

TECHNICAL DATA BULLETIN

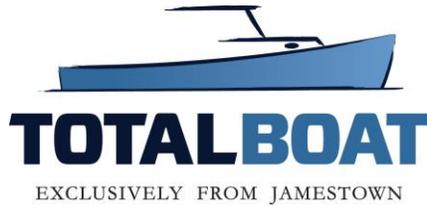
ALUMINUM BOAT LEAK SEALER

TotalBoat Aluminum Boat Leak Sealer is ideal for patching small holes and repairing or waterproofing leaky rivets and seams on aluminum boats. It combines the strength of an epoxy resin with the flexibility of an elastomeric sealant. Patches and repairs made with Aluminum Boat Leak Sealer are resilient and can withstand the stresses of flexing, twisting, expansion, contraction, shock and vibration.

HANDLING PROPERTIES		
	<u>VALUE</u>	<u>TEST METHOD</u>
Resin Density, lbs/gal	10.0	ASTM D1475
Hardener Density, lbs/gal	8.3	ASTM D1475
Mix Ratio By Volume	1A : 1B	Calculated
Mix Ratio By Weight	1.2A : 1B	Calculated
Initial Mixed Viscosity at 77°F, cP	Thixotropic	ASTM D2196
Gel Time at 72°F, 100g mass, minutes	40	ASTM D2471
Working Time, thin film, minutes	75	
Initial Cure Time, hours	3-4	
Workable Cure Time ¹ , hours	7-10	(¹ 24 Hours For High Loads)
Minimum Recommended Temperature	40°F (4°C)	

PHYSICAL PROPERTIES		
	<u>VALUE</u>	<u>TEST METHOD</u>
Color	Buff	Visual
Tensile Strength, psi	5,330	ASTM D638
Tensile Elongation, %	23.8	ASTM D638
Tensile Modulus, psi	187,000	ASTM D638
HDT, Room Temperature Cure, °F	134	ASTM D648
HDT, Post Cure, °F	189	ASTM D648
Compressive Strength, psi	7,200	ASTM D695
Flexural Strength, psi	8,800	ASTM D790
Flexural Modulus, psi	203,000	ASTM D790
Density, Cured, g/cm ³ (lbs/in ³)	1.14 (0.041)	ASTM D792
Volumetric Yield, in ³ /lb	24.3	ASTM D792
Volumetric Shrinkage, %	3.5	ASTM D792/D1475
Hardness, Shore D	77	ASTM D2240
Onset of Tg by DSC, °F	195	ASTM D3418
Ultimate Tg by DSC, °F	213	ASTM D3418





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INSTRUCTIONS FOR USE:

SURFACE PREPARATION: The surface must be clean, dry and free of dirt, dust, grease, loose paint, oils, or other contaminants. Sand the aluminum with 80-grit sandpaper within a 1" radius of the leak or repair until the metal is shiny. Remove any sanding residue before application. **APPLICATION:** Apply when the temperature of the air and substrate are 40°F or warmer. For ease of application, keep the cartridge at at least room temperature (60-90°F) directly before use. Remove the nut and nose plug from the top of the cartridge. Insert the cartridge into a caulk gun. For easiest application, use a caulk gun with a minimum ratio of 8:1. Attach the provided static mixing tip to the cartridge and twist on until it is tight. The first 3-4" of adhesive dispensed may be resin or hardener rich and should be discarded as waste. Apply the adhesive using an epoxy spreader to manipulate it. For best results, it should be spread to a thickness of 1/8" to 1/16" and covers all of the shiny, sanded metal. When finished, leave the static mixing tip on the cartridge to cure. For the next application, simply remove and replace the static mixing tip. Do not attempt to clean the tips. The adhesive will gel in about 40 minutes at 72°F. Assemble and clamp parts in position before the adhesive begins to gel. Keep parts clamped until the adhesive is cured, about 3-4 hours at 72°F. Cure time is faster at warmer temperatures and slower at cooler temperatures. Once cured, the epoxy resin is waterproof, sandable and paintable.

STORAGE:

Store at 60-90°F in a dry place. After use, tightly reseal all containers. Store products on a raised surface off the floor during cold weather and avoid storing near outside walls or doors. Epoxy resins that are contaminated with dust or moisture, or are subjected to low temperatures may crystallize. Do not use material that has any sign of crystallization until it has been liquefied. A crystallized resin or hardener can be returned to its original state by heating the material to 140°F to 150°F and stirring until it returns to the liquid state.

SAFETY HANDLING:

Work in well-ventilated areas using gloves, eye protection and clothing protection. Avoid contact to the skin and eyes. Avoid clothing contamination. Wash thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult Material Safety Data Sheets for complete precautions with this product.

Jamestown Distributors has experience only in the compounding of resins and hardeners and not in the actual manufacture of tools or parts. Each piece is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.

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