes so all preparations must be completed prior to mixing.

Carefully dispense equal amounts of hardener and resin onto a clean disposable surface.

Mix thoroughly without interruption for 1-2 minutes, making certain that all of the hardener comes in contact with all of the resin.

Apply the mixed compound with a putty knife, spatula, or similar tool. The tool may be moistened with water to provide a smoother finish. Since ALUMFAST will not adhere to polyethylene, a piece of that plastic can be placed on the uncured ALUMFAST 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 ALUMFAST 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> |
|--------------------|---------------------|-----------------------|
| 40°F (4°C) | 12 Minutes | 5 Hours |
| 60°F (16°C) | 7 Minutes | 2 Hours |
| 75°F (60°C) | 4 Minutes | 1 Hours |
| 90°F (32°C) | 3 Minutes | 1/2 Hours |

HY-POXY ALUMFAST 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.

H-455 & H-55 ALUMFAST TDS