Approvals and conformities

MS-26 APPROVALS	MIL S 83474, HMS 1068C49, HP 16-25, HP 10-7, STM 22-605, 7614-947941, MS-277, NSN 8040-01-392-4964

MS-26 moldable shims are filled epoxy resin compounds used to shim gaps in metal or composite assemblies. Originally developed for use in airframe assemblies, the moldable shims are now used in a wide variety of equipment alignment applications as well as land, air and sea applications.

Packaging sizes:
Two part (room temperature storage)

- 1 lb (pt.), 3 lb (qt.), 10 lb (gal.) - Kits
- 200 g sem-kit/tech-kit mix in tube
- Field kits (100 g / 50 g) with premeasured catalyst

USES

- Shimming gaps and offsets at the assembly level (metal and composites)
- Cast in place shim, forming complex contours on parts machined undersize at detail level
- As a layer, over rough machined parts, eliminating finish machining
- Close tolerance molding to produce accurate and identical parts
- Repair of dents, holes and faring applications
- Economical correction of tooling
- Alignment of heavy machine or motor parts
- Alignment of propulsion systems (marine applications, chocking)

DIRECTIONS FOR USE

APPLICATION OF MS-26 TWO-PART SYSTEM

- Estimate the amount of shim material needed for the job.
- Weigh into a container that can be heated, to the nearest gram, the base material needed.
- Heat the weighed base material to room temperature 75-80ºF (24-27ºC).
- While base material is warming, weigh into an inert container the proper amount of catalyst for the warming base material:
    - MS-26: 2.2 parts catalyst per 100 base material
- When base material has reached desired temperature, add measured amount of catalyst material and mix thoroughly. The MS-26 Moldable Shim Material is now ready for use.
- Application time is approximately 45 minutes depending on the temperature of the material and the temperature of the substrate to which it was applied.
- If a bubble-free mixture is required, the mix (base material and catalyst mixture) can be centrifuged for three minutes at 1500 rpm @ 75-80ºF (24-27ºC).

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- MS-26 is designed for room temperature cure, however, cure can be accelerated by moderate heating. Maximum properties can be obtained by heating to 120ºF (50ºC) for a period of two hours.

MS-26 can also be supplied in 50 and 100 g. field kits. It comes packaged in an aluminum “rip top” can with the pre-measured amount of catalyst packaged in a disposable syringe. To use the field kits, warm the base material to 75-80ºF (24-27ºC). Remove the “rip top” lid and empty the contents of the pre-measured syringe into the base material and mix thoroughly with the supplied spatula.

TECHNICAL CHARACTERISTICS

Product Name	Application Time at 75ºF (23ºC)	Assembly Time at 75ºF (23ºC)	Drill Time	Cure Time	Shelf Life & Storage Two Part System
MS-26	5-6 H	7-8 H	80 H at 75°F (23°C) or 20 H at 100°F (38°C)	100 H at 75°F (23°C) or 2 H at 180°F (82°C)	1 year at 40-100°F (4-38°C)

Property	Standard Method	Value
Block compression/ultimate (psi)	ASTM D695	75°F (23°C) 24,500
		250°F (121°C) 16,000
		350°F (176°C) 9,000
		420°F (215°C) 7,000
Flatwise compression (psi)	MIL S 83474	75°F (23°C) 103,700
		250°F (121°C) 52,800
		350°F (176°C) 45,700
		420°F (215°C) 22,200
Lap shear Aluminum (psi)	ASTM D1002	75°F (23°C) 2,700
		250°F (121°C) 2,000
		350°F (176°C) 18,000
		420°F (215°C) 1,100
Hardness Shore D	ASTM D2240	92
Specific Gravity		<1.60

PRECAUTIONS FOR USE AND STORAGE

For more information regarding the danger of the product, please consult the product safety data sheet according to local regulation.
For professional use only.

This technical data sheet replaces and cancels the previous one.

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