

# Repair stick aluminium

Art. No. 114583

Type No. 115.21



Exemplary illustration

For quick, non-rusting repairs or bonds of metal parts.

Patches and seals cracks, holes leakages and surface damage on car bodies, tanks, casings profiles or window frames as well as in DIY and gardening applications.

## Technical data

Contents	57 g
GHS	GHS07
GHSSIGNAL	A
Hazard statements	H315 - Causes skin irritation. H317 - May cause an allergic skin reaction. H319 - Causes serious eye irritation. H412 - Harmful to aquatic life with long lasting effects.
Base	epoxy
Filler	aluminium
Texture	modelling compound
Colour	aluminum-colored
Processing temperature	15 to 35 °C
Cure temperature	6 to 40 °C
Relative air humidity	< 85 %
Mixing ratio by weight	1:1
Density of the mixture	1.9 g/cm <sup>3</sup>
Gap bridging to max.	15.0 mm
Pot life at 20 °C, 10 g batch	approx. 6 min
Handling strength (35 % strength)	10 min
Working strength after (80 % strength)	60 min
Final strength (80 % strength)	24 hours
Shrinkage	< 1,0 %
Compressive strength DIN EN ISO 604	55 MPa
Hardness (Shore D) DIN ISO 7619	80±3
Adhesive strength DIN EN ISO 4624	6 MPa

## Technical data

Thermally stable	-50 to 120 °C
Briefly temperature resistance	150 °C
Thermal conductivity DIN EN ISO 22007-4	0.65 W/m·K
Resistance DIN EN 62631-3-1	approx. $5 \cdot 10^{11} \Omega \cdot m$
Electrical resistance ASTM D 257	5 $\Omega \cdot cm$
Dielectric strength	3.0 kV/mm
Magnetic	no

## Commercial data

Customs tariff number	32141010
Country of origin	DE
eCl@ss 5.1.4	30021609
eCl@ss 9.0	30021609
UNSPSC_Code_v190501	47131825
UNSPSC_CodeDesc_v190501	Contact surface cleaners

## Material informations

REACH SVHC1 substance name	no
CAS no. SVHC 1	no CAS No.
RoHS materials notice	RoHS compliant
REACH Info	no SVHC substance included

## Conversion table

$(^{\circ}C \times 1.8) + 32$	=	$^{\circ}F$
mm/25.4	=	inch
$\mu m/25.4$	=	mil
N x 0.225	=	lb
$N/mm^2 \times 145$	=	psi
MPa x 145	=	psi
Nm x 8.851	=	lb·in
Nm x 0.738	=	lb·ft
Nm x 141.62	=	oz·in
mPa·s	=	cP
N/cm x 0.571	=	lb/in
kV/mm x 25.4	=	V/mil

## Product informations

Non-corrosive | fast-curing | aluminium-filled

For the quick and non-corrosive repair and bonding of metal components. For the repair of cracks, holes and leaks in car bodies, gearboxes and tanks, window frames and profiles, and boats and models. The Repair stick aluminium can be used in machine and system construction, in the automotive industry, in gear construction, window construction, model building and many other applications.

### Instructions for use

When using RIEGLER products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets ([www.riegler.com](http://www.riegler.com)) must be observed.

### Surface pre-treatment

For a flawless adhesive bond, surfaces must be clean and dry.

### Processing

Repair sticks aluminium can bridge a bonding gap of max. 15 mm per work step. The specified pot life refers to a material preparation of 25 g at room temperature. Larger preparation quantities result in a faster curing time due to the typical reaction heat of epoxy resins (exothermic reaction). Higher temperatures also reduce the pot life and curing time. (General rule: every increase by +10 °C above room temperature results in a decrease of the pot life and curing time by half). Temperatures below +16 °C increase the pot life and curing time significantly. From approx. +5 °C and below, no reaction takes place.

### Storage

When unopened, Repair sticks aluminium can be stored at a constant room temperature of approx. +20 °C in a dry place for at least 18 months. Protect from direct sunlight.

## Repair Stick Aluminium

### Chemical resistance of Repair stick aluminium after curing\* (Excerpt)

Exhaust fumes	+	Potassium carbonate	+
Acetone	o	Potassium hydroxide 0-20 % (caustic potash)	+
Ethyl ether	+	Milk of lime	+
Ethyl alcohol	o	Carbolic acid	-
Ethylbenzene	-	Creosote oil	-
Alkalis (alkaline substances)	+	Cresylic acid	-
Hydrocarbons, aliphatic (petroleum derivatives)	+	Magnesium hydroxide	+
Formic acid >10 % (methanoic acid)	-	Maleic acid (cis-ethylenedicarboxylic acid)	+
Ammonia anhydrous 25%	+	Methanol (methyl alcohol) <85 %	-
Amyl acetate	+	Mineral oil	+
Amyl alcohol	+	Naphthalene	-
Hydrocarbons, aromatic (benzene, toluene, xylene)	+	Naphthene	-
Barium hydroxide	+	Sodium carbonate (soda)	+
Petrol (92-100 octane)	+	Sodium bicarbonate (sodium hydrogen carbonate)	+
Hydrobromic acid <10 %	+	Sodium chloride (table salt)	+
Butyl acetate	+	Sodium hydroxide >20 % (caustic soda)	o
Butyl alcohol	+	Caustic soda	+
Calcium hydroxide (slaked lime)	+	Heating oil, diesel	+
Chloroacetic acid	-	Oxalic acid <25 % (ethanedioic acid)	+
Chloroform (trichlormethane)	o	Perchloraethylene	o
Chlorosulphuric acid (wet and dry)	-	Kerosene	+
Chlorinated water (swimming pool concentration)	+	Oils, vegetable and animal	+
Hydrochloric acid	+	Phosphoric acid <5%	+
Chromium bath	+	Phthalic acid, phthalic anhydride	+
Chromic acid	+	Crude oil	+
Diesel fuels	+	Nitric acid <5%	o
Mineral oil and mineral oil products	+	Hydrochloric acid <10 %	+
Acetic acid diluted <5%	+	Sulphur dioxide (wet and dry)	+
Ethanol <85 % (ethyl alcohol)	+	Carbon disulphide	+
Greases, oils and waxes	+	Sulphuric acid <5%	o
Hydrofluoric acid diluted	o	White spirit	+
Tannic acid diluted <7%	+	Carbon tetrachloride (tetrachloromethane)	+
Glycerin (trihydroxypropane)	+	Tetralin (tetrahydronaphthalene)	o
Glycol	o	Toluene	-
Humic acid	+	Hydrogen peroxide <30 % (hydrogen superoxide)	+
Impregnating oils	+	Trichloraethylene	o
Potash	+	Xylene	-

+ = resistant 0 = for a limited time - = not resistant \*The storage of all Repair sticks was carried out at +20°C chemical temperature.