



pasty  
bronze-filled

WEICON BR is particularly suited for filling in blowholes and for repairing and rebuilding bronze equipment parts and castings.

WEICON BR can be used in tool construction, model and mould making, and in many other industrial applications.

### Technical data

Composition	Epoxy resin bronze-filled
Specific Properties	pasty
Mixing ratio by weight % (Resin/Hardener)	100:100
Pot-life at +20 °C (200 g preparation)	60 Min.
Density of the mixture	1,80 g/cm <sup>3</sup>
Viscosity of the mixture	650.000 mPa·s
Max. layer thickness per application	12 mm
Cure time mechanical loads	16 h
final hardness	24 h
Mean compressive strength (+25 °C) acc. to DIN 53281-83	95 MPa
Mean tensile strength (+25 °C) acc. to DIN 53281-83	29 MPa
Mean Flexural strength (+25 °C) acc. to DIN 53281-83	35 MPa
Mean strength E-Modul (+25 °C) acc. to DIN 53281-83	2.500 - 3.000 MPa
Shore D (+25 °C) acc. to DIN 53281-83	75
Shrinkage	0,02 %
Thermoforming resistance	50 °C
Colour	bronze
Temperature resistance	-35 bis +120 °C

### Pretreatment of the surface

The surface to be treated or filled up must be clean (metallic clean), dry and free of grease. The same applies to the working tools and mixing vessels. To improve the adhesion, surfaces should be roughened, especially when they are smooth. WEICON Cleaner S or WEICON Sealant and Adhesive Remover help to remove almost all residues. If necessary, sand blast in addition.

Cast parts which have been exposed to sea water for a long time should be treated with special care as they might contain inorganic salts. It is possible that these salts reach the surface and absorb moisture, thus starting rust formation (rust bubbles under the protective coating). We therefore recommend to heat or flame the surface after sand blasting. If adhesion with the ground is not desired, a separating

agent must be applied. For smooth surfaces e.g. WEICON Mould Release Agent F 1000(silicone-free). For porous surfaces WEICON Mould Release Agent Wax P 500.

### Processing

Before adding the hardener, it is absolutely necessary to stir up the fillers in the resin component thoroughly (exceptions: Epoxy Resin Putty and Casting Resin MS 1000).

Thoroughly mix the components for at least 4 minutes (type SF: 2-3 minutes) to get a uniform mixture. Avoid the formation of bubbles. Do not mix more than you are able to use within the pot life. If container is partly used, it is to be kept tightly closed. Strictly observe the specified mixing ratio (tolerance max. +/- 2%).

The quoted pot life times refer to mixtures of approx. 200 g. Larger quantities will cure faster due to the typical heat reaction of epoxy resins (exothermal reaction). WEICON Plastic Metals should be used at room temperature (approx. 20 °C). Pot life and cure time will be reduced at higher temperatures. (Rule of thumb: Every increase of 10 °C above room temperature leads to a reduction of pot life and cure time by 50%). At temperatures below +16 °C, the pot life and cure time will slow down; below approx. +5 °C no reaction between resin and hardener will take place any more.\* Depending on the type, WEICON Plastic Metal can be machined or demoulded after 2 hours (min.) resp. 16 hours (max.) at room temperature. Final cure of all types is reached after 24 hours (at room temperature). Only the type Weidling C should afterwards be temper-hardened step by step. In low temperature environments the cure time can be speeded up by the influence of heat, max. +40 °C (heat lamp, hot air fan). Do not use open flame!

\* To achieve a permanently high temperature resistance, we recommend to temper-harden after 48 hours as detailed below:

Type Weidling C

2 h at +40 °C, 2 h at +60 °C, 2 h at +80 °C, 2 h at +100 °C, finally 14 h at +120 °C

Types WEICON Ceramic W and WEICON TI

3 h at +50 °C, 2 h at +90 °C, 2 h at +130 °C, finally 1 h at +170 °C

### Storage

WEICON Plastic Metal at room temperature (but up to max. +25 °C) in a dry place. Unopened containers can be stored for 18 months at temperatures from +18 °C to +25 °C (Epoxy Resin Putty max. 3 years). Opened containers should be used within 6 months.

### Note

Any product specifications and recommendations given herein must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do warrant the continuously high quality of our products being free from defects in accordance with and subject to our General Sales Conditions. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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## Health and Safety

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

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