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## Technical Data Sheet

### Permatex® PermaPoxy™ Sticks

AAM Revised 07/02

#### PRODUCT DESCRIPTION

**S.I.N.: 834-300**

Permatex® PermaPoxy™ Sticks are two part, hand kneadable, putty type epoxies. Contrasting colored materials are mixed together to form a uniform color to indicate thorough mixing. PermaPoxy™ Sticks can be drilled, sanded, threaded or filed and are resistant to fuels and solvents after full cure.

#### PRODUCT BENEFITS

##### Easy To Use:

- No heating required

##### Fast and Reliable:

- Holds in 5 minutes
- Useable in 30 minutes
- Good moisture resistance
- Withstands high temperatures

##### Safe To Use:

- Non-flammable

#### TYPICAL APPLICATIONS

- Cracked transmission cases
- Chipped heads
- Rear end castings
- Cracked blocks
- Cracked intake manifolds
- Damaged keyways
- Split stampings

#### DIRECTIONS FOR USE

1. Before starting, make sure your work area is protected from accidental spills. Surfaces must be clean, dry and free of grease and oil.
2. Roughen smooth surfaces to be repaired with sandpaper.
3. Cut off required amount of epoxy and knead with fingers to a uniform color. This should take no longer than two minutes.
4. Apply to the surface to be repaired. Force into cracks or holes to be filled. Excess material can be removed, before it is cured, with a tool wetted with clean water.
5. On wet or damp surfaces, work material into area forcefully and hold in place until adhesion begins. Do not use hand to hold in place as heat is given off during cure.
6. After 5 to 10 minutes, the epoxy will harden.
7. After 1 hour, material can be drilled, sanded, tapped, threaded, filed or painted.

#### For Cleanup

1. Cleanup must be completed before curing is complete. Use acetone or mineral spirits for cleanup.
2. Clean hands with Permatex® brand hand cleaners.

#### PROPERTIES OF UNCURED MATERIAL

Typical Value

Chemical Type

Epoxy and amine resins

Appearance

Copper

Copper outside, olive green inside

Aluminum

Lt grey outside, olive green inside

Multi Metal

Dk grey outside, black inside

Odor

Slight amine

Specific Gravity (mixed)

1.9

Flash Point, TCC, °F

>500

Mix Ratio

1:1

#### TYPICAL CURING PERFORMANCE

Permatex® PermaPoxy™ Sticks have a set up time of 4 to 6 minutes, fixture time of 10 to 15 minutes with a full cure in 16 hours.

#### TYPICAL ENVIRONMENTAL RESISTANCE

##### Temperature Resistance

##### Typical Values

Continuous, °F Maximum

-60°F to 300°F

Intermittent, °F Maximum

+350°F

#### Chemical / Solvent Resistance

The product retains effective properties when in contact with water, oil, fuels and solvents.

#### GENERAL INFORMATION

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

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

#### ORDERING INFORMATION

Part Number	Container Size
84301	2 oz. Copper PermaPoxy™ Stick, w/vial, carded
84304	2 oz. Aluminum PermaPoxy™ Stick, w/vial, carded
84309	2 oz. Multi-Metal PermaPoxy™ Stick, w/vial, carded

#### STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. 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.

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.  
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