# resimac Ltd.

# 107 Metal Repair Paste XL

- Solvent free epoxy repair paste
- Extended working life for warmer climates
- Apply at thicknesses up to 25mm

## **Cure Times**

At **30°C (86F°)** the product will have the following cure times – **Usable Life** 30mins

Machining and light loading 2 hours

Maximum overcoating time

6 hours 3 days

# **Coverage Rates**

4kg (8.8lb) of fully mixed product will give the following coverage rates –

1.624m² at 1mm 17.2ft² at 40mil 0.812m² at 2mm 8.8ft² at 80mil 0.540m² at 3mm 5.8ft² 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 at **30°C** (86F°).

# **Typical Application**

Worn 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**

### Metallic Substrates – Mechanical abrasion

- All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
- All surfaces must be mechanically abraded using handheld grinders to ISO 8501/4 ST3 (SSPC SP3 ST3).
- Once abraded, the surface must be degreased and cleaned using MEK or similar type material.
- 4. All surfaces must be coated before gingering or oxidation occurs.

### Metallic Substrates – Abrasive blast cleaning

- All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
- All surfaces must be abrasive blasted to ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2) minimum blast profile of 75 microns (3mil) using an angular abrasive.
- Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material.
- 4. All surfaces must be coated before gingering or oxidation occurs.

PLEASE NOTE: For salt contaminated surfaces the substrate must be pressure washed with clean water and checked for salt contamination, please refer to the surface preparation and pre-application quide for further information.

# **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.



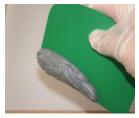
### STEP 4

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 107 metal repair paste XL to the surface.



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