

SELECTION & SPECIFIC DATA**Generic Type** Epoxy Paste**Description**

PANSEAL Paste is a unique, multi-component, trawlable epoxy designed for use as a lap weld feathering product for steel tanks. It is often used in conjunction with chemical resistant topcoats such as PANSEAL or ELASTASEAL. PANSEAL Paste has excellent chemical resistance to a wide range of petrochemical products, fuels, organic/inorganic acids & alkalis. It's long re-coat window allows it to be top-coated up to 14 Days, depending on temperatures. PANSEAL Paste is comprised of 100% solids and contains no VOC's. PANSEAL Paste's excellent adhesion properties allow it to bond to steel, concrete and iron even when coating conditions are less than ideal. Typical applications include leak repair, wastewater tanks, lift stations, wet wells, manholes, storage tanks cooling tower repair, anchor adhesive, plate bonding, pump casting and serves as a high strength structural adhesive for metal bonding. PANSEAL Paste is ideal for filling voids in concrete, strengthening damaged surfaces and vertical applications due to it's thick viscosity. PANSEAL Paste can be sanded, drilled, tapped or machined.

PANSEAL Paste Models

Model #	Description
2500PG	PANSEAL Paste Gallons (1 gallon kit - resin/hardener)
2500CTR	PANSEAL Paste Containers (315g)

* Other sizes/amounts available on request.

Product Features & Benefits

- *Immediately seals leaks, cracks on damaged surfaces*
- *Thick viscosity - Ideal for vertical repairs, filling voids and ceiling work*
- *Easy to apply with a trowel*
- *Bonds chemically and mechanically to substrate*
- *Works on metal, fiberglass, stainless steel, concrete and wood surfaces*
- *NO VOCs, 100% solids and entirely and free of solvents*

Recommended Uses

- *Wastewater and Storage Tanks*
- *Cooling Tower Repair and Structural Metal/Concrete Repair*
- *Structural Adhesive for Metal Bonding*
- *Resurfacing Damaged Areas*
- *Filling Voids, strengthening structures*

Color/Part #	Gray/2500PG
Finish	Matte
Primer	Self-priming
Solids Content	By Volume 100%
Theoretical Coverage Rate	2 sq. ft at 800 mils
Dry Time	Dry Times (ASTM D1640), 25 – 30 mils DFT
Tack Free Time	3.5 hours at 25°C (77° F)
Dry Hard Time	8 hours at 25°C (77° F)
Container Size	1 gallon

SUBSTRATES & SURFACE PREPARATION**General**

Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminant.

Primer

Self priming on most surfaces, but apply Dynesic's DX-1100 Primer prior to top-coat on concrete surfaces.

- **Metal, Galvanized** Depending on the surface's condition, pressure washing may be all that's necessary, or scrubbing with degreasers such as Dynesic's DX-ETCH to ensure there are no oils, greases or acids remaining on the surface. In more extreme conditions, or depending on surface type obtaining an etched surface results in optimum adhesion. If cleansers are used, make sure to rinse off all chemicals prior to coating.
- **Stainless Steel** Topcoat products have a difficult time adhering to slick surfaces, however, PANSEAL's 2750 psi adhesion strength allows it to fully adhere to stainless steel. An etched profile can be achieved by sand blasting or grinding. Keep in mind that an etched, rather than a polished profile is the goal.
- **Concrete/CMU** Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing with PANSEAL Paste (2500PG) to fill and strengthen the substrate. Prime concrete surfaces first with Dynesic DX-1100 Concrete Primer.

- Fiberglass, Wood Clean and apply.

* For previously painted surfaces contact Dynesic Technical Service Department.

CHEMICAL RESISTANCE

Acetic Acid 10%	Alkalis	Ammonium Hydroxide 25%	Brine Water
Caster Oil	Copper Sulfate	Crude Oil	Diesel Fuel
Ethanol	Ethylene Glycol	Fatty Acids	Fresh, or Non-Potable Water
Gasoline	Hydrochloric Acid 20 %	Mineral Spirits	Potassium Hydroxide 50%
Sewage	Sodium Chloride	Sodium Hydroxide 50%	Sulfuric Acid 75%
Wine			

MIXING & THINNING

Mixing Power mix part A (resin) separately, then add part B hardener and power mix.

Thinning Up to 8% w/ Acetone or Xylene

**Use of thinners other than those supplied or recommended by Dynesic may adversely affect product performance and void product warranty, whether expressed or implied.*

Ratio 3:1 Ratio (A to B) by Volume

Pot Life 45 minutes in 8 fl oz mass at 25°C (77°F)

**Do not keep the blended coating in the original container unless immediate use is planned. Otherwise, exothermic heat created during the curing process will considerably shorten the pot life. Pour the coating into a rolling tray or empty the material directly on the surface. Try to keep the depth of the coating in the tray below 3/8".*

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Application (General)

PANSEAL Paste is a 100% solids coating and may require adjustments in application techniques. Apply directly onto the prepared surface with a trowel or spatula tool. Press down firmly to remove entrapped air, fill all cracks, and ensure maximum contact with the surface. PANSEAL Paste Grade is fully machinable using conventional tools once cured and can be sanded.

Brush & Roller

A brush or roller can be used to smooth uncured surface with solvent if desired.

CLEANUP & SAFETY

Cleanup

Use MEK or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety

Read and follow all caution statements on this product data sheet and on the SDS for this product. Wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

PACKAGING, HANDLING & STORAGE

Shelf Life 24 months at 75°F (24°C)

** When kept at recommended storage conditions and in original unopened packaging.*

Shipping Weight (Approximate)

- 1 Gallon Kit: 12 lbs. (5.45 kg)
- 4 Gallon Kit: 50 lbs. (22.73 kg)
- 50 Gallon Drums: Part A 700 lbs./Part B 450 lbs.

Storage Temperature & Humidity

40° - 110°F (4° - 43°C)
0 - 100% Relative Humidity

Storage

Store Indoors. This product is not affected by excursions below these published storage temperatures, down to 10°F, for a duration of no more than 14 days.

PERFORMANCE DATA

TEST METHOD	SYSTEM	RESULTS
ASTM D-4541 Dry	Blasted Steel 1 ct.	>2,850 psi
Flash Point	Greater than 250°F (121°C)	
Specific Gravity	Part A : 1.36	Part B : .82
VOC lbs/gallon	0 grams/liter	
Weight per gallon	Part A 11.29	Part B 6.81
Dry Service	250°F (121°C)	
Splash/Spill	200°F (93.3°C)	
Immersion Service*	150°F (65°C)	

CURE SCHEDULE & RE-COAT WINDOW

<u>TEMPERATURE</u>	<u>MINIMUM RE-COAT</u>	<u>MAXIMUM RE-COAT</u>
10°C (50°F)	12 hours	14 days
25°C (77°F)	3 hours	14 days
60°C (140°F)	1 hour	7 days

DYNESIC TECHNOLOGIES

Dynesic produces exceptional chemically engineered coatings, adhesives and sealants offering premium corrosion protection, while being safe for the environment and safe/easy to apply. Dynesic Technologies can be found protecting steel, ductile and concrete substrates worldwide.



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