



# ® D309 ALUMINIUM EPOXY PASTE

## PRODUCT DESCRIPTION

**D309 ALUMINIUM EPOXY PASTE** is a high performance, two pack solvent free epoxy resurfacing system ideal for use on metallic surfaces and is designed for repairs to worn or damaged metal components and equipment including:

- Worn shafts
- All aluminium parts
- Cracked engine blocks
- Cracked casings
- Damaged flanges
- Leaking tank seams

## BENEFITS

- Two components
- Good corrosion resistance
- Solvent free epoxy
- Easy machinable
- Ideal for metallic surfaces
- 3 to 1 mixing ratio
- Multi purpose
- Excellent mechanical strength

## SURFACE PREPARATION

The following surface preparation guidelines must be followed for optimum performance:

- All oil and grease removed using a suitable Delta Surface Preparation cleaner.
- Use a cleaner which does not leave a residue such as Methyl Ethyl Ketone.
- All loose material, rust and coatings must be removed using mechanical grinding or abrasive blasting.
- For abrasive blast cleaning use Swedish standard SA 2.5 with angled grit, minimum 75 micron profile.
- Ensure all blasted surfaces are de-greased using a suitable Delta Surface Preparation cleaner.
- All surfaces must be coated before any oxidation takes place.

**PLEASE NOTE:** For salt contaminated surfaces the area must be blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After 24 hours wash the surface of the substrate and re blast to Swedish standard SA2.5, angled grit minimum 75 micron profile.

## DIRECTIONS FOR USE

Delta D309 Aluminium Epoxy Paste is a two component system which must be mixed together prior to application.

- Measure 3 base and 1 activator on the mixing board provided.
- Mix the two components together until they are streak free.
- Apply the mixed material to the prepared surface using the applicator provided.
- Ensure that the mixed material is pressed into any holes or cracks
- Wipe away excess material and leave to cure.
- Once cured the material can be machined to the correct profile.

2 PART STRUCTURAL



**2 PART STRUCTURAL**

<b>TECHNICAL DATA</b>	<b>DRYING AND CURING TIMES (AT 20C)</b>	
	Usable life	25-30mins
	Initial set	60 mins
	Overcoating time	2hrs
	Full mechanical cure	3 days
	Volume solids	100%
	VOC	0
	<b>MIXING RATIOS</b>	
	Base 3 Activator 1 by volume	
	Base 5 Activator 1 by weight	
	<b>PHYSICAL PERFORMANCE</b>	
Tensile Shear Adhesion ASTM D1002	185kg/cm <sup>2</sup> (2500psi)	
Compressive strength ASTM D695	1075kg.cm <sup>2</sup> (15,500psi)	
Rockwell Hardness ASTM D785	100	

**HEALTH AND SAFETY** • Refer to the relevant Material Safety Data Sheet (MSDS).

**PACKAGING** • Available in a 500g kit. Other packs available on request.

**LEGAL NOTICE**

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Delta Adhesives Limited accepts no liability arising out of the use of this information or the product described herein.

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