



# PSI-326

## Fast Cure Epoxy Repair Compound

**Product description**

PSI-326 is a low-odor, two-component, modified epoxy adhesive that cures rapidly at room temperature with exceptional tensile adhesion and peel strength to a wide variety of substrates. In just a few minutes PSI-326 forms a tough bond without the need for clamping. Thin sections may take somewhat longer.

**Basic uses**

PSI-326 may be used as a general purpose adhesive to bond wood, metal, fiberglass, glass, ceramics and many hard plastics. It forms a water-resistant bond and is tough enough to be drilled, tapped, filed or sanded after final cure.

**Benefits**

- Contains no volatile solvents and does not shrink upon curing.
- High peel strength and impact resistance for both industrial and household repairs.
- Fast curing.
- Thixotropic.

**Application limitations**

- Does not adhere to PTFE, polyethylene or polypropylene.
- Becomes very hot during cure; do not mix more than 0.5 lbs. (225 kg) at one time.

- Maximum temperature range is 250°F (121°C) continuous, 300°F (149°C) intermittent.
- Not intended for structural applications.

**Color**

Clear/transparent.

**Packaging**

Available in job-size 3 gm. SUM PAKs and 2 lb. (90 kg) kits (see heat warning under **Mixing**). Special packaging available upon request.

Performance Data*		
Properties	Results	Test Method
<b>Uncured Properties</b>		
Form	Two-part gel	
Consistency	Thixotropic paste	
Final mixed color	Translucent/straw	
Density	1.17 gm/cm <sup>3</sup> 9.76 lb/gal	
Work life, 3 grams at 75°F (24°C)	4 to 6 minutes	
Non-volatile content	100%	
Cure time to lap shear tensile strength=500 at 75°F (24°C)	60 to 90 minutes	ASTM D1002
Cure time to full cure at 75°F (24°C)	16 to 24 hours	
<b>Cured Mechanical Properties</b>		
Hardness, Shore D	60	ASTM D2240
Tensile strength	5,000 psi	ASTM D638
Lapshear tensile adhesive strength		
Steel to steel	1,000 psi	
Aluminum to aluminum	1,100 psi	
Glass to glass	>100 psi	
Compressive strength	12,000 psi	ASTM D695
Shrinkage	<1%	ASTM D2566
Upper temperature limits		
Continuous	250°F (121°C)	
Intermittent	300°F (149°C)	
<b>Cured Electrical Properties</b>		
Insulation resistance	30,000 megohms	ASTM D257
Volume resistivity	10 <sup>12</sup> ohm-cm	ASTM D257
Dielectric strength	300 volts/mil	ASTM D149
Arc resistance	50 seconds	ASTM D495

*\* Typical properties are for information only, not for purposes of specification.*

## Application

**Surface preparation:** To achieve optimum adhesion, surfaces should be dry and free of grease or dirt. Scuffing or sanding the surface prior to cleaning helps insure a good bond.

**Mixing and application:** Mix one part A with one part B by weight or volume until uniform. Do not mix more than 0.5 lbs. total (0.25 lbs. Part A and 0.25 lbs. Part B) at one time. Material becomes very hot during cure. Use within 3 minutes of mixing. See **Performance data** on reverse side. The use of Polymeric Systems' SUM PAK makes mixing and applying PSI-326 substantially easier. Please consult the SUM PAK data sheet for more information.

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

## Availability and cost

Polymeric Systems, Inc., is a part of Whitford Worldwide. For more information, please contact Polymeric Systems or Whitford Plastics Ltd. at:

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## Health precautions

- May irritate sensitive skin. Wash hands with soap and water after use.
- Eye irritant. In case of eye contact, flush with water and contact physician.
- May be harmful if swallowed.
- Keep out of reach of children.
- When sanding cured epoxy or substrate, use protective eyewear and dust mask.

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

NON-WARRANTY: ALL RECOMMENDATIONS, STATEMENTS AND TECHNICAL DATA CONTAINED HEREIN ARE BASED ON TESTS WE BELIEVE TO BE RELIABLE AND CORRECT, BUT ACCURACY AND COMPLETENESS OF SAID TESTS ARE NOT GUARANTEED AND ARE NOT TO BE CONSTRUED AS A WARRANTY, EITHER EXPRESS OR IMPLIED. USER SHALL RELY ON HIS OWN INFORMATION AND TESTS TO DETERMINE SUITABILITY OF THE PRODUCT FOR THE INTENDED USE, AND USER ASSUMES ALL RISK AND LIABILITY RESULTING FROM THIS USE OF THE PRODUCT. MANUFACTURER'S SOLE RESPONSIBILITY SHALL BE TO REPLACE THAT PORTION OF THE PRODUCT OF THE MANUFACTURER THAT PROVES TO BE DEFECTIVE. MANUFACTURER SHALL NOT BE LIABLE TO THE BUYER OR ANY THIRD PARTY FOR INJURY, LOSS OR DAMAGE DIRECTLY OR INDIRECTLY RESULTING FROM USE OF, OR INABILITY TO USE, THE PRODUCT. RECOMMENDATIONS OR STATEMENTS OTHER THAN THOSE CONTAINED IN A WRITTEN AGREEMENT SIGNED BY AN OFFICER OF THE MANUFACTURER SHALL NOT BE BINDING UPON THE MANUFACTURER.

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