



# TECHNICAL DATA SHEET

## ALUMFAST H-455 & H-55 PUTTY

**PRODUCT:** H-455 6.5oz. Rapid Aluminum Repair Kit  
H-55 2oz. Rapid 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:** H-455 is specially formulated for very fast, non-rusting, strong emergency aluminum repairs where putty is needed and where there is not constant exposure to water. It is ideal for repairing aluminum castings, pipes, valves, models, radiators, etc. For other types of applications, consult your distributor, salesman or write directly to our technical department at P.O. Box 6988 Hilton Head, SC 29938 U.S.A.

<b>PHYSICAL PROPERTIES:</b>	
Color	Grey
Pot Life 1 lb. @ 24°C (75°F)	4 minutes
Viscosity	Non-sagging Paste
Mixed Viscosity	330,000 cps
Cure Shrinkage	0.0007 in/in
Temperature Resistance	205°F (96°C)
Hardness (Shore, ASTM D 1706)	83D
Cured Density	17.5 cu. In. per lb.
Coefficient of Thermal Expansion	$50 \times 10^{-6}$ cm/cm/°C
Compression Strength (ASTM D 695)	6,600 psi (45 M Pa)
Tensile Strength (ASTM D 638)	3,600 psi (25 M Pa)

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



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**DIRECTIONS:** Surfaces must be clean, dry, and preferably roughened for maximum adhesion. The working time for the H-455 & H-55 is only four minutes so all preparations must be completed prior to mixing.

Squeeze equal amounts of hardener and resin.

Mix thoroughly without interruption for 2 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 ALUMFAST. Since ALUMFAST will not adhere to polyethylene, a piece of that plastic can be placed on the uncured ALUMFAST and removed after the material cures to leave a very smooth finish.

**CURING TIME:** At 75°F (24°C) a ½" (12.5mm) layer of HY-POXY ALUMFAST 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>
40°F (4°C)	12 Minutes	5 Hours
60°F (16°C)	7 Minutes	2 Hours
<b>75°F (60°C)</b>	<b>4 Minutes</b>	<b>1 Hours</b>
90°F (32°C)	3 Minutes	1/2 Hours

HY-POXY ALUMFAST 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 are beyond our control.

H-455 & H-55 ALUMFAST TDS