MAXKOTE
Repair, Maintenance & Protection Products

APPLICATION GUIDE

MET200 APG-REV1- 2018

MAXMET 200 EPOXY METAL REPAIR & RESURFACING FLUID

Description	**MAXMET 200** is a solvent free, epoxy resurfacing and rebuilding fluid, suitable for repairing metal components suffering material loss or pitting due to mechanical damage, erosion, corrosion or chemical attack. MAXMET 200 with the addition of an aggregate can also be used as an anti-slip resin on steel surfaces

Applications	• Conveyor belt head rollers • Brake test rollers • Storage tanks seams • Pump casings • Valves • Steel steps nosing's, • Steel walkways and decks

Surface Preparation Steel	All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK or similar solvent. For optimum performance, the surface should be grit-blasted to **ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)** and a minimum blast profile of 75 microns using an angular abrasive. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar solvent. All surfaces must be repaired before gingering or oxidation occurs Where abrasive blast cleaning is not possible (excluding salt contaminated surfaces) the surface should be roughened by needle gun or grinding.

Surface Preparation Salts	For salt contaminated surfaces the area must be grit-blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After this 24-hour period the surface must be washed with MEK prior to brush blasting to remove the surface salts. This process must be repeated until all ingrained contaminants have been sweated out of the surface.

Pot Life @ 20°C	20 - 25 minutes

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Mixing

Warm the Base component to 15-25°C before mixing and do not apply when the ambient or substrate temperature is below 5°C or less than 3°C above dew point. Mix both Part-A and part-B together in full units as supplied.

For small quantities us a mixing ratio of:

3:1 by volume or **8:1** by weight

When mixing both materials, it is very important to have a uniform grey paste that is streak free. Once mixing is complete, use the mixed paste as soon possible after mixing.

Application

Fairing compound - for filling badly pitted or scarred surfaces apply the material using a rubber float across the repair surface ensuring the product is pressed into any holes or cracks. The maximum wet film thickness this material can be applied onto a vertical surface's without sagging is 3mm.

Anti-slip systems - for conveyor rollers, steps or ramps, apply the product to the surface at a wet film thickness of 500 microns and then broadcast a suitable aggregate onto the surface (Aluminium Oxide or equivalent). Once cured brush off any excess aggregate.

Resurfacing - If applying as a resurfacing material to repair worn or damaged surfaces the application should be carried out in two coats. The material must be applied at a target wet film thickness of 250 microns per coat. From the commencement of mixing the whole of the material should be used within 20-30 minutes at 20°C

Cure times

Once hardened, material should be left for the following periods of time at 20°C before being subjected to the conditions indicated. These times will be doubled at 10°C and halved at 30°C.

- Movement without load or immersion 1.5 hours
- Machining and light loading 2 hours
- Full loading 2 days
- Immersion 3 days

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Coverage	1kg will cover 0.4 sq metres at a nominal thickness of 1mm

Over-Coat Times	**Minimum –** the applied material can be over-coated as soon as it is touch dry. **Maximum –** over-coating time **6 hours**. Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded, or flash-blasted and solvent washed to remove any surface contamination

Health and Safety	Please ensure good practice is always observed during the mixing and application of this product. Protective gloves must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read the fully detailed Material 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 the products suitability for use. Maxkote accepts no liability arising out of the use of this information or the product described herein.