# Quick application guide

## 101 Metal Repair Paste

**Solvent free epoxy repair paste**
**High build capability 20mm without slumping**
**Fully machineable once cured**

### Cure Times

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

| | |
|---|---|
| **Usable Life** | 30mins |
| **Touch dry** | 1.5 hours |
| **Machining / light loading** | 2 hours |
| **Full cure** | 2 days |

### Coverage Rates

1kg (2.2lb) of fully mixed product will give the following coverage rates –

| | |
|---|---|
| 0.406m²at 1mm | 4.3ft² at 40mil |
| 0.203m²at 2mm | 2.2ft² at 80mil |
| 0.135m²at 3mm | 1.45ft² 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 3 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 | 5:1 |
| | By volume | 3:1 |
| **Volume capacity** | Metric | 406cc/kg |
| | Imperial | 24.5cu in/2.2lb |

### Surface Preparation

All oil and grease must be removed from the surface of the repair

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 (3mil) using an angular abrasive.

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

In areas where the product should not adhere a thin layer of a suitable release agent should be applied

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”)

**101 Metal Repair Paste can be applied to any type of metallic surface. Surface preparation can range from hand wire brush to abrasive blast cleaning. However poor surface preparation will reduce the performance of this product.**

### 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 1 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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