

## 103 Metal Repair Stick

- Solvent free epoxy repair putty
- Rapid curing – full cure 1 hour
- Seal or rebuild damaged surfaces

### Cure Times

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

<b>Usable Life</b>	5mins
<b>Machining</b>	30mins
<b>Full cure</b>	1 hour

### Typical Application

cracked pump or valve casings  
scored hydraulic rams  
worn bearing housings  
damaged flanges  
leaking tank seams  
cracked engine blocks

### Colour

Mixed material - Mid 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 1 hour.

### 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

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

### Mixing and Application

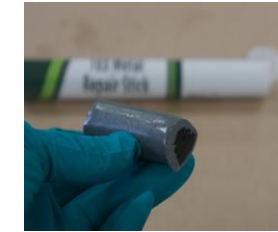
#### STEP 1

Remove the metal stick from The plastic tube



#### STEP 2

Cut off the required amount



#### STEP 3

Using a gloved hand mix the 2 components together



#### STEP 4

Once you have a consistent Mid grey colour, apply the Mixed product to the damaged Surface.

