

Industrial 5 Minute Metal

A metal-filled, fast-setting, two-part repair compound designed for maintenance and repair work. Industrial 5 Minute Metal is ideal for the maintenance and repair of pumps, valves, metals castings, low pressure pipes and tanks, and automotive bodywork. It can be used on metal, wood and most plastics and provides excellent protection against corrosion and chemical attack.

Description

Industrial 5 Minute Metal is reinforced with corrosion-resistant metal platelets, giving a smoother finish than regular repair pastes when machined. The light consistency makes it easier to mix than stiff and heavy traditional epoxy pastes and it is thixotropic, meaning it will not sag. In addition, Industrial Metal is virtually odourless, with no unpleasant smell compared to other products.

Applications

- Used for the repair and manufacture of pipes, fittings and equipment
- Used to repair holes, cracks and pitting in pipes and tanks, used to reline worn areas in pumps, valves and associated equipment
- Industrial equipment repair, maintenance and construction
- Gives protection against corrosion & chemical attack.

Advantages

- Fast setting
- Can be machined
- Does not shrink
- Easy to mix & apply

Directions for Use

Surface Preparation

- Surfaces must be prepared prior to application.
- All surfaces must be dry and free from grease. Clean and roughen surface for optimum adhesion.
- Remove all paint, rust and grime from the surface by abrasive blasting or with sandpaper.
- Aluminium: remove oxidation from surface for optimal adhesion.
- Roughen the surface first, ideally by grit blasting (8-40 mesh grit), or through grinding with a coarse wheel or abrasive disc pad. An abrasive disc may be used provided white metal is revealed. Do not 'feather edge' – this epoxy must be 'locked in' by defined edges and a good 3 – 5mm profile.
- Metal which has been in contact with seawater or other salt solutions should be grit blasted and high pressure water blasted, and then left overnight to allow salts in the metal to 'sweat' to the surface. Repeat this process if necessary to 'sweat out' all of the soluble salts.
 - Test for chloride contamination before application.
 - The maximum soluble salts left on the substrate should be no more than 40 ppm.
- Use a solvent cleaner to remove all traces of sandblasting, grit, oil, grease, dust or other foreign substances.
- In cold working conditions, it is recommended that the repair area is heated to 37°C - 43° C prior to application. This will dry off any moisture, contamination or solvents for maximum adhesion.
- Apply as soon as possible after preparation of the substrate to avoid oxidation or rusting.

Application Method

- Industrial 5 Minute Metal should be kept and applied at room temperature. It can be applied when temperatures are between 13°C and 52°C.
- Spread Industrial Metal over prepared surface with a putty knife. Press firmly to ensure maximum surface contact and avoid trapping air.
- To bridge large gaps or holes use fibreglass, sheet metal or wire mesh.

Technical Data

MINIMUM SHELF LIFE (months @ 24°C).....	24
MIX RATIO (WEIGHT)	1:1
MIX RATIO (VOLUME)	1:1
GEL TIME (minutes).....	5
FUNCTIONAL CURE (minutes)	60
FULL CURE (hours).....	24
HARDNESS, SHORE D (full cure, 24 hrs.).....	80+
LAP SHEAR TENSILE STRENGTH (Mpa)	
On Steel	14
TENSILE STRENGTH (MPa).....	20
COMPRESSIVE STRENGTH (MPa)	72
FLEXURAL STRENGTH (MPa)	20
DENSITY (gm/cm ³)	1.6
SHRINKAGE (%)	<1
NON-VOLATILE CONTENT (%)	100
MAXIMUM SERVICE TEMPERATURE (°C).....	95

(values are typical and should not be used for specification purposes)

Packaging

Available in the following kits:

CODE	NAME	SIZE
PSF/500g	Industrial 5 Minute Metal	500g
PSF/4x500g	Industrial 5 Minute Metal	4x500g
PSF/2kg	Industrial 5 Minute Metal	2kg
PSF/5kg	Industrial 5 Minute Metal	5kg
PSF/50kg	Industrial 5 Minute Metal	50kg

Storage

Sylmasta Epoxy Pastes should be stored out of direct sunlight in dry, frost free conditions at temperatures between 15° and 25°C. Under such conditions shelf life will be 2 years from the date of manufacture.

Health & Safety

Sylmasta Epoxy Paste consists of epoxy resins and hardener systems, please consult the individual Material Safety Data Sheet for hazard information. Wear eye protection and rubber or plastic coated gloves, and wash hands with soap and water immediately after use.