Quick application guide

106 Metal Repair Paste XF

Fast curing solvent free epoxy repair paste
Applied at 20mm without slumping
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	1 day

Coverage Rates

500gm (1.1lb) of fully mixed product will give the following coverage rates –

0.277m² at 1mm	3ft² at 40mil
0.139m² at 2mm	1.5ft² at 80mil
0.092m² at 3mm	1ft² 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 3 hours.

Typical Applications

Damaged pump shafts
Cracked pump or valve casings
Damaged flanges
Leaking tank seams
Cracked engine blocks
Plate Bonding

Technical specifications and characteristics

Mixing ratios	By weight	1 to 1
	By volume	1 to 1
Volume capacity	Metric	278cc/500gm
	Imperial	16.8cu in/1.1lb

Surface Preparation

Ideal surface preparation for this material is abrasive blast cleaning to ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2) and with a minimum blast profile of 75 microns using an angular abrasive.

However this product has been designed for surfaces with less than ideal surface preparation –

Hand tools, use a wire brush or coarse sand paper to abrade the surface.
Mechanical tools, use a handheld mechanical grinder with a coarse grinding pad or rotary wire brush. 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.

Ensure the repair surface is wiped with an appropriate solvent cleaner such as MEK after abrading the surface.

Mixing and Application

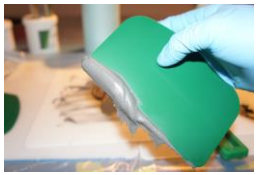
STEP 1
Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula, 1 applicator, 1 x clean mixing area.

STEP 2
Take equal measures of base and activator materials, ensure the spatula is clean.

STEP 3
Mix the two components using the spatula provided, ensure any unmixed material around the edges is mixed.

STEP 4
To ensure the product is fully mixed create a diamond pattern on the surface and look for any areas which are not mid grey in colour.

STEP 5
Once the material is fully mixed use the applicator tool provided to apply the metal repair paste to the surface



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