

## RESIMETAL 103 Metal Repair Stick – fast curing solvent free epoxy putty

**Resimetal 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.

- Apply to hand prepared or mechanically cleaned surfaces
- Rapid curing – hard dry in 30mins

### Typical Applications

cracked pump or valve casings  
damaged flanges

scored hydraulic rams  
leaking tank seams

worn bearing housings  
cracked engine blocks

### 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

Prior to mixing please ensure the following:

1. The ambient & surface temperature is above 41F°.
2. The product is supplied in stick form and therefore the base and activator component are premeasured.
3. Simply break off the required amount of material from the stick and using gloved hands knead the product until the black and grey components become a consistent mid grey.
4. The product once fully mixed has a usable life of 3-5mins at 68F°.
5. Once a consistent mix has been achieved apply the material by pressing the putty onto the prepared surface.

### Cure Times

At 68F° the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Usable Life	5 mins
Machining and light loading	30 mins
Full cure	1 hour

### Pack Sizes

This product is available in the following pack sizes –  
125gm (4.4oz)

### Color

Mixed material – Mid grey  
Base component – dark grey  
Activator component – Light grey

### Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry.

Maximum - the over-coating time should not exceed 1 hours.

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.

### **Storage Life**

5 years if unopened and store in normal dry conditions (60-86°F)

### **Other Technical Documents**

Quick Application Guide	-	Hand application
Safety Data Sheets Product	-	Single component
Specification Sheet	-	Technical Performance Information

### **Health and Safety**

Please ensure good practice is observed at all times. Protective gloves, goggles & a disposable coverall must be worn during the mixing and application of this product. Before mixing and applying the material ensure you have read the fully detailed Safety Data Sheet.

### **Legal Notice:**

The data contained within this Technical Data Sheet 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 if the product is suitable for use. Resimac accepts no liability arising out of the use of this information or the product described herein.



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