



Kneadatite® Brown/Neutral Epoxy Putty Tape

Product description

Kneadatite Brown/Neutral is a room-temperature curing epoxy/ polyamide sealant-adhesive in tape form. It is stable in its packaged form consisting of base and curing agent side by side on release film. The base and curing agent are of contrasting colors so that when kneaded together, complete mixing is easily observed. When cured it may be filed, sanded, drilled and tapped like metal.

Basic uses

Nicknamed "Brown", Kneadatite Brown/Neutral is well known by sculptors for its long work life, non-grainy texture and ability to hold fine detail. It can be cut to achieve hard edges, for sculpting and to build up understructures. Cured models withstand the heat and pressure of up to 4 vulcanizations in the mold making process for castings. Mixing "Brown" with Kneadatite Blue/Yellow® will increase Blue/Yellow's hardness, and mixing proportions can be adjusted to control curing time.

Kneadatite Brown/Neutral is also used to repair small automotive body dents and exhaust system holes and for attaching metal strips.

Benefits

- Excellent adhesion to steel.
- Long worklife.
- No shrinkage.
- Solvent resistant.

Application limitations

- Will not adhere to polyethylene, polypropylene, or PTFE.

Performance Data*

Properties	Results	Test Method
Uncured Properties		
Mix ratio, base to curing agent	1:1 by weight	
Consistency	Putty	
Non-volatile content	100%	
Density	1.53 gm/cm ³ 12.8 lb/gal	
Work life at 75°F (24°C)	1.5 to 2 hours	
Uncured green strength		
vertical shear (1" x 1" x 1/16")	1.25 psi	
Cure time to Shore D Hardness 30	4 to 5 hours	
Cure time to ultimate Hardness	20 to 24 hours	
Cured Mechanical Properties		
Hardness, Shore D at 24 hours	70	ASTM D2240
Lap shear tensile strength		
on steel (1" x 1" x 1/16")	500 psi	ASTM D1002
Elongation	10%	ASTM D638
Shrinkage	<1%	ASTM D2566
Upper temperature limits		
Continuous	250°F (121°C)	
Intermittent	300°F (149°C)	
Chemical resistance	Resistant to hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, and dilute acids and bases	
Cured Electrical Properties		
Electrical resistance	30,000 megohms	ASTM D257
Dielectric strength	300 volts/mil	ASTM D149

* Typical properties are for information only, not for purposes of specification.

- Not for structural applications.

Color

Base color is Brown; curing agent color is Neutral; cured color is Brown.

Packaging

Available in 1-1/2" wide and 4" long strips packed in a plastic box, 24 boxes per carton. Custom packaging is available.

Application

Surface preparation: To achieve optimum adhesion, surfaces should be cleaned free of grease or dirt. Scuffing or sanding the surface prior to cleaning helps ensure a good bond.

Mixing: Hand mixable without messy residue. Any length of the two-part tape contains the proper ratio of base to curing agent necessary to produce a hard, tough material.

Twist or cut off required amount. To mix, knead with fingers to a uniform color. If mixing is difficult, warm Brown/Neutral to room temperature or slightly above. Apply to the surface to be repaired within 1 hour of mixing. Force into any cracks or holes to be filled and strike off excess material, preferably with a tool wetted with clean water.

When applying to a damp, wet or slowly leaking area, work the material forcefully into the surface and apply pressure until adhesion begins to take effect.

For a smooth appearance, hand rub with water or a damp cloth prior to hardening. Remove excess material before hardening begins. After 2 hours the epoxy will begin to form a tenacious bond. After just 4 to 5 hours Brown/Neutral can be drilled, sawed, carved, sanded, stained or painted.

Shelf life: One year from date of shipment when stored in unopened container at 75°F (24°C).

Health precautions

- May cause irritation to sensitive skin. Wash hands with soap and water after use.
- May be harmful if swallowed.
- Eye irritant. In case of contact, flush with water. Contact physician.
- Keep out of reach of children.
- When sanding cured putty and substrate, use protective eye wear and dust mask.
- Turn off power when doing electrical repairs.

For additional health and safety information, consult a Material Safety Data Sheet.

Availability and cost

For more information, please contact Polymeric Systems, Inc., 723 Wheatland Street, Phoenixville, PA 19460-3394. Telephone: 1-888-EPOXY-FIX (1-888-376-9934), or (610) 935-1180. Or visit us at our website: www.polymericsystems.com.

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Form No. 4027-0805