

TECHNICAL DATA SHEET

P323

V1-01/04/2024

METAL FILLED EPOXY

DESCRIPTION

A multi-purpose, metal filled, two component, high strength epoxy putty for repairing and rebuilding machinery and equipment where conventional methods such as welding cannot be performed. The epoxy putty is based on high performance polymers resulting in a durable and fully machinable finish.

PROPERTIES

- Easy to mix and apply.
- No shrinkage (100% solids)
- Can be applied to vertical surfaces.
- Gap filling putty
- Non-toxic when fully cured.
- High Mechanical Strength
- High Bond Strength
- Fully Machinable

COLOUR	: Metallic Grey
Nº. OF COMPONENTS	: 2
MIXING RATIO (WEIGHT)	: 1.5 : 1
CONSISTENCY	: Putty Paste
VOLUME SOLIDS	: 100%
MIXED DENSITY	: 2.77
PRACTICAL SPREAD RATES	: 1m ² /l
POT LIFE @ 25°C	: 45 min
TOUCH DRY @ 25°C	: 4 hrs
HARD DRY @ 25°C	: 24 hrs
FULL CURE	: 7 days
CLEANING EQUIPMENT	: P701 WSBC
SHELF LIFE	: 12 months
PACK SIZE	: 1kg

RECOMMENDED AREAS FOR USE

Used for shafts, hydraulic rams, pipes, tanks, flange faces, casings, keyways, bearing housings & levelling.

PHYSICAL PROPERTIES

Taber Abrasion 1 kg Load CS17 Wheel (Dry) 56mm ³ loss per 1000 cycles	Adhesion (Cleavage) Grit Blasted Steel (100µ Angular Profile) 25kg/mm ²
Hardness 89 Shore P (Typical)	Heat Distortion Temperature 58°C (Ambient Cure) 102°C (Post Cure)
Impact Strength 35 J/m (Reverse impact)	Shrinkage < 0.03%
Compressive Strength 900 kg/cm ² (Ambient Cure) 1020 kg/cm ² (Post Cure)	Flexural Strength 600 kg/cm ² (Ambient Cure) 900 kg/cm ² (Post Cure)
Dielectric Strength 3300 volts/mm	Volume Resistivity 5,3 x 10 ⁷ ohm/cm

CHEMICAL RESISTANCE

Resistant to most dilute acids & alkalis, petroleum products, aliphatic solvents & salt water.

SURFACE PREPARATION

All surfaces must be free of dust, oil and dirt. Smooth surfaces should be abraded to create a mechanical key.

MIXING

- Using a spatula or trowel, mix the epoxy and activator in the proportions given to a uniform colour.
 - Apply with a trowel or scraper and smooth with epoxy thinners.
 - Allow to cure overnight, 12 to 24 hrs before sanding or machining.

TOXICITY

Although P323 is safe, inert and harmless when cured, care should be taken to avoid skin contact or inhalation of the uncured components during mixing and application. Refer to the relevant 16-point Material Safety Data Sheet.

The technical data furnished is obtained from controlled laboratory tests under ideal application conditions. No guarantee of any performance characteristic is therefore given or implied and we do not hold ourselves responsible for any consequential damage of whatsoever nature that may arise from use of our products. In the event of a proven fault our liability will be limited to the replacement of the product only. It is the user's responsibility to confirm the currency of product data sheets.



HOW TO SPECIFY

Repair suitably prepared surfaces using P323 Metal Filled Epoxy in accordance with the manufacturer's instructions.

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