

101 Metal Repair Paste

- Solvent free epoxy repair paste
- High build capability 25mm without slumping
- Fully machineable once cured

Cure Times

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

Usable Life	30mins
Machining	2 hours
Maximum Overcoating	6 hours
Full cure	3 days

Coverage Rates

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

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

Surface Preparation

Metallic Substrates –Mechanical abrasion

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 gringing or oxidation occurs.

Metallic Substrates – Abrasive blast cleaning

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. 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.
3. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gringing 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 guide 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 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 101 metal repair paste to the surface.

