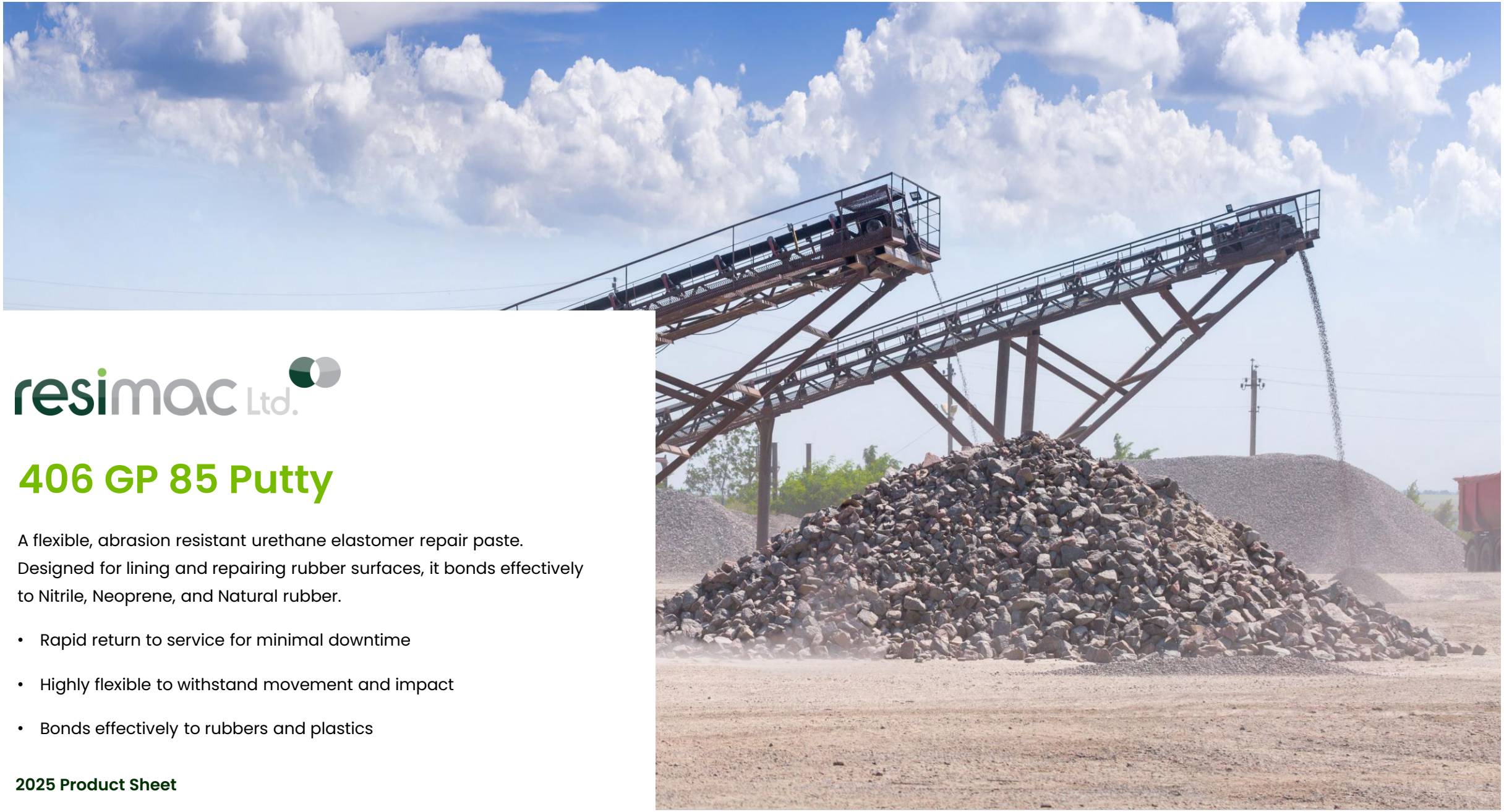

resimac Ltd.

406 GP 85 Putty

A flexible, abrasion resistant urethane elastomer repair paste. Designed for lining and repairing rubber surfaces, it bonds effectively to Nitrile, Neoprene, and Natural rubber.

- Rapid return to service for minimal downtime
- Highly flexible to withstand movement and impact
- Bonds effectively to rubbers and plastics

2025 Product Sheet

Typical Applications

406 GP 85 Putty is a two component, solvent free urethane elastomer formulated for repairing and lining rubber surfaces. Its durable, abrasion resistant composition ensures long lasting performance in demanding environments. Suitable for bonding to materials such as Nitrile, Neoprene, and Natural rubber, it provides a reliable solution for industrial repairs.

