

# Steel Epoxy-Stick



**fast cure**  
**steel-filled**

It is particularly suited for the fast and high-strength repair and bonding of metal parts and for the patching and sealing of cracks, holes, and leaks in machine parts, tanks and pipelines, containers, pumps and housings, balcony railings, banisters, and torn-out threads.

The Steel Epoxy-Stick can be used in machine and system construction, in tank construction and apparatus engineering, in the foods, cosmetic and pharmaceutical industries and in many other applications.

## Technical Data

Composition	Epoxy resin steel-filled
Composition	pasty
Colour after curing	dark-grey
Mixing ratio by volume resin/hardener	1:1
Density of the mixture	2,0 g/cm³
Gap bridging max.	15 mm
Processing temperatur	+10 to +35 °C
Curing temperature	+6 to +40 °C
Polt life for 25gr preparation and +20°C (+68°F)	4 min.
Handling strength (35%) after	10 min.
Mechanical loads (50% strength) after	60 min.
Final strength (100%) after	24 h
Pressure (DIN 53281-83)	80 N/mm²
Medium shear strength after 7 days at +20°C (+65°F) DIN 532832 at	Steel sandblasted: 4,1 N/mm²
Shore hardness D	75
Thermal conductivity (ASTM D 257)	0,6 W/m.K
Linear shrinkage	<1 %
Electrical resistance (ASTM D 149)	5•10¹¹ Ohm/cm
Dielectric strength (ASTM D 149)	3,0 kV/mm

Thermal expansion coefficient (ISO 11359)	30-40 x 10 <sup>-6</sup> K <sup>-1</sup>
Temperature resistance	-50 to +120 briefly +150 °C

## Surface pre-treatment

To ensure a perfect bond, the surfaces to be joined must be clean and dry.

## Processing

Epoxy-Sticks cover gaps of max. 15 mm per procedure. The pot life given is for a material quantity of 25 g at room temperature. If larger quantities are used, the curing time will be faster due to the typical reaction heat of epoxy resins (exothermic reaction). Similarly, higher ambient temperatures shorten the cure time (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time). Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

## Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, Epoxy-Sticks will keep for at least 18 months. Avoid direct sunlight.

## Safety and health

When using products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets must be observed.

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