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Technical Data Sheet

Permatex® 4 min Multi Metal Epoxy Putty

PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex™ 4 min Multi Metal Epoxy Putty is two part, hand kneadable, putty type epoxy. Contrasting coloured materials are mixed together to form a uniform colour to indicate thorough mixing. Permatex Epoxy Putty can be drilled, sanded, threaded or filed and are resistant to fuels and solvents after full cure.

PRODUCT BENEFITS

Easy To Use:

- No heating required

Fast and Reliable:

- Holds in 5 minutes
- Useable in 30 minutes
- Good moisture resistance
- Withstands high temperatures

Safe To Use:

- Non-flammable

TYPICAL APPLICATIONS

- Cracked transmission cases
- Chipped heads
- Rear end castings
- Cracked blocks
- Cracked intake manifolds
- Damaged keyways
- Split stampings

DIRECTIONS FOR USE

1. Before starting, make sure your work area is protected from accidental spills. Surfaces must be clean, dry and free of grease and oil.
2. Roughen smooth surfaces to be repaired with sandpaper.
3. Cut off required amount of epoxy and knead with fingers to a uniform colour. This should take no longer than two minutes.
4. Apply to the surface to be repaired. Force into cracks or holes to be filled. Excess material can be removed, before it is cured, with a tool wetted with clean water.
5. On wet or damp surfaces, work material into area forcefully and hold in place until adhesion begins. Do not use hand to hold in place as heat is given off during cure.
6. After 5 to 10 minutes, the epoxy will harden.
7. After 1 hour, material can be drilled, sanded, tapped, threaded, filed or painted.

FOR CLEANUP

1. Cleanup must be completed before curing is complete. Use acetone or mineral spirits for cleanup.
2. Clean hands with Permatex® brand hand cleaners.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy and Amine Resins
Mix ratio (volume)	1:1
Appearance	Dark grey outside, black inside
Odour	Slight Amine
Specific Gravity	1.9
Flash Point, TCC	>260°C

CURING PROPERTIES

Permatex Epoxy Putty has a set up time of 4 to 6 minutes, fixture time of 10 to 15 minutes with a full cure in 16 hours.

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance	Typical Values
Continuous, °C Maximum	-50°C to 148°C
Intermittent, °C Maximum	+176°C

Chemical / Solvent Resistance

The product retains effective properties when in contact with water, oil, fuels and solvents.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
35202 & 35203	56g

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C unless otherwise labelled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOTE

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