



## Directions for Use:

Proper surface preparation is essential to the success of any epoxy application. In all cases the surface should be clean, dry, free from oils, and rough.

1. Remove all oils, dirt and grease by means of a strong cleaner/degreaser (Devcon Cleaner is suitable for this process).
2. Roughen the surface by grit blasting (8-40 mesh grit) or grinding. A 75-125 micron profile is desired for most applications.
3. All abrasive preparation should be followed by another cleaning to remove any remnants from that process.
4. Ideal application temperature is 13°C-32°C. Under cold conditions, heating the repair area to 38°C - 43°C is recommended.

## Mix Ratio – Resin to hardener: Weight 9:1, Volume 2.5:1

5. Add hardener to resin and mix thoroughly with a putty knife until a uniform, streak-free consistency is obtained (about 4 minutes).
6. Spread mixed material over the repair area and work firmly into the substrate to ensure maximum surface contact.
7. To bridge large gaps or holes, use fibreglass tape, expanded metal or mechanical fasteners.

## Cure:

- Working time is 45 minutes @ 24°C
- Functional (75%) cure is achieved in 16 hour @ 24°C
- For maximum physical properties, heat cure for 4 hours @ 100°C after curing at room temperature for 3-4 hours

## Machining

- Allow material to cure for at least 4 hour before machining
- Lathe speed 48 m/minute
- Cut: dry
- Tools: Carbide top rake 6° (+/- 2°) – Side/front 8° (+/- 2°)
- Feed rate (rough): Travel speed 0.50 mm Rough cut 0.50 mm – 1.5 mm/rev
- Feed rate (finishing): Travel speed 0.25 mm Finish cut 0.25 mm/rev
- Polishing: use 400 to 650 emery paper wet. Material should polish to a 25-50 micron finish

## Precaution

Use in accordance with Material Safety Data Sheet.

Warranty: Devcon 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.

**Warning: For industrial use only.**

## ORDERING INFORMATION

| Stock No. | Unit Size |
|-----------|-----------|
| 10110     | 0.5 kg    |
| 10120     | 1.5 kg    |

**MANUFACTURED BY**  
ITW Polymers & Fluids  
100 Hassall Street  
Wetherill Park NSW 2164

**QUEENSLAND DISTRIBUTOR**  
*INTERNATIONAL TRADERS Pty Ltd*  
6/286 Evans Rd  
Salisbury - BRISBANE - QLD 4107  
Phone (07) 3272 9051 Fax (07) 3272 9744