HYPOXY STEEL LIQUID

FLOWABLE POLYMER LIQUID WITH STEEL FILLERS

PRODUCT: **H-110 1lbs (454gms.)**

A two-component Liquid Polymer formulation highly filled with steel fillers, modified curing agents, and special high quality additives to provide maximum strength, durability, and ease of application. Will easily pourable to reach intricate parts & difficult to reach and is easily machineble with standard metalworking tools and equipment.

SPECIAL FEATURES :

- **Low viscosity Steel filled compound, Easy to Brush.**
- **Low or almost Nil shrinkage**
- **Machinable to metallic finish**
- **Self flowing & settling - Does not Sag.**

APPLICATIONS:

Repair blow holes in castings.
Repair Surface Pin holes on Cast components.
Low viscosity Steel filled compound, Easily brushable, Self flowing & settling, Does not Drip or Sag.
Repair machine bed foundation bolts.
Filling Pitted Steel Structure.
Repairing hard-to-reach areas where a flowable epoxy is needed.
Ideal for building up metal surfaces.
Widely used for fast, inexpensive, but accurate drill jigs and placement fixtures.

PHYSICAL PROPERTIES

Colour	Dark Grey
Pot Life 1 lb. @ 24ºC (75°F)	45 minutes
Mixed Viscosity	350,000 cps
Cure Shrinkage	0.0005 in/in
Temp.Resistance	250°F (121ºC)
Hardness (Shore, ASTM D 1706)	85D
Cured Density	14.6 cu. in. per lb.
Coefficient of Thermal Expansion	75 X 10- 6 cm/cm/ºC
Compression Strength (ASTM D 695)	10,000 psi9 (69 M Pa)
Tensile Strength (ASTM D 638)	4,500 psi (31 M Pa)
Flexual Strength (ASTM D 790)	7,100 psi (49 M Pa)
Thermal Conductivity (ASTM C 177)	1.26 X 10-3 cal-cm/sec.cm2 ºC
Dielectric Strength (ASTM D 149)	35 volts/mil
Adhesive Tensile Shear (ASTM D1002)	2835 psi

CHEMICAL RESISTANCE

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

DIRECTIONS FOR USE :

Surfaces must be clean, dry, and preferably roughened for maximum adhesion. Add all of the hardener to all of the resin in the resin container.
For smaller portions, dole out 1 part hardener to 4 parts resin by volume (1 to 9 parts by weight).

Mix thoroughly, making certain that all of the hardener comes in contact with all of the resin.
Apply the mixed compound by pouring and spreading with brush.

CURING TIME: At 75°F (24°C) a ½" (12.5mm) layer of HY-POXY® STEELBOND LIQUID will be hard in appro 2 hours. Faster curing may be achieved by exposing the deposit to hot air blower.

FULL cure times are as follows:

TEMPERATURE	WORKING TIME	FULL CURE TIME
60°F (16°C)	90 Minutes	12 Hours
75°F (24°C)	45 Minutes	6 Hours
90°F (32°C)	25 Minutes	4 Hours

NON-WARRANTY: We can accept no responsibility or liability for lack of results because the storage, handling, and application of the compound is beyond our control.

CALL IN YOUR LOCAL AUTHORISED DEALER TO GET FULL ADVANTAGE OF PRODUCT TRAINING AND KNOW HOW TO MAKE MORE USE OF HY POXY PRODUCTS.

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