



## SURFACE PREPARATION, MIXING & APPLICATION TECHNIQUES

### **HYPOXY ALUMBOND H450 – FOR REPAIRING ALUMINIUM CASTING DEFECTS.**

Surfaces must be clean, dry, free from oil / grease etc.

Take a flat steel / plastic plate to be used for mixing resin & hardener thoroughly.

Take out RESIN MATERIAL from the Resin tube and make a puddle on a flat steel mixing plate.

Similarly take out HARDENER MATERIAL from the Hardener tube and make a same size puddle aside of resin puddle.

Ensure that resin puddle is of same size ( BY VOLUME ) as of the hardener puddle. THE THUMB RULE IS THAT THE RESIN & HARDENER MATERIAL OF SAME QUANTITY IS TO BE TAKEN OUT & MIXED.

**IF COLOUR MATCHING IS NEEDED, THEN MIX VERY SMALL PORTION OF WHITE / BLACK PIGMENT SUPPLIED SEPRATELY IN THE RESIN MATERIAL TAKEN OUT ON THE PLATE SO AS TO GET THE DESIRED COLOUR SHADE.  
THE COLOUR PIGMENT PORTION IS MIXED IN RESIN IN SUCH A MANNER SO THAT FINAL COLOUR OF THE RESIN + PIGMENT + HARDENER MIXTURE IS CLOSEST TO THE DESIRED COLOUR SHADE OF THE CASTING.**

Once done so, now take a mixing bar / rod to mix resin + pigment mixture (IF NEEDED) with hardener material thoroughly on the flat steel / plastic plate.  
Mix thoroughly, ensuring that all of the hardener material is mixed thoroughly with all of the resin + pigment material.  
Ensure aggressive mixing for atleast 2-3 minutes.

Apply the mixed compound by hand finger or with putty knife, spatula, or similar tool on the casting which needs to be repaired.

The Hypoxy H450 ALUMBOND has a pot life of 35-40 minutes at room temperature so ensure that all the resin & hardener material mixed is used and applied on casting before the mixture gets hard.

The applied ALUMBOND material on the repaired casting will get hard in 40-50 minutes time.

However keep the repaired casting for atleast 3-4 hours so that complete chemical reaction takes place and the applied ALUMBOND material on the defect area gets full mechanical strength and bond completely with the parent casting surface.

After 4 hours, wipe out the extra material applied on the casting surface by using buffing wheel, grinder, sand paper or suitable tool and ensure to make fine surface finish.

Now send the repaired casting for next process of machining or powder coating or zinc chromating or painting etc as needed.

#### **NON-WARRANTY:**

We can accept no responsibility or liability for lack of results because the storage, handling, and application of the compound is beyond our control.

**PL CALL IN YOUR LOCAL AUTHORISED DEALER TO GET FULL ADVANTAGE OF PRODUCT TRAINING AND KNOW HOW TO MAKE MORE USE OF HY POXY PRODUCTS.**



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