

Quick application guide

302 Epoxy Repair Paste

Solvent free epoxy repair paste
High build capability 20mm without slumping
Suitable for manual/ mechanical prep surfaces

Cure Times

At 20°C (68°F) the product will have the following cure times

Usable Life	30mins
Touch dry	6 hours
Hard dry	12 hours
Full cure	2 days

Coverage Rates

1kg (2.2lb) of fully mixed product will give the following coverage rates –
0.625m² at 1mm
6.7ft² at 40mil
0.313m² at 2mm
3.3ft² at 80mil
0.208m² at 3mm
2.2ft² at 1/8"

Colour

Mixed material - Black
Base component – Black
Activator component – Beige

Over-coating times

Minimum - as soon as it is touch dry.

Maximum - the over-coating time should not exceed 24 hours.

Typical Applications

Damaged flanges
Leaking tank seams
Plate bonding
Rebuilding internal tank surfaces
Internal & External pipeline surface

Technical specifications and characteristics

Mixing ratios	By weight	1:1
	By volume	1:1

Volume capacity	Metric	625cc/kg
	Imperial	38cu in/2.2lb

Surface Preparation

Hand tools, use a wire brush or coarse sand paper to abrade the surface. Ensure all loose material and as much surface contamination is cleaned from the surface.

Mechanical tools, use a handheld mechanical grinder with a coarse grinding pad or rotary wire brush. **DO NOT POLISH THE SURFACE, ENSURE THAT THE SURFACE HAS A CROSS HATCH PATTERN.**

MBX bristle blaster, for the best mechanical surface preparation results use an MBX bristle blaster.

Once the surface has been cleaned ensure the repair area is washed down with solvent such as MEK (Methyl Ethyl Ketone).

Mixing and Application

STEP 1

Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula, 1 applicator, 1 x clean mixing area.



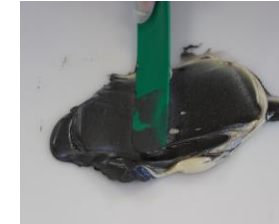
STEP 2

Take equal measures of the base and activator material.



STEP 3

Mix the two components using the spatula provided, ensure any unmixed material around the edges is mixed.



STEP 4

To ensure the product is fully mixed create a diamond pattern on the surface and look for any areas which are not black in colour.



STEP 5

Once the material is fully mixed use the applicator tool provided to apply the metal repair paste to the surface.

