

## MARINE-TEX® EPOXY PUTTY

**MIXING RATIO:** 5 Parts epoxy resin to 1-part hardener by volume. (When mixing by weight, the ratio is 6.3 parts resin to 1-part hardener.) Always keep the epoxy at room temperature before mixing.

**CONSISTENCY OF MIXED EPOXY:** Thick, creamy no-sag putty, easily applied.

**POT LIFE (WORKING TIME):** At 72° F, 30 minutes if mixed and spread thin across mixing board. (A lump of material, or higher temperatures, may generate a 15 - 20-minute working time due to the heat the epoxy creates within itself.)

**CURE TIME:** 24 hours at a constant temperature of 72° F. Lower temperatures will create longer cure times. It is not recommended to apply the product in temperatures below 55° F.

### Mixing Info

Before starting project, store Marine-Tex at 70° F for ease of mixing and application. Read instructions on labels or instruction sheets inserted in packaged kits. The temperature of the work area must be at least 55°F, and this minimum temperature must be maintained for 24 hours while the epoxy cures.

Work in a well-ventilated area. Avoid contact with skin and eyes. Wear rubber or vinyl gloves and eye protection. Wash hands immediately after use.

Surface preparation is the key to epoxy adhesion. Remove all contaminants (dirt, oil, grease) with acetone or lacquer thinner. Sand area, then remove grit to improve adhesion.

Marine-Tex is a high-strength structural epoxy, designed for convenient proportioning and mixing — by volume — in a ratio of 5 parts epoxy resin to 1-part catalyst/hardener. Example: 5 level spoonful's of epoxy resin to 1 level spoonful of hardener. The nominal variation in proportioning the two components is 10 percent. Excess hardener / catalyst will not accelerate cure time, and it can reduce the strength of the cured epoxy. (If this epoxy is mixed by weight, the ratio is 6.3 grams of epoxy to 1 gram of hardener.)

Mix the properly proportioned components with a putty stick or hard plastic squeegee on a broad flat surface, wood, cardboard or plastic. Mix only enough for 15 or 20 minutes of nominal working time. After components are thoroughly mixed, spread your mixture into a long thin line to ensure a streak-free consistency and to provide you with maximum working time. Near the end of its working time, the mixture will become very warm, and it should be discarded.

### COMPRESSIVE STRENGTH\*:

Gray - 13,000 PSI (910 Kg/Cm<sup>2</sup>)

White - 8,700 PSI (610 Kg/Cm<sup>2</sup>)

### ADHESION SHEAR STRENGTH\*:

Gray - 1,800 PSI (126 Kg/Cm<sup>2</sup>)

White - 2,300 PSI (160 Kg/Cm<sup>2</sup>)

### CHEMICAL RESISTANCE:

Most common acids, alkalies and hydrocarbons.

### TENSILE STRENGTH\*:

Both White and Gray - 4,000 PSI (280 Kg/Cm<sup>2</sup>)

\*All strengths are dependent upon make-up of substrate and surface preparation.