



TECHNICAL DATA SHEET

Plastic Bronze

ThistleBond 'Plastic Bronze' is a high performance multi purpose metal repair compound specifically developed for onsite repairs of damaged or faulty castings, corroded pumps, valves, pump or shafts

ThistleBond 'Plastic Bronze' is formulated on a complex range of epoxy resins combined with a polyamino curing system which is reinforced with inert pigments and bronze fillers to produce a pourable paste which has excellent resistance to corrosive liquids and gasses.

ThistleBond 'Plastic Bronze' is ideally suited for use in tool rooms providing an economical solution to the problem of producing short run or prototype dies, jigs and fixtures.

ThistleBond 'Plastic Bronze' is simple and easy to use, can be drilled, tapped or filed etc. just like the parent metal.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

Heavy contamination due to oil or grease must first be removed using **ThistleBond Cleaner**.

All loose material, rust and surface contaminants, including existing coatings, must be removed and the surface roughened by using an angle grinder, needle gun or abrasive blasting. Where grinding or needle gunning is used, the surface should be cross-scored to improve adhesion. Care must be taken, when angle grinding, to avoid polishing rather than roughening metal surfaces.

Where possible, abrasive blasting is the preferred surface preparation, especially in fluid flow repairs.

Surfaces should finally be carefully degreased using **ThistleBond 'Cleaner'**. Cloths should be frequently changed to avoid spreading contamination. On deeply pitted surfaces or porous castings, **ThistleBond 'Cleaner'** should be worked into the surface by brush and washed off using excess cleaner.

MIXING

ThistleBond 'Plastic Bronze' is a two component solvent free material comprising resin and hardener components which must be mixed together prior to use.

The mixed material should be used within 30 minutes of mixing at 20°C (68°F). This time will be reduced at higher temperatures and extended at lower temperatures.

APPLICATION

The mixed material should be pressed firmly onto the prepared area, working the material into any cracks and surface defects.

When **ThistleBond 'Plastic Bronze'** is being used to bond two surfaces together, both surfaces should be coated with the material. The two pieces should then be pressed firmly together and clamped in position until the product has set, any excess material squeezed out should be scraped away before the **ThistleBond 'Plastic Bronze'** begins to cure.

When a reinforcing Tape is being used to strengthen the repairs the tape should either be impregnated with **ThistleBond 'Plastic Bronze'**, or the tape should be layed over the **ThistleBond 'Plastic Bronze'** surface and stippled into the material before it cures, then additional **ThistleBond 'Plastic Bronze'** applied over the surface.

Once **ThistleBond 'Plastic Bronze'** has cured for a minimum of 4 hours at 20°C (68°F), sanding, grinding and machining etc. can be carried out using standard engineering practice.

Volume Capacity

813cc (49.5cu ins) per kilo

PHYSICALCONSTANTS

Mixing Ratio	Resin	Hardener	
	2.2	1	By Volume
	2	1	By Weight

Appearance	Resin	Bronze Paste
	Hardener	Light Brown Paste

Drying & Cure Times at 20°C	Usable Life	30 minutes
	Gel Time	3-4 hours
	Machining	4 hours
	Full Mechanical	3 days

Volume Solids 100%

V.O.C. Nil

Shelf Life Indefinite in original sealed containers when stored between 5°C (40°F) and 40°C (104°F).

PHYSICALPROPERTIES

Compressive Strength 956kg/cm² (13600 psi)

ASTM D 695

Corrosion Resistance 5000 hours

ASTM B117

Flexural Strength 991kg/cm² (14100 psi)

ASTM D 790

Hardness (Shore D) 100

ASTM D22.46

Heat Distortion 48°C

ASTM D648

Dielectric Strength 0.9

kv/mm

Tensile Shear Adhesion 239kg/cm² (3400 psi)

ASTM D1002

(Grit Blasted Steel)

HEALTHANDSAFETY

As long as normal good practice is observed **ThistleBond 'Plastic Bronze'** can be safely used.

Protective gloves should be worn during use.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 0.300kg packs

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.

FOR FURTHER INFORMATION PLEASE CONTACT

ThistleBond

www.thistlebond.com

ThistleBond Division of E. Wood Ltd.
Standard Way, Northallerton, N. Yorks. U.K. DL6 2XA
Tel: +44(0)1609 780170 Fax: +44(0)1609 780438 & 777905
E Mail: info@thistlebond.com