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Technical Data Sheet

Permatex® Fuel Tank Repair

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PRODUCT DESCRIPTION

Permatex® Fuel Tank Repair is a two-part, hand kneadable, putty type epoxy stick used for repairing metal gas tanks and containers. Contrasting colored materials are mixed together to form a uniform color to indicate thorough mixing. The resulting cured adhesive can be drilled, sanded, threaded or filed and it is resistant to fuels and most solvents after full cure.

Note: Permatex® Fuel Tank Repair is not intended for repairing Polyethylene and Propylene tanks or for structural bonding.

PRODUCT BENEFITS

Easy To Use:

- No heating required
- Applies and shapes like putty

Fast and Reliable:

- Holds in 1 hour
- Can be machined within 5 hours
- Full cure in 24 hours
- Withstands moderate temperatures
- No shrinkage
- Resistant to most solvents, including ethanol

Safe To Use:

- Non-flammable
- No VOC's

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, oil, and excess debris.
2. Roughen smooth surfaces to be repaired with sandpaper.
3. Before handling the epoxy stick, place impermeable gloves on hands. 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. Also, for a smooth surface, hand rub with water or a damp cloth before the epoxy hardens.
5. On wet or damp surfaces, work material into area forcefully and hold in place until adhesion begins. Do not hold in place with hands, as heat is given off during cure.
6. After 1 hour, the epoxy will harden.
7. After 5 hours, the material can be machined.

For Cleanup

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

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy and Amine resins
Appearance	Brown outside, Grey inside
Odor	Slight amine
Specific Gravity (mixed)	1.5 g/ml
Flash Point, TCC, °F	>200
Mix Ratio	1:1

TYPICAL CURING PERFORMANCE

Permatex® Fuel Tank Repair sets up in 1 hour, can be machined in 5 hours, and fully cures in 24 hours.

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance	Typical Values
Continuous, °F Maximum	-60°F to 250°F
Intermittent, °F Maximum	300°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
84334	1 oz. Permatex® Fuel Tank Repair Stick, w/vial, carded

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C and 28°C (46°F and 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.

NOTE

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