

Introduction

SealXpert™ PS104 Bronze Repair Putty is a two component, ambient-temperature curing epoxy putty. It is a brass-filled putty suitable for bronze casting parts defect repairing and worn parts rebuilding, SealXpert™ PS104 Bronze Repair Putty is suitable for a wide application range, convenient-to-use, no sagging with high bond strength. It can be machined after cured.

Typical Applications

Used for repairing various bronze casting air holes and sand holes over 2mm, shrinkage and cracks. Can also be used for filling oversize, scratch or damaged repairing. Applicable to watercraft, machines, automobiles, mine etc. manufacturing and repairing.

Typical Properties of Uncured Materials

Component A (Resin)

Appearance	Brass colour paste
Basic material	Modified Epoxy Resin
Specific gravity (g/cm ³)	2.30

Component B (Hardener)

Appearance	Off-white paste
Basic material	Epoxymodified amine
Specific gravity (g/cm ³)	1.05

Typical Properties of Mixed Materials

Appearance	Brass colour paste
Weight ratio (A : B)	9:1
Volume ratio (A : B)	3:1
Pot life (min)	40
(100g@25°C)	

Min. curing time at room temperature	
50%loading	12 hours
100%loading	24 hours

Typical Performance of Cured Materials

Specific gravity	2.2 g/cm ³
Hardness (Shore D)	80
Shear Strength	18 MPa
Compressive Strength (ASTM D695)	95 MPa
Tensile Strength (ASTM D688-111)	30 MPa
Working Temperature	-50 – 170°C

Directions for Use:

Cleaning and Preparation: Prepare the repairing surface by grinding, filing or sand blasting. Remove oil and chemical (if any) from the surface.

Mixing: Mix component A (Resin) and Component B (Hardener) in accordance to the specified ratio and stir to ensure uniform mixture.

Dispensing: Dispense the repair putty onto the repairing surface with scrapper, compress and compact to eliminate gaps and air bubbles.

Cure: Allow curing in accordance to the minimum curing time at room temperature before operation. If faster curing is required, heat up the surface slightly to shorten curing time.

Note: Higher temperature and mixing more of each components together will shorter the pot life. On the contrary, lower temperature and mixing less of each components will length the pot life. In the case of temperature below 10°C, it is recommended to preheat the repairing surface. In the case high temperature, reduce the mixture of each component to shorten curing time.

General Information

Keep out of reach of children.

It is recommended to use at well ventilated place.

In case of contact with skin, wipe away, and rinse immediately with water. If contact with eyes, rinse immediately with water and visit a physician.

Please refer to the MSDS for more details

Package

Item No.: PS104, 227grams/ set

Component A (Resin): 204grams/ container

Component B (Hardener): 23grams/ container

Storage

Stored in a cool and dry location in unopened containers at 8 to 28°C.

The shelf life is 24 months.