



ORAMETAL A

EPOXY RESIN PASTE

WITH STEEL

DEFINITION

Double-component, epoxy putty for bonding, sealing, repairing and filling all metal materials, especially steel parts.

ADVANTAGES

- Provides good bond on all materials.
- Resists oil, grease, aliphatic solvents, humidity, diluted acids.
- Resists vibrations.
- Anti-corrosive treatment.
- For indoor or outdoor use; resists UV rays and the elements.
- Possesses excellent, long-lasting stability.
- After complete polymerisation (24 hours), can be pierced, filed, tapped and painted over.

APPLICATION FIELDS

- Maintenance, construction and repair for interior or exterior use.
- Use in tool manufacturing, setting devices.
- Repair damages caused by impact or corrosion.
- Repair cracks, holes in all steel structures.
- This product is designed mainly for bonding and repairing steel parts, but may be used on other types of metal, and even wood.

TECHNICAL CHARACTERISTICS

Aspect	Paste
Colour	Light Grey (syringe) and dark grey (kit 500)
Density	1.80
Continuous operating temperature	-35°C up to 120°C
Working life at 20°C	Approximately 60 minutes for the 500 g kit
Working life at 20°C	< 10 minutes for the 28 g syringe
Complete polymerisation	16 to 24 hours
Hardness	<90 SHORE D for the 500 g kit
Hardness	>60 SHORE D for the 28g syringe
Module E	4000 – 4500 MPa
Glass transition temperature, Tg	Approximately 58°C
Elongation ASTM D 882	2.5%

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Manufacturing site and registered office

Parc Industriel de la Plaine de l'Ain - 225 allée des Cèdres - 01150 Saint-Vulbas - FRANCE
 Tél. +33 (0)4 74 40 20 25 - Fax +33 (0)4 74 40 20 26 - www.orapi-maintenance.com

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TECHNICAL CHARACTERISTICS - continued

Di-electrical strength ASTM D 149 1.2 KV/mm
Coefficient of thermal expansion ISO 11359 ... 30.10-6 K-1
Thermal conductivity ASTM D 257 1.11 W/m.K

The following measurements taken at 20°C DIN 53281-83:

Compression strength >10 MPa
Tensile strength 24 MPa
Flexural strength 58 MPa
Impact strength 50 KJ/m²

INSTRUCTIONS FOR USE

Combine the part A resin with the part B hardener until you obtain a uniform mixture.

Ratio 100:10 in weight.

Ratio 4:1 in volume only for the 500 g kit.

Ratio 1:1 for syringes.

You could use a nozzle ref 700083 to mix the adhesive (sold separately)

Once you have obtained a uniform mixture, apply the glue on clean and dry surfaces.

To use with a mould, spray some ORATEN on surfaces to prevent bonding.

PACKAGING

28 g syringes	Ref. 1210 E1	x 12
500 g kit	Ref. 1210 K2	x 1

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