



## RESIMETAL 106 Metal Repair Paste XF – fast curing solvent free epoxy paste

**Resimetal 106 Metal Repair Paste XF** is a fast curing two component solvent free epoxy metal repair compound. The product has been designed for use on a wide range of metallic surfaces and once cured is readily machineable.

- Apply to hand tool prepared & mechanically cleaned surfaces
- Rapid curing – hard dry in 45mins
- Apply at thicknesses up to 20mm

### Typical Applications

damaged pump shafts  
leaking tank seams  
underwater hulls

cracked pump or valve casings  
cracked engine blocks  
underwater structures

damaged flanges  
underwater surfaces

### 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

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

### Mixing

Prior to mixing please ensure the following:

1. The base component is at a temperature between 60-77F°.
2. The ambient & surface temperature is above 41F°.

Once these 2 checks have been met, please proceed with mixing the product.

If part mixing the unit of material please follow the instructions below:

1. Using the spatula provided place 1 equal measure from the base & activator units onto the mixing board provided.
2. Ensure to clean the spatula thoroughly after measuring the base component and before measuring the activator component.
3. Mix the 2 components together until you have a streak free mix (mid grey) on the mixing board.
4. Ensure there is no unmixed material on the spatula or mixing board.
5. From the commencement of mixing, the material should be used within 5 minutes at 68F°.

### Application

1. Using a spatula or applicator tool, apply the material to the prepared surface.
2. Ensure the product is pressed into any holes, scars or cracks.
3. Once the repair has been completed smooth off any imperfections using a gloved hand.

### Coverage Rates

200gm (0.44lb) of fully mixed product will give the following coverage rates –  
1.2ft<sup>2</sup> at 40mil

500gm (1.1lb) of fully mixed product will give the following coverage rates –  
5.38ft<sup>2</sup> 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

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	5mins
Hard dry/ machining	45mins
Full cure	4 hours

## Pack Sizes

This product is available in the following pack sizes –  
200gm (0.44lb), 500gm (1.1lb)

## Color

Mixed material - Mid grey  
Base component – Black  
Activator component – White

## 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 4 hours.

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded 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	-	Base & Activator components
Product 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.

