



3281 Guasti Road, Suite 260
Ontario, CA 91761
(909) 987-0550 (800) 538-3091
Fax: (909) 987-0490
<http://pacertechindustrial.supergluecorp.com>

PRO WELD QUICK WELDING COMPOUND

Pacer Technology's Pro Seal PRO WELD Quick Cold Welding Compound is a two part epoxy adhesive system that is formulated to resist temperatures up to 300°F and withstand drilling, machining or sanding. Typical applications include the repair of cracks in transmission and rear end casings, manifolds, radiator seams, casting defects and keyways.

<u>PROPERTIES - LIQUID PRODUCT</u>		
Chemical Base	<u>Epoxy resin</u>	<u>Epoxy hardener</u>
Color	Dark Gray or Black paste	Gray paste
Viscosity, cP	600,000	500,000
Mix Ratio	1:1 mix of equal parts	

<u>PROPERTIES - MIXED PRODUCT</u>	
Set Time	4 Minutes
Full Cure	4-6 Minutes
Maximum Gap	.25"
Tensile Strength, ASTM D638	2040 psi ($\pm 10\%$)
Tensile Shear Strength	
ASTM D 1002, Steel/Steel	1072 psi ($\pm 10\%$)
Service Temperature Range	-65°F to +250°F (-54°C to +121°C)
Hardness, Shore D	73 (After curing 60 minutes)
	83 (After full cure)

USE INSTRUCTIONS

1. Surfaces should be clean and dry, free from oil and grease.
2. Roughen surfaces with emery cloth or sandpaper for best results.
Remove all residual dust.
3. Mix equal amounts of resin and hardener thoroughly, for approximately 1 minute.
4. Apply to both surfaces and mate parts together.
5. Remove excess epoxy immediately with denatured alcohol.
6. Fixtures in 60 minutes, full cure in 12 to 24 hours.

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