Quick application guide

resimac Ltd.

107 Metal Repair Paste XL

Solvent free epoxy repair paste
Extended working life
Fully machineable once cured

Cure Times

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

Usable Life	60mins
Touch dry	5 hours
Machining / light loading	12 hours
Full cure	7 days

Coverage Rates

4kg (2.2lb) of fully mixed product will give the following coverage rates –

1.552m² at 1mm 16.7ft² at 40mil
0.776m² at 2mm 8.35ft² at 80mil
0.517m² at 3mm 5.56ft² at 1/8”

Colour

Mixed material – Dark grey
Base component – Dark grey
Activator component –Light grey

Over-coating times

Minimum - as soon as it is touch dry.

Maximum - the over-coating time should not exceed 6 hours.

Typical Applications

Worn or damaged pump shafts
Cracked pump or valve casings
Scored hydraulic rams
Worn bearing housings
Damaged flanges
Leaking tank seams
Worn keyways
Cracked engine blocks
Plate bonding

Technical specifications and characteristics

Mixing ratios	By weight	1.7 to 1
	By volume	3 to 2
Volume capacity	Metric	1552cc/4kg pack
	Imperial	94.7cu in/8.8lb

Surface Preparation

All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK.

For optimum performance, the surface should be abrasive blasted to ***ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)*** and a minimum blast profile of 75 microns using an angular abrasive.

PLEASE NOTE: For salt contaminated surfaces the area must be abrasive blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After this 24 hour period the surface must be washed prior to brush blasting to remove the surface salts.

In the case of cracked surfaces, the cracks should be stabilised by drilling the termination points and the cracks veed out and drilled, tapped and bolted every 75-100 mm (3-4”)

Where abrasive blast cleaning is not possible (excluding salt contaminated surfaces) the surface should be roughened by MBX, needle gun or grinding.

Mixing and Application

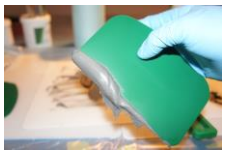
STEP 1
Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula, 1 applicator, 1 x clean mixing area.

STEP 2
Take equal 3 equal measures of base material, clean the spatula, then take 2 measure of the activator.

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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