

ATOMA®

AT-231 4 MINS STEEL EPOXY



TECHNICAL DATA SHEET

Ver.01 | 29 Aug 2025

AT-231 4 Mins Steel Epoxy is steel filled fast setting gray colour epoxy adhesive. It offers good gap-filling capabilities and slumping characteristics. It has temperatures resistance up to 120°C and is pressure resistant. It is very useful for emergency repairs in industries, workshops, marine, automotive, construction and also for household use. After cured, it can be drilled, sanded, and painted. It contains no solvent or VOC, not flammable and no shrinkage after cure.

FEATURES

- ◆ Paintable
- ◆ Non-shrinkage
- ◆ Steam and heat resistance
- ◆ Fast setting within 4 minutes
- ◆ Easy to use, one to one mixing ratio
- ◆ Strong bonding strength when hardened
- ◆ Water, solvent, acid and alkaline resistance
- ◆ Can be sanded, filed, drilled, tapped or threaded when hardened

USES

- ◆ Permanent repair: leaks, holes, cracks, mounting signs to walls.
- ◆ Suitable substrates: metal, fiberglass, concrete, ceramics and some plastic materials.

Due to a large variety of different coatings and substrates, we recommend preliminary compatibility tests prior to application to achieve desirable results.

NOT RECOMMENDED FOR

PE, PP and PTFE.

APPLICATION

- ◆ Puncture the tube with the cap and squeeze out equal amount of resin and hardener.
- ◆ Mix homogenously until mixture gets uniform colour.
- ◆ Apply it on clean surface within 3 minutes.
- ◆ For best adhesion, roughen the surface.
- ◆ Replace cap after use and store in cool, dry place.

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SPECIFICATION

Colour	Resin	Black
	Hardener	White
Specific Gravity	Resin	1.77 ± 0.05
	Hardener	1.60 ± 0.05
Viscosity	Resin	475 ± 125K cP
	Hardener	375 ± 125K cP
Mixing Ratio, A:B		1:1
Appearance		Paste form
Work Life (minutes at 25°C)		3 – 4
Curing Time (minutes at 25°C)		4 – 5
Hardness (Shore D)		Minimum 80
Temperature Limits		15°C to 120°C
Non-volatile Content		100 %
Lap Shear Strength (kg/cm ²)		Minimum 90
Shelf Life		24 months

STORAGE

Shelf life is subjected to change due to the type of packaging used and the condition of the environment. Material should be stored in a dry and cool place between +5°C to +30°C.

CAUTION

Normally, while mixing by hand it does not cause any skin irritation, but in some cases with sensitive skins, it may cause irritation or sensitization. In such cases, wash the hands with plenty of water and soap and use hand gloves for application.

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