



Technical Data Sheet / S-520 Plastic Steel Epoxy

✧ Features:

- 100% solid, no solvents
- Non-shrinking
- Rapid strength development
- Good resistance against solvents and common automotive oils

✧ Typical applications

- Suitable for bonding metal, wood, plastic, china, tools. and glassware.
- Not suitable for bonding of polyethylene, polypropylene, PTFE and other flexible materials.

✧ Physical Properties

Cured 7 days @ 24 °C

Mixed Viscosity	-	Putty	Visually
Mixed Color	-	Dark grey	Visually
Working Time	minutes	20	Gelling
Functional Cure Time	hours	2	-
Full Cure Time	hours	16	-
Tensile Strength	MPa	17.2	ASTM D638
Shelf Life	Month	12	From delivery date

*Technical data should be considered representative or typical only and should not be used for specification purposes.

✧ Application

- Surface preparation
 1. Remove dust, mud, rust, tar or paints from the surface. To maximize adhesion, roughen all surfaces by grinder or wire brush.
 2. Surfaces should be solvent-wiped, free of heavy deposits of grease, oil, dirt or the contaminants, or cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. Don't use the thinners for painting or solvent that contains the nonvolatile.
- Mixing
 1. Open the cap and take same volume of resin and hardener.
 2. Mix well for about 1 minute with the attached spatula or putty knife or disposable chopsticks.
- Application instruction
 1. Apply to surface to be repaired.
 2. Force into any cracks or holes to be filled and strike off excess material. When applying to a damp, wet, or slowly leading area, work the material forcefully into the area and apply pressure until adhesion begins to take effect.
 3. Remove excess material before hardening begins.
 4. For a smooth appearance of the cured compound, hand-rub with water or a damp cloth prior to hardening.

- **Cure**
 1. The products can be applied when temperature is between 15°C and 30°C
 2. When temperatures are below 20°C, cure pot life will be longer, and above room temperature, cure and pot life will be shorter. When temperature is below 15°C, heat the surface to be repaired at 30-40°C with an infrared lamp or heating equipment.
 3. The actual cure time of this product is determined by the size of the mass and the temperature.

✧ **Storage**

Store in cool and dry place avoid direct sunshine.

✧ **Note**

- Please refer to the appropriate SDS prior to using this product.
- Handle this product with a pair of gloves.
- If the ingredients contact with the skin directly, immediately wash off with soap and water.
- All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW P&F East Asia makes no representations or warranties of any kind concerning this data. Due to variance of storage, handling and application of these materials, ITW P&F East Asia cannot accept liability of any malfunction after cure

✧ **Package**

20g / set

