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Product Description Sheet

3468 Wet Surface Repair Putty

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PRODUCT DESCRIPTION

Loctite 3468 Wet Surface Repair Putty is a two component epoxy that adheres to damp and underwater surfaces. It has high compressive strength, and can be machined, drilled etc. Temperature range -30° to $+65^{\circ}\text{C}$.

TYPICAL APPLICATIONS

Repair and rebuilding of parts in damp and wet environments:

- Chemical plant
- Water treatment plant
- Pulp and paper mills
- Marine engineering

PROPERTIES OF UNCURED MIXED MATERIAL

	Typical Value
Appearance	Grey Putty
Mix Ratio (R:H) by Volume	1:1
by Weight	100:89
Coverage	1000 cm ² @ 6 mm thick per 1 kg. kit 160 in ² @ 1/4" thick per 1 kg. kit

TYPICAL CURING PERFORMANCE

Curing Properties

(@ 25°C unless noted)

	Typical Value
Working Life, minutes	30
Cure Time, hours	18

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties	Typical Value
Compressive Strength, ASTM D695, N/mm ²	86.2
Shear Strength ASTM D1002, N/mm ²	13.8
.125mm gap, acid etched aluminium	
Hardness ASTM D-2240, Shore D	85
Tensile Strength, ASTM D638, N/mm ²	24.1

DIRECTIONS FOR USE

- Thoroughly clean and abrade surfaces (grit blast if possible)
- Mix 1 part resin to 1 part hardener by volume (1 to 0.89 by weight) or transfer entire kit onto a clean and dry mixing surface and mix material vigorously until a uniform colour is obtained.
- Initially apply as a thin film, build up to desired thickness and shape.
- At 25°C working time is 30 minutes and functional cure is achieved in 18 hours.

TECHNICAL TIPS FOR WORKING WITH EPOXIES

Working time and cure time depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of material mixed, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool resin/hardener components.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C unless otherwise labelled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact Loctite UK Technical Service.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

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NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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