

103 METAL REPAIR STICK

103 Metal Repair Stick is a two component repair material in stick form which cures rapidly at room temperature after mixing. It is a metal repair adhesive which develops high mechanical strength in a short period of time.

Typical applications

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

Characteristics

Appearance

Base: Dark Grey putty
Activator: Black putty
Mixed: Mid grey putty

Mixing Ratio

Product supplied in stick form

Volume Capacity

55.5cc per 125gm stick

Solids content

100%

Sag Resistance

Nil at 25mm

Cure Times

The applied material should be allowed to harden for the times indicated below before being subjected to the conditions indicated:

Usable life

10°C	10 minutes
20°C	5 minutes
30°C	2.5 minutes
40°C	1.25 minutes

Minimum machining time

10°C	1 hour
20°C	30 mins
30°C	15 mins
40°C	7.5 mins

Full Cure

10°C	2 hours
20°C	1 hour
30°C	30 minutes
40°C	15 minutes

Storage life

5 years if unopened and stored in normal dry conditions (15-30°C)

Mechanical Properties

Adhesion

Tensile Shear to ASTM D1002 on abrasive blasted mild steel with 75 micron profile
185 kg/ cm² (2630 psi)

Pull off Adhesion to ASTM D4541 on mechanically prepared mild steel to ST2 surface cleanliness
125kg/ cm² (1780 psi)

Compressive strength

Tested to ASTM D695
843kg/cm² (12,000psi)

Flexural Strength

Tested to ASTM D790
455kg/cm² (6470psi)

Hardness

Rockwell R to ASTM D785
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Heat Resistance

Suitable for use in immersed conditions at temperatures up to 50°C.
Resistant to dry heat up to 150°C dependent on load.

Food Contact

USDA compliant for incidental food contact.

Approvals

Approved by BUREAU VERITAS for Surface Protection and Cold Repair Products applied to Marine Vessels.
Certificate No: 55258/AO BV
Expiry: 24th March 2024

Chemical Resistance

The product resists attack by a wide variety of inorganic acids, alkalis, salts and organic media.

For more detailed information refer to the Resimac Technical Centre for advice.

Quality

All Resimac Products are supplied under the scope of the company's fully documented quality system.

Warranty

Resimac warrants that the performance of the product supplied will conform to the typical descriptions quoted within this specification provided material is stored correctly and used according to the procedures detailed in the Technical Data Sheet for the material.

Health and safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves and other recommended personal protective equipment must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read and fully understood the detailed Material Safety Data Sheet

Legal Notice: The data contained within this Product Specification is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Resimac accepts no liability arising out of the use of this information or the product described herein.