

EPO DYNAWEIGHT / BAL FAMILY

Customer Standard Operating Procedure

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Products Covered	EPO Dynaweight, BAL I, BAL VI and BAL XV

1. Product Description

EPO Dynaweight, BAL I, BAL VI and BAL XV are two-component epoxy putty balancing compounds designed for precision balancing, repair and placement applications.

These products are hand mixed and do not follow the standard mechanical-mixing procedure used for most Dynamis epoxy products.

2. Storage

- Store between 70°F and 85°F.
- Protect from freezing.
- Keep containers tightly closed when not in use.
- Use material within the stated shelf life shown on the product documentation.

3. Surface Preparation

The application surface must be clean, dry and free of oil, grease, dirt, dust and loose contamination. Light sanding is recommended when additional mechanical adhesion is desired.

4. Mixing

IMPORTANT: Hand mix only. Do not mechanically mix and do not shake.

- Remove equal parts by volume of Part A and Part B.
- Hand knead the components together until the material is completely uniform in color.
- Continue mixing until no streaks remain.
- The mixing endpoint is uniform color, not a fixed mixing time.

Product	Uniform Mixed Color
EPO Dynaweight	Medium Gray
BAL I	Purple
BAL VI	Pink
BAL XV	Orange

5. Application

- Lightly wet your finger, glove, spatula or placement tool with clean water before pressing the material into place.
- Do not add water to the epoxy itself.
- Press the mixed material firmly against the prepared substrate.
- Shape and smooth the material immediately after placement.

Wetting the application surface of the tool helps prevent sticking and permits smoother placement. Water is used only as a release aid on the glove or tool.

6. Working and Cure Times

Product	Working Time	Approximate Set Time
EPO Dynaweight	2-2.5 hours	Approximately 12 hours
BAL I	45-60 minutes	Approximately 90 minutes
BAL VI	2-2.5 hours	Approximately 12 hours
BAL XV	15-20 minutes	25-30 minutes

Full chemical cure for all products is seven days. Actual working, set and cure times may vary with temperature, material temperature, batch size and application conditions.

7. Optional Warming and Heat Cure

- Standard EPO Dynaweight and BAL VI may be heat cured when the application permits.
- If Part B becomes stiff because of cold storage, warm Part B only in short intervals of no more than 15 seconds until workable.
- Do not microwave mixed material.
- Avoid overheating. Heated material may cause burns and will react faster.

8. Quality Checklist

- ☐ Correct product selected for the required working time.
- ☐ Matching Part A and Part B used.
- ☐ Equal parts measured by volume.
- ☐ Material mixed to a completely uniform color with no streaks.
- ☐ Application surface clean and dry.
- ☐ Glove or placement tool lightly wetted with clean water only.
- ☐ Material pressed firmly into place.
- ☐ Adequate set and cure time allowed before handling or service.

9. Critical Rules

- **Hand mix only.**
- **Use equal parts by volume.**
- **Mix until the color is completely uniform.**
- **Do not shake.**
- **Do not add water to the epoxy.**
- **Water may be used only to wet the application tool, glove or finger.**
- **Use only matching Part A and Part B.**
- **Allow adequate set and cure time before placing the part into service.**

10. Safety and Technical Support

Review the current Safety Data Sheet before use. Wear appropriate personal protective equipment and follow applicable workplace safety requirements. For unusual substrates, operating temperatures, rotational speeds or cure requirements, contact Dynamis Epoxy before application.

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