

ALUMINIUM LIQUID (F-2)

PRODUCT INFORMATION

	<u>Stock No.</u> 10711	<u>Package Size</u> 500g
Description	Aluminium filled epoxy liquid ideal for making moulds, patterns and fixings.	
Recommended Applications	<ul style="list-style-type: none"> • Used for making fine detailed duplicating masters • Mould making for casting lightweight moulds • Pattern making • Making panoraphs • Repairs to punch and die assemblies 	

PRODUCT DATA

Typical Physical Properties	Colour	Aluminium
	Mix Ratio by Volume	5:1
	Mix Ratio by Weight	9:1
	% Solids by Volume	100
	Pot life at 25°C/ mins	75
	Specific Volume CC/Kg	631
	Cured Shrinkage cm/cm	0.0009
	Specific Gravity	1.58
	Temperature resistance / °C	Wet 65°C Dry 175°C
	Coverage	1262cm ² /Kg @ 5mm
	Cured Hardness / Shore D	85 D
	Dielectric Strength KV/mm	4
	Adhesive Tensile Shear / MPa	18.6
	Compressive Strength MPa	68
	Coefficient of Thermal Expansion x10 ⁻⁶ cm/cm/°C	90
	Thickness per Coat / mm	As Required
	Functional Cure Time /Hours	16
Recoat Time /Hours	4	
Mixed Viscosity /cps (where applicable)	15-25000	

Chemical Resistance	7 days room temperature cure (30 days) - Testing carried out 30 days immersion at 21°C			
	Ammonia	Fair	Methylene Chloride	Poor
	Cutting Oil	Very Good	Sodium Hypochlorite 5% (Bleach)	Fair
	Isopropyl Alcohol	Poor	Sodium Hydroxide 10%	Fair
	Gasoline (Unleaded)	Very Good	Sulphuric Acid 10%	Very Good
	Hydrochloric Acid 10%	Very Good	Xylene	Fair
	Methyl ethyl Ketone (MEK)	Poor		
		Excellent = +/- 1% weight change Very Good = +/- 1-10% weight change Fair = +/- 10-20% weight change Poor = > 20% weight change		

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APPLICATION INFORMATION

Cure	A 12.7mm thick section of Devcon Epoxy will harden @ 24°C in 4 hours. The material will be fully cured in 16 hours.
Surface Preparation	<p>Proper surface preparation is essential to a successful application. The following procedures should be considered:</p> <ul style="list-style-type: none"> • All surfaces must be dry, clean and rough. • If surface is oily or greasy, use Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 to degrease the surface. • Remove all paint, rust and grime from the surface by abrasive blasting or other mechanical techniques. • Aluminium repairs: Oxidation of aluminium surfaces will reduce the adhesion of an epoxy to a surface. This film must be removed before repairing the surface, by mechanical means such as grit-blasting or chemical means. • Provide a "profile" on the metal surface by roughening the surface. This should be done ideally by grit blasting (8-40 mesh grit), or by grinding with a coarse wheel or abrasive disc pad. An abrasive disc may be used provided white metal is revealed. Do not 'feather edge' epoxy materials. Epoxy material must be 'locked in' by defined edges and a good 3 - 5 mil profile. • Metal that has been handling sea water or other salt solutions should be grit blasted and high pressure water blasted and left overnight to allow any salts in the metal to 'sweat' to the surface. Repeat blasting may be required to 'sweat out' all the soluble salts. A test for chloride contamination should be performed prior to any epoxy application. The maximum soluble salts left on the substrate should be no more than 40 p.p.m. (parts per million). • Chemical cleaning with Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 should follow all abrasive preparation. This will help to remove all traces of sandblasting, grit, oil, grease, dust or other foreign substances. • Under cold working conditions, heating the repair area to 38°C - 43° C immediately before applying any of Devcon's Metal-filled Epoxies is recommended. This procedure dries off any moisture, contamination or solvents and assists the epoxy in achieving maximum adhesion to the substrate. • Always try to make the repair as soon as possible after cleaning the substrate, to avoid oxidation or flash rusting. If this is not practical, a general application of FL-10 Primer will keep metal surfaces from flash rusting.
Mixing	Add hardener to resin. Mix thoroughly with spatula or similar tool until a uniform, streak-free consistency is obtained, should take about 4 minutes. Be sure to mix material from bottom and sides of container.
Application	Brush thin coat on prepared surface then pour material in a fine stream to avoid bubbles. Do not pour liquid epoxy in sections thicker than 25.4mm at a time. Allow applied epoxy to cool at room temperature before pouring additional thickness.
Shelf life & Storage	A shelf life of 3 years from date of manufacture can be expected when stored at room temperature (22°C) in their original containers
Precaution	For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.
Warranty	ITW Devcon will replace any material found to be defective. As the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.
Disclaimer	<p>All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.</p> <p>For product information visit www.devconeurope.com alternatively for technical assistance please call +44 (0) 870 458 7388 (UK) or +49 431 718830 (Germany).</p>