

RESIMETAL 302 Epoxy Repair Cement – surface tolerant solvent free epoxy repair paste

Resimetal 302 Epoxy Repair Cement is a high performance, two pack, solvent-free epoxy repair system for use on metallic surfaces. Resimetal 302 Epoxy Repair Cement is ideal for applications where only minimal surface preparation can be carried out.

- Apply to manual or mechanically cleaned surfaces
- High build capability (20mm)
- Bonds to a wide range of metallic surfaces

Typical Applications

Suitable for rebuilding corrosion pitting on metallic structures such as internal/ external tank surfaces, pipelines and pipework.

Surface Preparation

Metallic Substrates – Hand tools

1. The repair surface must be cleaned with solvent to ensure any oil, grease or surface contaminants are removed.
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.

Mixing

Prior to mixing please ensure the following:

1. The base component is at a temperature between 15-25°C (60-77°F).
2. The ambient & surface temperature is above 5°C (41°F).

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 unit onto the mixing board provided.
2. Clean the spatula thoroughly.
3. Then take 1 equal measure from the activator unit and place alongside the base measure.
4. Mix the 2 components together until you have a streak free mix on the mixing board.
5. Ensure there is no unmixed material on the spatula or mixing board.

If mixing a complete unit of material (200gm/1kg/3kg) please follow the instructions below:

1. Dispense as much of the base and activator units onto a clean mixing surface.
2. Mix the 2 components together until you have a streak free mix on the mixing board.
3. Ensure there is no unmixed material on the spatula or mixing board.

From the commencement of mixing, the material should be used within 30 minutes at 20°C (68°F).

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

1kg (2.2lb) of fully mixed product will give the following coverage rates –

0.625m ² at 1mm	6.7ft ² at 40mil
0.313m ² at 2mm	3.3ft ² at 80mil
0.208m ² at 3mm	2.2ft ² at 1/8"

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

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Cure Times

At 20°C (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	30 minutes
Touch dry	6 hours
Hard dry	12 hours
Full cure	2 days

Pack Sizes

This product is available in the following pack sizes –
200gm (0.44lb), 1kg (2.2lb), 3kg (6.6lb)

Colour

Mixed material – Dark brown
Base component – Dark brown
Activator component – Light brown

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 24 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 (15-30°C/ 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.