

## 106 METAL REPAIR PASTE XF

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**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.

### Typical applications

damaged pump shafts, cracked pump or valve casings, damaged flanges, leaking tank seams, cracked engine blocks, underwater surfaces, underwater hulls, underwater structures

### Characteristics

#### Appearance

Base: Black viscous paste  
Activator: White viscous paste  
Mixed: Mid grey viscous paste

#### 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 20mm

#### Coverage

200gm (0.44lb) of fully mixed product will give the following coverage rates –  
0.111m<sup>2</sup> at 1mm 1.2ft<sup>2</sup> at 40mil

500gm (1.1lb) of fully mixed product will give the following coverage rates –  
0.278m<sup>2</sup> at 1mm 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

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/ minimum machining time

10°C 90 mins  
20°C 45 mins  
30°C 22 mins  
40°C 11 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/ cm<sup>2</sup> (2630psi)

**Pull off Adhesion** to ASTM D4541 on abrasive blasted mild steel with 75 micron profile  
155kg/ cm<sup>2</sup> (2205psi)

#### Compressive strength

Tested to ASTM D695  
615kg/cm<sup>2</sup> (8750psi)

#### Corrosion Resistance

Tested to ASTM B117  
Minimum 5000 hours

#### Flexural Strength

Tested to ASTM D790  
655kg/cm<sup>2</sup> (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.

## Approvals

Approved by BUREAU VERITAS for Surface Protection and Cold Repair Products applied to Marine Vessels.

Certificate No: 55258/AO BV  
Expiry: 24<sup>th</sup> 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.

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.

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.

## Quality

## Health and safety

Please ensure good practice is observed at all times during the

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