

# Repair Stick Aluminium



non-rusting  
aluminium-filled

For the quick and nonrusting repair and bonding of metal parts. For the repair of cracks, holes and leaks in car bodies, gearboxes and tanks, window frames and profiles, and boats and models.

The WEICON Repair Stick Aluminium can be used in machine and system construction, in the automotive industry, in gear construction, window construction, model building and many other applications.

ISSA: 75.530.10/11  
IMPA: 81 29 65/66

## Technical data

|   |   |
|---|---|
| Composition   | Epoxy resin and aluminium fillers, putty      |
| Pot life at 25 g material and at +20 °C             | 4 Min.  |
| Density of the mixture                              | 1,6 g/cm <sup>3</sup>                         |
| Processing temperature                              | +10 bis +35 °C                                |
| Curing temperature                                  | +6 bis +40 °C                                 |
| Colour after curing                                 | aluminium                                     |
| Gap covering power to maximum                       | 15 mm   |
| Handling strength (35% strength/+20 °C) after       | 10 Min.                                       |
| Capable of bearing mechanical loads(50% strength/+2 | 1 h   |
| Final strength (100%) at +20 °C after               | 24 h  |
| Pressure (DIN 53281-83)                             | 80 N/mm <sup>2</sup>                          |
| Shore hardness D                                    | 75  |
| Average tensile shear strength after 7 days         |   |
| ac. to DIN 53283                                    | 4,2 (Aluminium sandblasted) N/mm <sup>2</sup> |
| Temperature resistance                              | -50 to +120 (briefly +150) °C                 |

## Pretreatment of the surface

To ensure a perfect bond, the surfaces to be joined must be clean and dry (e.g., clean and degrease using WEICON Surface Cleaner). Smooth surfaces should be roughened, e.g. by sandblasting.

## Processing

WEICON Repair-Sticks cover gaps of max. 15 mm per procedure. The pot life given is for a material quantity of 25 g at room temperature. If larger quantities are used, the curing time will be faster due to the typical reaction heat of epoxy resins (exothermic reaction).

Similarly, higher ambient temperatures shorten the cure time (as a rule of thumb, every +10 °C increase above room temperature will halve

working and curing time). Temperatures below +16 °C will extend working and curing times considerably, while below about +5 °C, no reaction will take place at all.

## Storage

When kept at a constant room temperature of about +20 °C and unopened in dry conditions, WEICON Repair Sticks will keep for at least 18 months.

Avoid direct sunlight.

## Note

Any product specifications and recommendations given herein must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

## Health and Safety

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

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