



ADHESIVES & SEALANTS

SPEC DATA SHEET & Application Instruction

PRODUCT

PIONEER DURASTEEL 5 MINUTES

Steel Filled Epoxy

SUPPLIER

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PRODUCT DESCRIPTION

PIONEER DURASTEEL 5-3% is a soft paste, 100 % solids, steel filled epoxy especially formulated to have the following characteristics :

1. It is a versatile maintenance repair product. Very convenient in repairing damaged equipment.
2. Cures quickly to form a durable metallic mass tha can be drilled, sanded and machined.
3. Simple mixing ratio, 1 : 1 by volume.

Typical Uses. Repairing pipes, valves, tanks; building up worn equipment; filling and leveling surfaces; making tools, templates and metal forming dies.

TECHNICAL DATA

TABLE 1. PHYSICAL PROPERTIES: UNCURED STATE

Color	
Part A	Black
Part B	Off-White
Viscosity	Soft Paste
Solids Content	100 %
Mixing Ratio	1 : 1 by volume
Pot Life	5 minutes
Cure Time (initial)	3 hours
Full Cure	72 hours
Weathering Resistance	Excellent
Heat Resistance	Could withstand up to 90 °C oven heat; non-combustible



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Chemical Resistance

Resistant to oil, gasoline, water and most chemicals
Not resistant to concentrated acids and solvents.

APPLICATION PARAMETERS

Surface Preparation. Surfaces to be done must be clean and dust, oil, grease free. On large areas where DURASTEEL 5-3% is to be applied, sanding or sandblasting is a must followed by a complete and thorough removal of the resulting residue.

Mixing. It is a 1 : 1, Part A: by volume mixing ratio. Mix Part A and Part B in a clean container, blend it well until a uniform color is attained. To avoid wastage, prepare a quantity just enough to be consumed within 3mins..

Method. DURASTEEL is applied by a putty knife or spatula. Prepared mixture is applied on both sides of glue joints. A slight or contact pressure is necessary for at least 6 hours to hold the bond in its proper position while the adhesive cures. Initial bond strength is attained after an overnight stand and its full strength after 96 hours.

Health and Safety Consideration. If skin contact occurs, wipe immediately with cloth of tissue paper dampened with Kerosene and wash it with soap and water. If contact with eyes occurs, flush thoroughly with water and get medical attention immediately.

PACKAGING

TUBES

Mini (Tipid) Pack	15 gms.
Medium Pack	35 gms.(20ml)

TIN CANS

Gallon, Quart, Pint Kits

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