

104 Metal Repair Fluid XF

Fast curing solvent free epoxy repair fluid
Applied at 2-3mm (80-120mil) per coat
Fully machineable once cured

Cure Times

At 20°C (68F°) the product will have the following cure times –

Usable Life	5mins
Touch dry	45mins
Machining / light loading	2 hours
Full cure	8 hours

Coverage Rates

800gm (lb) of fully mixed product will give the following coverage rates –

0.444m ² at 1mm	5.9ft ² at 40mil
0.222m ² at 2mm	3ft ² at 80mil
0.148m ² at 3mm	2ft ² at 1/8"

Colour

Mixed material – Light Grey
Base component – Black
Activator component –White

Over-coating times

Minimum - as soon as it is touch dry.

Maximum - the over-coating time should not exceed 4 hours.

Typical Applications

Plate bonding
Anti-slip coating (with aggregate)
Seal leaking oily surfaces
Seal leaking tank seams
Wrap leaking pipes

Technical specifications and characteristics

Mixing ratios	By weight	1 to 1
	By volume	1 to 1
Volume capacity	Metric	555cc/kg
	Imperial	33.8cu in/1.8lb

Surface Preparation

104 Metal has been designed to be applied to surfaces with less than ideal surface preparation.

Mechanical tools, use a handheld mechanical grinder with a coarse grinding pad or rotary wire brush. Ensure all loose material and as much surface contamination is cleaned from the surface. **DO NOT POLISH THE SURFACE, ENSURE THAT THE SURFACE HAS A CROSS HATCH PATTERN.**

MBX bristle blaster, for the best mechanical surface preparation results use an MBX bristle blaster. Ensure all loose material and as much surface contamination is cleaned from the surface.

Leaking transformer surfaces – to repair a weeping/ leaking transformer surface mixed 104 Metal Repair Fluid must be applied within 10-15 seconds of the surface being cleaned. **DO NOT ABRABE THE SURFACE WITH ANY MECHANICAL TOOLS.** If possible use a wire brush to take off any loose corrosion or coating, then wipe the surface with a solvent wipe and take away as much excess oil as possible. Then apply the mixed material to the surface using the applicator tool provided.

Mixing and Application

STEP 1

Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula, 1 applicator, 1 x clean mixing area.



STEP 2

Take equal measures of base and activator material, clean the spatula between measures.



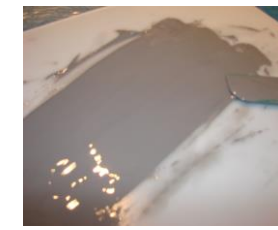
STEP 3

Mix the two components using the spatula provided, ensure any unmixed material around the edges is mixed.



STEP 4

The material must be a consistent light grey. Wipe away any unmixed material from the mixing surface.



STEP 5

Once the material is fully mixed use the applicator tool provided to apply the metal repair paste to the surface.

