



# TECHNICAL DATA SHEET

## H-450 & H-45 ALUMBOND ALUMINUM PUTTY

**PRODUCT:** H-450 6.5oz/184 gram Aluminum Repair Kit  
H-45 2oz/56.8 gram Aluminum Repair Kit

**DESCRIPTION:** A two-component epoxy formula highly concentrated with carefully selected pure aluminum particles, modified curing agents, and special high quality additives to provide maximum strength, durability, and ease of application.

**APPLICATIONS:** ALUMBOND is specially formulated for repairing HVAC copper pipes, HVAC condenser coils, tanks, valves, pumps, castings, water jackets, radiators, etc., where non-rusting, non-magnetic aluminum finish is desired.

<b>PHYSICAL PROPERTIES:</b>	
Color	Grey
Pot Life 1 lb. @ 24°C (75°F)	45 minutes
Viscosity	Non-sagging Paste
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 X 10 <sup>-6</sup> 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)
Maximum Line Pressure (after 5 hours application time)	650 psi

<b>CHEMICAL RESISTANCE:</b>	
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.

Dispense equal volumes of resin and hardener. Volume Ratio is 1:1.

Mix thoroughly for 6 minutes making certain that all of the hardener comes in contact with all of the resin.

Apply the mixed compound with a putty knife, spatula, or similar tool. The tool may be moistened with water to provide a smooth finish to the HY-POXY ALUMBOND.

**CURING TIME:** At 75°F (24°C) a ½" (12.5mm) layer of HY-POXY ALUMBOND putty 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 accept no responsibility or liability for lack of results because the storage, handling, and application of the compound are beyond our control.

ALUMBOND H-45 & H-450 TDS