



# ORAMETAL A

## EPOXY RESIN PASTE

### WITH STEEL

#### DESCRIPTION

Double-component, epoxy putty for bonding, sealing, repairing and filling all metal materials, especially steel parts.

#### APPLICATIONS

- Maintenance, construction and repair for interior or exterior use.
- Use in tool manufacturing, setting devices.
- Repair damages caused by impact or corrosion.
- Repair cracks, holes in all steel structures.
- Designed mainly for bonding and repairing steel parts, but may be used on other types of metal, and even wood.

#### PRODUCT BENEFITS

- Provides good bond on all materials.
- Resists oil, grease, aliphatic solvents, humidity, diluted acids.
- Resists vibrations.
- Anti-corrosive treatment.
- For indoor or outdoor use; resists UV rays and the elements.
- Possesses excellent, long-lasting stability.
- After complete polymerisation (24 hours), can be pierced, filed, tapped and painted over.

#### PHYSICAL PROPERTIES

Aspect .....	Paste
Colour .....	Grey
Density .....	1.80
Continuous operating temperature .....	-35°C up to 120°C
Working life at 20°C .....	Approximately 60 minutes for the 500 g kit
Working life at 20°C .....	< 10 minutes for the 28 g syringe
Complete polymerisation .....	16 to 24 hours
Hardness .....	<90 SHORE D for the 500 g kit
Hardness .....	>60 SHORE D for the 28g syringe

**PHYSICAL PROPERTIES- continued**

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Module E .....	4000 – 4500 MPa
Glass transition temperature, Tg .....	Approximately 58°C
Elongation ASTM D 882 .....	2.5%
Di-electrical strength ASTM D 149 .....	1.2 KV/mm
Coefficient of thermal expansion ISO 11359 ...	30.10-6 K-1
Thermal conductivity ASTM D 257 .....	1.11 W/m.K

The following measurements taken at 20°C DIN 53281-83:

Compression strength .....	>10 MPa
Tensile strength .....	24 MPa
Flexural strength .....	58 MPa
Impact strength .....	50 KJ/m <sup>2</sup>

**DIRECTIONS FOR USE**

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Combine the part A resin with the part B hardener until you obtain a uniform mixture.  
Ratio 100:10 in weight.  
Ratio 4:1 in volume only for the 500 g kit.  
Ratio 1:1 for syringes.

Once you have obtained a uniform mixture, apply the glue on clean and dry surfaces.

To use with a mould, spray some ORATEN on surfaces to prevent bonding.

**PACKAGING**

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28 g syringes	Ref. O 210 E1	x 12
500 g kit	Ref. O 210 K2	x 1

**WARRANTY**

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