

PRATLEY®

Instruction Leaflet for PRATLEY STEEL PUTTY



CONGRATULATIONS!

The product you have purchased is from a range of the most advanced adhesives and sealants in the world - researched, manufactured and marketed by Pratley.

GENERAL:

Pratley Steel Putty is an exceptionally high strength, hand mouldable, putty-like adhesive. Mixing equal proportions of the resin and hardener supplied in the form of sticks yields a highly versatile, medium speed putty with a 1001 uses.

PROPERTIES:

- Very high strength.
- Medium speed cure.
- Can be shaped and moulded.
- Adheres to most rigid materials.
- Once set can be sawn, filed, machined, sanded.
- Accepts paint.
- Good electrical insulator.
- Will set under water.
- Withstands most chemicals, mild acids, oil, petrol, etc.
- Can be smoothed and shaped with a wet finger or spatula.

TIME TO SET:

- Sets hard in ± 45 minutes (at 23°C).
- Should be applied within 15 minutes of mixing.
- Reaches 75% strength in ± 3 hours.
- Reaches full strength in ± 5 hours.

SURFACE PREPARATION:

Surfaces to be bonded must be free of loose dirt, rust, paint, oil and grease. Wire brushing or sanding will substantially enhance adhesion to smooth surfaces.

MIXING PROCEDURE:

1. Place the sticks side by side and without removing the wrapping. Simultaneously cut **equal amounts** off each stick with a sharp knife (**Fig. 1**).
2. Remove wrapping from cut parts.
3. Place both parts together between your fore-fingers and thumb and kneed putty between fingers using both hands for ± 1 minute (**Fig. 2**).
4. Roll a sausage between the palm of your hands, applying lots of pressure onto putty whilst rolling. (**Fig 3**).
5. Fold sausage into a ball and repeat step 4 (**Fig. 4**).
6. Keep on repeating step 4 & 5 for $\pm 6-8$ minutes.
NB! - It is important to keep on applying pressure whilst rolling putty between the palm of your hands.
7. **NB! Unlike other Pratley Putty, Pratley Steel Putty goes through 3 distinct stages whilst mixing.**

Stage 1: It starts off malleable and slightly sticky up to about 1 minute of mixing.

Stage 2: It warms up and becomes somewhat crumbly at about 3 minutes.

Stage 3: It then slowly becomes more and more malleable with further mixing. It needs to be mixed for about 6 to 8 minutes.

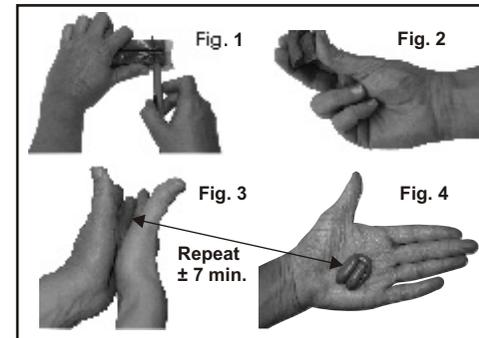
Thorough mixing is essential.

It is important not to stop mixing at stage 2.

Apply by dabbing and wiping with pressure onto the application surfaces. This ensures a good bond. Build up the shape as necessary.

NOTE:

- Pratley Steel Putty should be applied in thick section (not less than 3 mm (1/8") for maximum strength).
- Should the sticks be hard due to prolonged storage in a cold place, gentle warming should restore them to their original consistency.



Note:

- As product is used outside our control, we cannot accept liability for any possible failures.

SOME SUGGESTED USES:

1. Seal metal water tanks and cracked motor car sumps.
2. Repair metal castings
3. Replace broken handles and knobs on utensils..
4. Repair ceramic fuse holders and insulators.
5. Repair car radiators and leaking petrol tanks.
6. Mend garden implements and metal watering cans.
7. Re-fit loose screws.
8. Make your own models and sculptures.

NOT RECOMMENDED FOR:

- Bonding of rearview mirrors to windscreens.
- Very high temperature above 120°C continuous (e.g. exhaust pipes).
- Flexible materials.

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