

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
Machining	45mins
Maximum Overcoating	4 hours
Full cure	4 hours

Coverage Rates

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

0.277m ² at 1mm	3ft ² at 40mil
0.139m ² at 2mm	1.5ft ² at 80mil
0.092m ² at 3mm	1ft 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

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

Metallic Substrates – Hand tools

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be cleaned using wire brush, metal file, coarse sandpaper etc.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.

Metallic Substrates – Mechanical tools

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded using handheld grinders to **ISO 8501/4 ST3 (SSPC SP3 ST3)**.
3. 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

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

