

104 Metal Repair Fluid XF

- Fast curing solvent free epoxy repair fluid
- Applied at 2-3mm (80-120mil) per coat
- Fully machineable once cured

Cure Times

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

Usable Life	5mins
Touch dry	45mins
Full cure	4 hours

Coverage Rates

800gm (lb) of fully mixed product will give the following coverage rates –

0.444m ² at 1mm	5.9ft ² at 40mil
0.222m ² at 2mm	3ft ² at 80mil
0.148m ² at 3mm	2ft 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

Plate bonding
Anti-slip coating (with aggregate)
Seal leaking oily surfaces
Seal leaking tank seams
Wrap leaking pipes

Technical specifications and characteristics

Mixing ratios	By weight	1 to 1
	By volume	1 to 1

Volume capacity	Metric	555cc/kg
	Imperial	33.8cu in/1.8lb

Surface Preparation

Metallic Substrates – Hand tools

1. Wipe away any ponding oil or grease using a solvent wipe.
2. All surfaces must be cleaned using wire brush, metal file, coarse sandpaper etc.
3. Once abraded, the surface must be cleaned with solvent to ensure as much oil and grease is removed.

Metallic Substrates – Mechanical tools

1. Wipe away any ponding oil or grease using a solvent wipe.
2. All surfaces must be mechanically abraded using handheld grinders to **ISO 8501/4 ST2 (SSPC SP3 ST2)**.
3. Once abraded, the surface must be cleaned with solvent to ensure as much oil and grease is removed.

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 material, clean the spatula between measures.



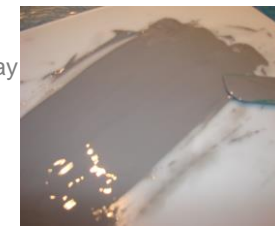
STEP 3

Mix the two components using the spatula provided, ensure any unmixed material around the edges is mixed.



STEP 4

The material must be a consistent light grey. Wipe away any unmixed material from the mixing surface.



STEP 5

Once the material is fully mixed use the applicator tool provided to apply the metal repair paste to the surface.

