

104 METAL REPAIR FLUID XF

104 Metal Repair Fluid

XF is a two component fast curing solvent free epoxy metal repair fluid. The product has been designed for use on a wide range of surfaces and is tolerant of less than ideal surface preparation and surfaces contaminated with grease, oil and lubricants.

Typical applications

Suitable for emergency repairs to worn surfaces, as an anti-slip system for metallic substrates and for resurfacing and sealing leaking transformers.

The material can also be used as a gap filling adhesive.

Characteristics

Appearance

Base: Black viscous fluid

Activator: White viscous fluid

Mixed: Mid grey viscous fluid

Mixing Ratio

By weight: 1:1

By volume: 1:1

Density

Base: 1.80

Activator: 1.80

Mixed: 1.80

Volume Capacity

555cc/Kg

Solids content

100%

Sag Resistance

Nil at 3mm

Coverage

200gm (0.44lb) of fully mixed product will give the following coverage rates –
0.111m² at 1mm 1.2ft² at 40mil

800gm (1.76lb) of fully mixed product will give the following coverage rates –
0.444m² at 1mm 4.75ft² at 40mil

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

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 75 seconds

Hard dry

10°C 2 hours

20°C 60 mins

30°C 30 mins

40°C 15 mins

Full Cure

10°C 8 hours

20°C 4 hours

30°C 2 hours

40°C 1 hour

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
185kg/ cm² (2630psi)

Pull off Adhesion to ASTM D4541 on abrasive blasted mild steel with 75 micron profile
155kg/ cm² (2205psi)

Compressive strength

Tested to ASTM D695
615kg/cm² (8750psi)

Corrosion Resistance

Tested to ASTM B117
Minimum 5000 hours

Flexural Strength

Tested to ASTM D790
655kg/cm² (9315psi)

Hardness

Rockwell R to ASTM D785
85

Heat Distortion

Tested to ASTM D648 at 264psi fibre stress.

20°C Cure 60°C

100°C Cure 98°C

Heat Resistance

Suitable for use in immersed conditions at temperatures up to 60°C.

Resistant to dry heat up to 130°C dependent on load.

Food Contact

USDA compliant for incidental food contact.

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

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