



MIX2FIX[®] LV Steel

(formerly PSI-367 Steel-filled Epoxy Paste)

Product description

MIX2FIX LV Steel is a two-component, steel-filled, non-sag, epoxy adhesive that cures in a matter of minutes. It has excellent adhesion to a variety of materials including metals, concrete, wood, ceramics, and many plastics. Just one hour after application MIX2FIX LV Steel can be drilled, tapped, filed, and sanded.

Basic uses

MIX2FIX LV Steel is ideal for adhesive or sealing applications requiring easy spreadability, rapid cure and high hardness. It seals leaks; fills holes, pits and cracks; makes an excellent thread lock; can be used for anchoring machines; is useful as a general-purpose adhesive to repair practically anything.

Benefits

- Exceptionally strong and hard once cured.
- Excellent adhesion to a wide variety of substrates.
- Solvent free with no volatile components.
- Will not shrink upon curing.
- Fast curing.

Application limitations

- Does not adhere to PTFE, polyethylene, or polypropylene.
- Becomes very hot during cure; do not mix more than 8 oz. (224g) total at one time, i.e. 4 oz. (112g) each of Part A and Part B.
- See performance data for temperature limits.
- Do not apply at temperatures below 41°F (5°C).
- Not intended for use in structural applications.

Color

Cured color is Steel Gray.

Packaging

Available in 2-lb. kits (1 lb. [455g] of each part) and 2-US-gallon kits (1 gallon [3.79 liters] of each part) in a 2-gallon pail.

How to use

Surface preparation: To achieve optimum adhesion, surfaces should be free of grease or

dirt. Scuffing or sanding the surface prior to cleaning helps insure a good bond.

Mixing and application: Wear impermeable gloves when mixing or handling uncured product. Measure out equal amounts of resin and hardener by weight or volume, using different utensils for each to avoid contamination. Use only the amount needed for the job at hand. Do not mix more than 8 oz. (224g) total at one time, i.e., 4 oz. (112g) each of Part A and Part B. Material may become hot during cure.

Mix together until a uniform gray color is achieved. Apply to clean, preferably abraded surfaces within 3 minutes of mixing. Remove excess material before product begins to set. Worklife is 5 minutes.

Allow MIX2FIX LV Steel to harden until a strong bond has formed, normally about 60 minutes, depending on the nature of the application. Product cures faster at higher temperatures and larger volumes, and slower at lower temperatures and in thin sections. After 1 hour the application can be tapped, drilled, filed and sanded. Full cure is reached in 24 hours.

Shelf life: One year from date of shipment when stored in original, unopened containers at 75°F (24°C).

Health precautions

- Contains Epoxy Resin. Epoxies are skin/eye irritants and known sensitizers. Direct product contact may cause an allergic reaction in some individuals. Avoid skin/eye contact. Wear impermeable gloves when mixing or handling uncured product.
- Inhalation of dust may be harmful. Avoid inhalation of dust. Wear dust mask and protective eyewear when sanding cured product.
- Ingestion of product may be harmful. Avoid ingestion.
- KEEP OUT OF THE REACH OF CHILDREN.

For additional health and safety information, consult a Safety Data Sheet.

Performance Data*		
Properties	Results	Test Methods
Uncured Properties		
Composition	Steel-filled epoxy resin	
Physical appearance	Paste	
Odor (hardener)	Strong sulphurous smell (no odor when cured)	
Mix ratio by weight and volume	1:1	
Viscosity	750,000 cps	
Mixed density	14.1 lb/gl (1.7 g/cm ³)	
Maximum thickness in one pass	<0.47 in (12 mm)	
Application temperature	50 to 95°F (10 to 35°C)	
Work life at 75°F (24°C)	5 minutes	
Handling time at 75°F (24°C)	1 hour	
Return to service time at 75°F (24°C)	24 hours	
Cured Mechanical Properties		
Physical appearance when cured	Steel-gray solid	
Hardness, Shore D	75	ASTM D2240
Tensile strength	4,750 psi (33 MPa)	ASTM D925
Lapshear tensile adhesive strength		
Steel to steel	1,750 psi (12 MPa)	ASTM D1002
Compressive strength	7,250 psi (50 MPa)	ASTM D695
Temperature limits		
Continuous	-40°F to +250°F (-40°F to +121°C)	
Intermittent	-40°F to +300°F (-40°F to +149°C)	
Chemical resistance	Resistant to hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, dilute acids and bases	
* Typical properties are for information only, not for purposes of specification. The data above represents product performance in ideal laboratory conditions. Individual users' experience may vary depending on application conditions.		

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