



TECHNICAL DATA SHEET

ALUMBOND LIQUID-ALUMINUM LIQUID PUTTY

PRODUCT: H-410 1 lb. Repair Kit Stock Number 00410
H-411 3 lbs. Repair Kit Stock Number 00411

DESCRIPTION: A two-part room temperature curing epoxy compound filled with carefully selected pure aluminum particles, modified curing agents, and special high quality additives to provide outstanding adhesion, strength and durability. Provides a very smooth finish.

APPLICATIONS: ALUMBOND LIQUID is especially formulated for duplicate patterns, molds, or maintenance and repair applications requiring a pourable liquid, where a non-rusting, non-magnetic aluminum finish is desired.

PHYSICAL PROPERTIES:	
Color	Grey
Pot Life 1 lb. @ 24°C (75°F)	45 minutes
Viscosity	Pourable Liquid
Mixed Viscosity	330,000 cps
Cure Shrinkage	0.0005 in/in
Temperature Resistance	250°F (121°C)
Hardness (Shore, ASTM D 1706)	83D
Cured Density	17.5 cu. in. per lb.
Coefficient of Thermal Expansion	40×10^{-6} cm/cm/°C
Compression Strength (ASTM D 695)	8,600 psi (59 M Pa)
Tensile Strength (ASTM D 638)	3,500 psi (24 M Pa)

CHEMICAL RESISTANCE:	
Hydrochloric Acid 10%	Very Good
Hydrochloric Acid 50%	Good
Sulfuric Acid 10%	Very Good
Sulfuric Acid 50%	Good
Water	Very Good
Ammonia	Very Good
Sodium Hydroxide 10%	Very Good
Gasoline, Oil, Kerosene	Very Good
Mineral Spirits	Very Good
Toluene	Good
Methanol	Fair
MEK	Fair
Propylene Glycol	Very Good



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DIRECTIONS: Surfaces must be clean, dry, and preferably roughened for maximum adhesion.

Add all of the hardener to all of the resin in the resin jar. For smaller portions, dole out 5 parts resin to 1 part hardener by volume (9 to 1 parts by weight).

Mix thoroughly for 5 minutes, making certain that all of the hardener comes in contact with all of the resin. While mixing be sure to scrape the sides and bottom of the container.

Pour slowly allowing the material to flow outward. Do not pour back and forth as air entrapment results.

COVERAGE: 1lb./454gr. covers approximately 140 square inches/903 square centimeters at 1/8"/3mm thickness.

CURING TIME: At 75°F (24°C) a 1/2" (12.5mm) layer of HY-POXY ALUMBOND LIQUID 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>
60°F (16°C)	90 Minutes	32 Hours
75°F (60°C)	45 Minutes	16 Hours
90°F (32°C)	25 Minutes	8 Hours

HY-POXY ALUMBOND will not cure properly below 40°F (4°C).

NON-WARRANTY: We can accept no responsibility or liability for lack of results because the storage, handling, and application of the compound is beyond our control.

ALUMBOND LIQUID H-410 & H-411 TDS