

# LOCTITE® Fixmaster® Metal Magic Steel™

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## PRODUCT DESCRIPTION

LOCTITE® Fixmaster® Metal Magic Steel™ provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Chemical Type</b>	Epoxy
<b>Appearance (uncured)</b>	Metallic black <sup>LMS</sup>
<b>Components</b>	One part - requires no mixing
<b>Cure</b>	Room temperature cure
<b>Application</b>	Bonding
<b>Specific Benefit</b>	<ul style="list-style-type: none"> <li>• Cures under water and will adhere to most damp surfaces</li> <li>• Adheres to most types of clean surfaces</li> <li>• Cures in 10 minutes for fast repairs</li> <li>• Epoxy adhesive stick applies like putty and cures to a steel-like finish</li> </ul>

LOCTITE® Fixmaster® Metal Magic Steel™ is a versatile, single component, easy to use, steel filled epoxy repair putty. It is applied like a putty and when cured it has a high compressive strength and good adhesion to most surfaces. This product stops leaks in pipes and tanks, fills oversized bolt holes, smoothes welds, and repairs non-structural defects in castings holes in tanks. This product is typically used in applications with an operating range of -30 °C to +121 °C.

## NSF International

**Certified to ANSI/NSF Standard 61** for use in commercial and residential potable water systems not exceeding 82° C.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Coverage 40 cm<sup>2</sup> @ 6 mm thick per tube  
(16 in<sup>2</sup> @ 0.25 in thick per tube)

## TYPICAL CURING PERFORMANCE

### Curing Properties

Cure Time @ 25 °C, minutes 10  
Working Time @ 25 °C, minutes 2.5 to 5.0<sup>LMS</sup>

## TYPICAL PROPERTIES OF CURED MATERIAL

Cured for 1 hour @ 25 °C

### Physical Properties:

Shore Hardness, ISO 868, Durometer D >70<sup>LMS</sup>  
Tensile Strength, ISO 527-2 N/mm<sup>2</sup> 17  
(psi) (2,500)

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Adhesive Properties

Cured for 1 hour @ 25 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted) N/mm<sup>2</sup> ≥3.45<sup>LMS</sup>  
(psi) (≥500)

Aluminum (acid etched):

0.125 mm gap N/mm<sup>2</sup> 4.8  
(psi) (700)

Compressive Shear Strength, ISO 10123:

Steel pins and collars N/mm<sup>2</sup> 83  
(psi) (12,000)

## GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

## Directions for use

1. **CAUTION:** Do not apply to surfaces above 66 °C.
2. Clean and dry application surface, if possible. For maximum adhesion, clean and sand the surface. Clip desired amount, remove plastic, roll briskly between hands, twist and knead until uniform color.
3. Firmly apply for patch, repair or bonding.
4. For a smooth finish, wet a cloth or finger with water and smooth.

## Technical Tips for Working With Epoxies

Working time and cure depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of material, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool putty down.

## Loctite Material Specification<sup>LMS</sup>

LMS dated January 22, 2002. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

**Storage**

Store product in the unopened container in a dry location. Material removed from containers may be contaminated during use. Do not return liquid to original container. Storage information may be indicated on the product container labeling.

**Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.**

Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those recommended. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\mu\text{m} / 25.4 = \text{mil}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{N/mm}^2 \times 145 = \text{psi}$

$\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

**Note**

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Reference 1.1