



WINKEL PRO W-B PLASTIC STEEL EPOXY LIQUID

TECHNICAL DATA

Product Name: Winkel Pro W-B Plastic Steel Epoxy Liquid
Product Code: 20053
Product Description: Steel repair epoxy liquid cures at room temperature and is designed for filling, rebuilding and bonding steel or metal surfaces.
This liquid type system can cast over models for accurate detailed reproduction.

Features:

- 1.Low viscosity, self-leveling liquid
- 2.Fix to stainless steel, steel and many other metals, as well as concrete.
- 3.Machine casting to metallic finish.
- 4.100% solids.
- 5.Non-rusting repairs.
- 6.Resistant to chemicals and most acids, bases, solvents and alkalis.

Product Data:

The color of Part A (Resin): Steel gray
The color of Part B (Hardener): Amber
The mixed color: Steel gray, nearly steel color
Ratio: 5.6:1 (by volume), 94:6 (by weight)

Storage condition & Shelf-Life: 24 months from date of production if stored properly in original unopened, sealed and undamaged packaging in cool and dry conditions at temperatures between +5°C and +25°C. Protect from direct sunlight.

Technical Data:

| TYPICAL PHYSICAL PROPERTISE | RESULTS | TEST METHOD |
|-------------------------------|--|--|
| Uncured | | |
| % Solids by Volume | 100 | - |
| Mixed Viscosity | Liquid | - |
| Specific Gravity | Resin: 2.5 Hardener: 1 Mixed: 2.41 | - |
| Working time | 25-30 mins (500g, @25°C) | - |
| Full cure time | 24 hours | - |
| Maximum Operating Temperature | Wet: 49°C, Dry: 150°C | - |
| Cure 7 days @25°C | | |
| Shear Strength | 1113 psi | Ref.ASTM D 1002-10 |
| Tensile Strength | 7290 psi | ASTM D638-14 (Type I, V= 5 mm/min.) |
| Glass Transition Temperature | 88.75 (T _g) °C | DSC |
| Flexural Strength | 11982 psi | ASTM D790-17 Procedure AI |
| Comperssive Strength | 16415 psi | ASTM D695-15 |
| Hardeness | 87 Type D/1 sec | Ref. ASTM D2240-15 ^{el} |
| Temperature Lmitations | Continuous: -30 to 150 °C Intermittent: -30 to 200 °C | - |

*** For information only - not for specification purposes.***

Application Instructions:**1.Surface Preparation**

Steel repair epoxy liquid only be applied to clean, dry and well roughened surfaces.

- (1) Remove all loose material and surface contamination and clean with a suitable solvent which leaves no residue on the surface after evaporation such as acetone, MEK, isopropyl alcohol, etc.
- (2) If necessary, apply moderate heat to remove ingrained oil and clean again with solvent.
- (3) Roughen surface by abrasive blasting, grinding, rotary file or other appropriate means.

2.Mixing & Application

Using an appropriate tool, apply the mixed epoxy putty to the prepared surface, pressing firmly to insure intimate contact and eliminate any air pockets at the bond line or within the material.

Some applications such as holed pipes or tanks and cracked casings may require the use of reinforcement tape to bridge the damaged area(s) followed by the application of additional material to completely cover the reinforcement tape.

3.Cleaning Equipment

Wipe excess material from tools immediately. Use acetone, MEK, isopropyl alcohol or similar solvent as needed.

*** Not recommended for long term exposure to concentrated acids or to organic solvents ***

Health and Safety Information: For information and advice on the safe handling, storage and disposal, users shall refer to MSDS containing physical, ecological, toxicological and other safety-related data.