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3460 Steel Putty

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PRODUCT DESCRIPTION

Loctite 3460 Steel Putty is a steel reinforced, two-part epoxy repair putty, it has high compressive strength, and can be machined, drilled etc. Temperature range -30° to $+105^{\circ}\text{C}$.

Advantages:

- Won't sag or shrink.
- Rebuilds worn parts fast, reduces downtime.
- High steel content – cure to a metal-like finish.
- Excellent adhesion – forms a permanent bond

TYPICAL APPLICATIONS

- Repairing non structural defects in castings
- Making jigs/fixtures.
- Sealing tanks, vessels, and valves.
- Resurfacing worn air seals.
- Filling cavitated areas.

PROPERTIES OF UNCURED MIXED MATERIAL

Mixture	Typical Value
Appearance	Metallic Grey, Thixotropic paste
Mix Ratio (R:H) by Volume	2.5:1
by Weight	6.25:1
Coverage	612 cm ² @ 6 mm thick per 1 kg. kit 95 in ² @ 1/4" thick per 1 kg. kit

TYPICAL CURING PERFORMANCE

Curing Properties

(@ 25°C unless noted)

	Typical Value
Working Life, minutes	30
Cure Time, hours	6

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties	Typical Value
Compressive Strength, ASTM D695, N/mm ²	89.7
Shear Strength ASTM D1002, N/mm ²	11.7
.005" gap, acid etched aluminium	
Tensile Strength, ASTM D638, N/mm ²	44.8
Hardness ASTM D-2240, Shore D	85

DIRECTIONS FOR USE

- Thoroughly clean and abrade surfaces (grit blast if possible), finally clean with Loctite 7063. Mix 2.5 parts resin to 1 part hardener by volume (6.25 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 of material is 30 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 material, 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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PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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