

## D319 Aluminium Epoxy Stick

### PRODUCT DESCRIPTION

D319 is a hand kneadable, Speciality Epoxy Putty that mixes in one minute to provide fast, permanent repairs to most Aluminium surfaces. When applying D319 to surfaces it is necessary to work the material forcefully into the surface and apply pressure until adhesion begins to take effect. The lower the temperature the longer it takes to cure. It comes in a handy rod form with the curing agent encapsulated in the contrasting colour base material. Its putty-like consistency eliminates drips and runs, providing “no mess” application with no tools required to use. The mixed epoxy turns from a silvery colour to “Alloy” upon curing and will not yellow upon exposure to UV light. After final cure, D319 may be drilled, sawed, tapped, filed, sanded and painted. It allows patching in areas where welding is impossible.

### APPLICATIONS

After proper mixing, D319 moulds like clay and may be used to permanently patch dents, scratches, cuts, gouges and holes in items such as Housings and all types of repairs to mouldings and injection type shapes. B2002 is ideal for making emergency repairs to reforming, rebuilding and patching anything made out of aluminium such as .....HVAC parts, REFRIGERATION units, Air Conditioning units, machine parts, Alu-Roofing and Siding, Flagpoles, Shelving, Platforms, Walkways, Campers, Road Vehicles, Canopies, Gutters, Truck and Trailer Bodies, Wheels, Manifolds, Stripped Threads, Marine Hardware and Casings.

### USEFUL HINTS/NOTES

Mixing: Twist or cut off required amount. To mix, knead with fingers to a uniform colour. If mixing is difficult, warm D319 to room temperature or slightly above. Apply to the surface to be repaired (within 2 minutes of mixing). The mixed Epoxy does not exhibit high bond strength at this point, but appears to be merely lying on the surface. Force into any cracks or holes to be filled and strike off excess material, preferably with a tool wetted with clean water. Work the material forcefully into the surface and apply pressure until adhesion begins to take effect.

For a smooth appearance of the cured compound, hand rub with water or a damp cloth prior to hardening. Remove excess material before hardening begins. After 15-20 minutes the Epoxy will harden like metal and start to form a tenacious bond. After just 45 minutes D319 is completely cured and can be drilled, sawed, carved, sanded, stained or painted.

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.

### INSTRUCTIONS FOR USE

In order to achieve optimum adhesion, surface should be cleaned free of grease or dirt. Scuffing or sanding the surface prior to cleaning helps to ensure a good bond.

### TECHNICAL FEATURES

Resin	Light Silver
Epoxy resistance	Hydrocarbons, Ketones, esters, halo-carbons, alcohols, aqueous salt solutions, diute acids and bases
Electrical resistance	30,000 mega Ohms
Dielectric strength (steel)	300 Volts/mil
Shrinkage	<1%
Non volatile content	100%
Shelf life	24 months @ 24°C

### CURED PERFORMANCE

Initial cure	1 hour
Full cure time	24 hours
Lap shear strength (steel)	4.8 N/mm(2)
Shore D Hardness	70/80
Compressive strength	84N/mm(2) - 12,000 psi

### PROPERTIES

Opening time	5 mins
Max temp resistance	121°C CONTINUOUS 149°C INTERMITTENT

### STORAGE

Store in cool conditions, preferably away from direct sunlight or excessive heat. Shelf life at least 12 months @ 24°C.

### PRECAUTION

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product