

## 103 METAL REPAIR STICK

**103 Metal Repair Stick** is a two component repair material in stick form which cures rapidly at room temperature after mixing. It is a metal repair adhesive which develops high mechanical strength in a short period of time.

### Typical applications

cracked pump or valve casings  
scored hydraulic rams, worn bearing housing, damaged flanges, leaking tank seams, cracked engine blocks

### Characteristics

#### Appearance

Base: Dark Grey putty  
Activator: Black putty  
Mixed: Mid grey putty

#### Mixing Ratio

Product supplied in stick form

#### Volume Capacity

55.5cc per 125gm stick

#### Solids content

100%

#### Sag Resistance

Nil at 25mm

### Cure Times

The applied material should be allowed to harden for the times indicated below before being subjected to the conditions indicated:

#### Usable life

10°C 10 minutes  
20°C 5 minutes  
30°C 2.5 minutes  
40°C 1.25 minutes

#### Minimum machining time

10°C 1 hour  
20°C 30 mins  
30°C 15 mins  
40°C 7.5 mins

#### Full Cure

10°C 2 hours  
20°C 1 hour  
30°C 30 minutes  
40°C 15 minutes

### Storage life

5 years if unopened and stored in normal dry conditions (15-30°C)

## Mechanical Properties

### Adhesion

**Tensile Shear** to ASTM D1002 on abrasive blasted mild steel with 75 micron profile  
185 kg/ cm<sup>2</sup> (2630 psi)

**Pull off Adhesion** to ASTM D4541 on mechanically prepared mild steel to ST2 surface cleanliness  
125kg/ cm<sup>2</sup> (1780 psi)

### Compressive strength

Tested to ASTM D695  
843kg/cm<sup>2</sup> (12,000psi)

### Flexural Strength

Tested to ASTM D790  
455kg/cm<sup>2</sup> (6470psi)

### Hardness

Rockwell R to ASTM D785  
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### Heat Resistance

Suitable for use in immersed conditions at temperatures up to 50°C.  
Resistant to dry heat up to 150°C dependent on load.

### Food Contact

USDA compliant for incidental food contact.

### Approvals

Approved by BUREAU VERITAS for Surface Protection and Cold Repair Products applied to Marine Vessels.  
Certificate No: 55258/AO BV  
Expiry: 24<sup>th</sup> March 2024

## Chemical Resistance

The product resists attack by a wide variety of inorganic acids, alkalis, salts and organic media.

For more detailed information refer to the Resimac Technical Centre for advice.

## 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 the Technical Data Sheet for the material.

## Health and 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 the detailed Material Safety Data Sheet

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