- Gasket sealing
- Lining of process equipment
- Repairing worn rubber components

Cure times

Usable Life	
10°C/50°F	15 mins
20°C/68°F	9 mins
30°C/86°F	4 mins
40°C/104°F	2 mins

Min overcoating time	
10°C/50°F	60 mins
20°C/68°F	30 mins
30°C/86°F	20 mins
40°C/104°F	15 mins

Max overcoating time	
10°C/50°F	72 hours
20°C/68°F	36 hours
30°C/86°F	18 hours
40°C/104°F	9 hours

Light loading Dry	
10°C/50°F	16 hours
20°C/68°F	8 hours
30°C/86°F	6 hours
40°C/104°F	4 hours

Heavy Loading Dry	
10°C/50°F	48 hours
20°C/68°F	24 hours
30°C/86°F	20 hours
40°C/104°F	10 hours

Water / Sea immersion	
10°C/50°F	6 days
20°C/68°F	3 days
30°C/86°F	36 hours
40°C/104°F	18 hours

Chemical immersion	
10°C/50°F	14 days
20°C/68°F	7 days
30°C/86°F	3 days
40°C/104°F	36 hours

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

Characteristics

Appearance

Base	Black Paste
Activator	Amber Paste
Mixed	Black Paste

Solids Content

100%

Density

Base	1.05
Activator	1.15
Mixed	1.08

Mixing Ratio

By weight	100:26
By volume	100:23

Storage Life

1 year if unopened and stored in normal dry conditions, 15-30°C (59-86°F)

Slump Resistance

Nil at 2.5cm

Coverage

500g will cover 0.46m² at a nominal thickness of 1mm not allowing for losses

Mechanical Properties

Tensile Strength

Tested to BS EN ISO 37 100 kg/cm² (1450psi)

Elongation

Tested to BS EN ISO 37 900%

Tear Strength

Tested to BS EN ISO 34 4690kg/m (262pli)

Shore A Hardness

Tested to BS EN ISO 868 85

90°C (194°F) Peel Adhesion to Steel

Tested to ASTM D429

Abrasive blasted and primed with 402 primer

3132 kg/m (175pli)

Los Angeles Abrasion Test (modified)

After 7 days cure at 20°C (248°F) using granite and 150# silicon carbide. Volume loss per week 0.92%

180°C (176°F) Peel Adhesion to Rubbers

Tested to ASTM D413

Roughened with MBX and primed with 402 primer:

Neoprene 609 kg/m (TF)	34 pli
Nitrile 377 kg/m (CS)	21 pli
Natural 215 kg/m (CS)	12 pli
EPDM 428 kg/m (CS)	24 pli

TF = Tape failure

CS = Cohesive failure in substrate

Heat Resistance

Suitable for long term water immersion at temperatures up to 50°C (122°F)

intermittent contact water contact up to 80°C (176°F)

Resistant to dry heat up to 120°C (248°F)

Linear Shrinkage

500x 50x 10mm <0.05%

Details & Legal

Chemical Resistance

The product resists attack by a wide variety of inorganic acids, alkalis, salts and organic media. Refer to the Resimac Technical Centre for advice.

Pack Sizes

This product is available in the following pack sizes:

500gm (1.1lbs) foil laminate bag

Quality

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 this document.

Application Guide

A. Surface Preparation

Metallic Substrates: Mechanical abrasion

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. Prime the surface with 402 Multi-surface primer.

Metallic Substrates: Abrasive blast cleaning

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be abrasive blasted to ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2) minimum blast profile of 75 microns (3mil) using an angular abrasive.
3. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.
5. Prime the surface with 402 Multi-surface primer.

Health & Safety

Please ensure good practice is observed at all times during the 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 all information.

Rubber substrates:

1. Remove any surface contamination and degrease with MEK.
2. Use a suitable carding tool or MBX bristle blaster to roughen the surface before brushing away any debris.
3. Prime the surface with 402 Multi-surface primer.

B. Product Preparation

Prior to mixing, please ensure the following:

1. The ambient & surface temperature is above 10°C (50°F).
2. The ambient & surface temperatures are not less than 3°C (6°F) above the dew point.

PLEASE NOTE: For salt contaminated surfaces the substrate must be pressure washed with clean water and checked for salt contamination, please refer to the surface preparation and pre-application guide for further information.

C. Mixing & Application

1. 406 GP 85 Putty is supplied in a twin compartment bag with the base and activator components already pre-measured.
2. Remove the bag from the outer foil container and warm to around 20°C (68°F) prior to use to ease mixing.
3. Remove the plastic divider and thoroughly mix the two components by hand until homogeneous.
4. Dispense the mixed product onto the prepared surface and smooth out using the applicator tool provided.

   If required, 406 GP 85 Putty can be used in conjunction with 808 reinforcement tape to create a multi-layered reinforcement system.

Once all surfaces, metallic or rubber, have been prepared, apply 402 Multi-surface Primer to all surfaces using a cut down brush. Apply the primer to the surface with a stippling action avoiding ponding and leave to cure until touch dry and for a minimum of 20 minutes at 20°C (68°F).

Quick Application Guide

Step 1

Ensure you have:
1 x 500gm sachet
1 x 402 Primer
1 x spatula
1 x applicator tool
1 x reinforcement tape
1 x paintbrush

Step 2

Remove dividing rod from the sachet.

Step 3

By hand forcibly mix the 2 components together without piercing the sachet for approx. 3-4 mins.

Step 4

Cut the end of the sachet and dispense material onto a clean mixing board.

Step 5

Check to ensure that the 2 components are fully combined by giving a final mix with the spatula. The paste should be a consistent, uniform black colour.

Step 6

Using the applicator tool apply the mixed material to the primed repair surface.

About Resimac

A UK based manufacturer of epoxy and polyurethane coatings and repair materials.

From our head office in the heart of rural North Yorkshire, England we supply our range of Epoxy, Polyurethane & Silicone coatings and repair materials to the Oil & Gas, Petrochemical, Marine, Paper & Pulp, Water, Power Generation & Chemical Industries.

Legal Notice

Information & Enquiries

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