



# MeCaFix 100 Express

## APPLICATION INSTRUCTIONS MeCaTec

### SURFACE PREPARATION

Ensure that surface is clean, dry and uncontaminated. Precleaning of the surface is necessary in order to remove oil, wax or other foreign matter which may contaminate the abrasive media and impregnate itself into the blast profile. Always check for ionic salt contamination (chlorides and sulfates) and neutralize the surface as required. Proceed only if the substrate temperature is 5°F (3°C) above the dew point temperature and that the relative humidity is below 85% during surface preparation and coating application. Abrasive blast clean with angular abrasive media. For steel surfaces, blast to a Near White Metal Blast (SSPC-SP10; NACE 2; SA 2.5) with a minimum 3 mils (75 µm) depth profile. Blow down the surface before applying the coating to ensure it is free of dust and other loose contaminants.

For less severe service or emergency repairs, surface preparation by mechanical flapper wheel grinding (40 grit or coarser) and bristle blasting process is permitted. The surface must be clean with a rough profile of 2 mils (50 µm). Due to the slower rate of cleaning by mechanical means, these methods are ideally suited for smaller repair applications.

### MIXING INSTRUCTIONS

Mixing Ratio	
Volume	1 part Resin (A) : 1 part Hardener (B)
Weight	1.55 part Resin (A) : 1 part Hardener (B)

This is a two-component system. **DUE TO THE HIGH EXOTHERM DEVELOPMENT AND FAST REACTION SPEED OF THE MIXED COMPONENTS, IT IS IMPORTANT TO MIX ONLY SMALL QUANTITIES AT ONE TIME.** Ensure product temperature is between 68-85°F (20-30°C). Apply one part of the Resin Part A to a mixing board or cup. Apply an equal portion of Hardener Part B to the mixing board or cup.

Mix for 30 seconds until a uniform color and consistency is achieved. To ensure complete mixing, scrape sides and bottom of container and continue mixing for an additional 15 seconds. Excessive mixing speed will induce air into the mixture and is not recommended.

### APPLICATION INSTRUCTIONS

1) Once mixed, begin applying product immediately - no induction time is needed. All mixed material must be used within 3 minutes.

Once mixed the product viscosity will begin to thicken immediately. This product has a short working life and will develop exothermic heat due to the polymeric reaction. The higher the temperature and the larger the mass, the faster the product cure speed.

To use this material as a low viscosity compound apply immediately once it is mixed. For a paste like consistency allow the material to begin to react and use the material as the viscosity begins to increase. This will be near the end of the product's working life.

2) The product is applied with the application spreader provided. Work the material in a very thin layer to allow the polymer resin to "wet" out the surface to ensure proper adhesion. Once the surface is wet, begin to build up the coating to the desired thickness.

3) The product should be applied in a single layer. When additional thickness is required the coating must be abraded to allow for inter-coat adhesion.

4) To reinforce a repair, MeCaFlx 100 may be used in conjunction with reinforcement fiber tape. Pre-wet the fiber tape with MeCaFix 100 and apply it to the affected area.

### INSPECTION

Immediately following the application of the coating visually inspect the coating for discoloration and areas of missed coating. These areas can be repaired immediately if the coating is tacky to touch.

Further inspection is to be performed once the coating has cured. Visually inspect the coating for discoloration, uncured coating, blisters, and other visual defects.

Mechanical removal and reapplication may be required depending on the defect type.

## CURING PERFORMANCE

Curing performance data is based on an applied thickness of 160 mils (4 mm). The cure speed will be faster as the thickness of the coating increases and the exotherm of the reaction becomes hotter. The thinner the coating is applied the slower the curing speed.

**For chemical immersion of the coating, it is recommended that the coating cure for 24 hours to maximize its performance in service.**

Curing Schedule	50°F	77°F	86°F
	10°C	25°C	30°C
Pot Life	4 minutes	3 minutes	2 minutes
Dry to Touch	15 minutes	10 minutes	6 minutes
Dry to Handle	45 minutes	30 minutes	20 minutes
Full Load Exposure	4 hours	2 hours	1 hour
Max. Recoat Time	While material is soft		

## STORAGE & CLEAN UP

- 1) Use commercial solvents (Xylene, Methyl Ethyl Ketone) to clean tools immediately after use.
- 2) Once the coating is dry, the material must be abraded off.
- 3) Keep containers tightly sealed. For cleanup, use M.E.K. or a 50:50 blend of M.E.K. and Xylol.
- 4) Long time storage should be between 50°F (10°C) and 80°F (27°C).

**DO NOT FREEZE.**

- 5) Use product within 2 years of receiving. Once the product lid is opened it must be resealed tightly. The shelf life will be reduced to 3 months.

## SAFETY

Before using any products, please refer to the Safety Data Sheet (SDS). Follow standard confined space entry and work procedures, if appropriate.

Wear eye safety protection and full skin protection including chemical resistant gloves. Only use this product in well ventilated areas. Use NIOSH approved respirator where mist occurs.

*Before applying this product, please refer to the Technical Data Sheet.*

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

