

FASMETAL 10 HVAC REPAIR

PRODUCT INFORMATION

	<u>Stock No.</u> 19770	<u>Package Size</u> 184g
Description	An aluminum-filled, high strength, bonding, patching and sealing product.	
Recommended Applications	<ul style="list-style-type: none"> • Sealing leaks in pipes and tanks • Altering or repairing patterns, core boxes • Repairing large and small holes in aluminum or other castings. • Ideally suited for refrigeration repairs and wet environments 	

PRODUCT DATA

Typical Physical Properties	Colour	Aluminium	
	Mix Ratio by Volume	1 : 1	
	Mix Ratio by Weight	0.9 : 1	
	% Solids by Volume	100	
	Pot life at 25°C/ mins	45-60	
	Specific Volume CC/Kg	581	
	Cured Shrinkage cm/cm	0.0008	
	Density g/cm ³	1.72	
	Temperature resistance / °C	Wet 43°C Dry 121°C	
	Coverage	0.581m ² /Kg @ 1mm	
	Cured Hardness / Shore D	85	
	Dielectric Strength KV/mm	4	
	Adhesive Tensile Shear / MPa	17	
	Compressive Strength MPa	58	
	Coefficient of Thermal Expansion x10 ⁻⁶ cm/cm/°C	52	
	Thickness per Coat / mm	As Required	
	Functional Cure Time /Hours	16	
Recoat Time /Hours	10-12		
Mixed Viscosity /cps (where applicable)	Paste		
Chemical Resistance	7 days room temperature cure (30 days) - Testing carried out 30 days immersion at 24 °C		
	Ammonia	Fair	Methylene Chloride Poor
	Cutting Oil	Very Good	Sodium Hypochlorite 5% (Bleach) Fair
	Ethyl Alcohol	Poor	Sodium Hydroxide 10% Fair
	Gasoline (Unleaded)	Very Good	Sulphuric Acid 10% Fair
	Hydrochloric Acid 10%	Fair	Xylene Poor
	Methyl ethyl Ketone (MEK)	Poor	
	Epoxies are very good in water, saturated salt solutions, leaded gasoline, mineral spirits, ASTM#3 oil and propylene glycol. Epoxies are not recommended for long-term exposure to concentrated acids and organic solvents.		
	Excellent = +/- 1% weight change Very Good = +/- 1-10% weight change Fair = +/- 10-20% weight change Poor = > 20% weight change		

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APPLICATION INFORMATION

Cure	Devcon HVAC Fasmetal will harden at 24°C in 2 hours. Repaired item can be handled in 5 hours. Full bond strength is reached in 16 hours
Surface Preparation	<p>Proper surface preparation is essential to a successful application. The following procedures should be considered :</p> <ul style="list-style-type: none"> • All surfaces must be dry, clean and rough. • If surface is oily or greasy, use Devcon Fast Cleaner 2000 Spray /Cleaner Blend 300 to degrease the surface. • Remove all paint, rust and grime from the surface by abrasive blasting or other mechanical techniques. • Provide a "profile" on the metal surface by roughening the surface. This should be done ideally by grit blasting (8-40 mesh grit), or by grinding with a coarse wheel or abrasive disc pad. An abrasive disc may be used provided white metal is revealed. Do not 'feather edge' epoxy materials. Epoxy material must be 'locked in' by defined edges and a good 3 - 5 mil profile. • Metal that has been handling sea water or other salt solutions should be grit blasted and high pressure water blasted and left overnight to allow any salts in the metal to 'sweat' to the surface. Repeat blasting may be required to 'sweat out' all the soluble salts. A test for chloride contamination should be performed prior to any epoxy application. The maximum soluble salts left on the substrate should be no more than 40 p.p.m. (parts per million). • Chemical cleaning with Devcon Fast Cleaner 2000 Spray /Cleaner Blend 300 should follow all abrasive preparation. This will help to remove all traces of sandblasting, grit, oil, grease, dust or other foreign substances. • Under cold working conditions, heating the repair area to 38°C - 43° C immediately before applying any of Devcon's Metal-filled Epoxies is recommended. This procedure dries off any moisture, contamination or solvents and assists the epoxy in achieving maximum adhesion to the substrate. • All prepared surfaces should be repaired as soon as possible, to eliminate any changes or surface contaminants.
Mixing	Remove caps and pierce ends to remove nozzle barriers entirely. Squeeze out equal lengths of resin and hardener onto a clean, disposable surface. Be sure to squeeze tubes from bottom with equal pressure to ensure that bead diameter of material is uniform. Proper homogenous mixing of the two epoxy components of resin and hardener are essential for the curing and development of stated strengths. Always mix the two components with clean tools, preferably of a disposable design.
Application	Spread mixed product over prepared surface with a putty knife or similar tool. Press material firmly into all cracks and voids to ensure maximum surface contact and avoid trapping air. Apply a minimum of 1.6mm thickness. Do not feather edge.
Shelf life & Storage	Devcon HVAC Fasmetal should be stored in a cool, dry place when not used for a long period of time. A shelf life of 3 years from date of manufacture can be expected when stored at room temperature 22°C in their original containers.
Precaution	For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.
Warranty	Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.
Disclaimer	<p>All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.</p> <p>For product information visit www.devconeurope.com alternatively for technical assistance please call +44 (0) 870 458 7388 (UK) or +49 431 718830 (Germany)</p>

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