MAXKOTE
Repair, Maintenance & Protection Products

APPLICATION GUIDE

MET600 APG-REV1- 2018

MAXMET 600 5-MINUTE EPOXY METAL REPAIR COMPOUND

Description	**MaxMet 600** is a 5-minute solvent free, epoxy repair and rebuilding compound. Suitable for emergency repairs to metal or plastic components suffering material loss due to mechanical damage, erosion, corrosion or chemical attack.

Applications	• Filling pitting corrosion • Leaking seams on storage tanks • Pump impellers and casings • Leaking flange faces • Shafts and bearing housings • Resurfacing underwater structures • Cracks in Engine Blocks

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 **Hand tools** use a wire brush or coarse sandpaper to abrade 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. Ensure all loose material and as much surface contamination is cleaned from the surface. Ensure the surface is wiped with an appropriate solvent cleaner such as MEK after abrading the surface.

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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.
Cracks	In the case of cracked surfaces, the cracks should be stabilised by drilling the termination points and the cracks ve-ed out and drilled, tapped and bolted every 75 -100 mm.
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: **1:1** by volume or **1:1** 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	Using a spatula or applicator tool, apply the material to the prepared surface, ensuring the product is pressed into any holes, scars or cracks and profile the repair to a smooth finish.
Coverage	0.5kg unit of mixed product will cover 0.222 sq metres at a nominal thickness of 1.0mm

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Pot Life @ 20°C	3-5 minutes

Cure Times	• Movement without load or immersion	45mins
	• Machining and light loading	90mins
	• Full loading	4 hours
	• Immersion	8 hours

Over-Coat Times	**Minimum –** the applied material can be over-coated as soon as it is touch dry. **Maximum –** over-coating time 4 **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.

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