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Product Description Sheet

3465 Aluminium Putty

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PRODUCT DESCRIPTION

Loctite 3465 Aluminium Putty is a two-part epoxy system heavily reinforced with aluminium powder. Ideal for repairing non structural defects in aluminium castings, or for use where an aluminium finish is desired. Temperature range –30° to +90°C

Advantages:

- High compressive strength.
- Easy to mix and use.
- Rebuilds worn parts fast – reduces downtime.
- Forms a non-rusting aluminium-like finish.
- Excellent adhesion – forms a permanent bond.

TYPICAL APPLICATIONS

- Repairing aluminium castings
- Repairing worn aluminium parts
- Making models and jigs for holding odd shaped parts

PROPERTIES OF UNCURED MIXED MATERIAL

Mixture	Typical Value
Appearance	Aluminium Grey Paste
Mix Ratio (R:H) by Volume	4:1
by Weight	6.3:1
Coverage	1000 cm^2 @ 6mm thick per 1 kg. Kit 160 in^2 @ ¼ in. thick per 1 kg. kit

TYPICAL CURING PERFORMANCE

Curing Properties (@ 25°C unless noted)	Typical Value
Working Life, minutes	20
Cure Time, hours	6

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties	Typical Value
Compressive Strength, ASTM D695, N/mm^2	77.9
Shear Strength ASTM D1002, N/mm^2	10.4
.125mm gap, acid etched aluminium	
Tensile Strength, ASTMD 638, N/mm^2	27.6
Hardness ASTM D-2240, Shore D	87

DIRECTIONS FOR USE

- Thoroughly clean and abrade surfaces (grit blast if possible), finally clean with Loctite 7063.
- Mix 4 parts resin to 1 part hardener by volume (6.3 to 1 by weight) or transfer entire kit onto a clean and dry mixing surface and mix material vigorously until a uniform colour is obtained.
- Initially apply as a thin film, build up to desired thickness.
- At 25°C working time is 20 minutes and cure time is 6 hours.

TECHNICAL TIPS FOR WORKING WITH EPOXIES

Working time and cure time depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of the material mixed, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool resin/hardener components.

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).

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C 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. For further specific shelf life information, contact Loctite UK Technical Service.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

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