

## SURFACE PREPARATION

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Prepare the surface of the conveyor belt by removing any loose rubber. In a cross hatch pattern use a bristle blaster or slow speed sander with 18 to 24 grit aluminum oxide disc to create rough grooves onto the repair area. The prepared surface should extend 1" beyond when the actual coating will be applied. Sharp edges should be beveled for best results.

Clean the repair area with MEK solvent. Do not soak the solvent on the work surface. Only use a light amount to remove residual dirt and contamination.

Apply a very thin layer of MeCaPrime 14 primer to the repair area. Do not saturate the surface.

MeCaPrime 14 must be thoroughly mixed before use. Brush, roller on prepared surface to a minimum thickness of 0.5 mil (12.5 µm) to a maximum of 1 mil (25 µm). MeCaPrime 14 is a solvent based flammable material, **keep away from open flame, sparks and direct sunlight. THE SOLVENT IN THE PRIMER MUST FLASH OFF BEFORE APPLYING THE MECAFIX 144 PRODUCT.** Allow to dry for 15-30 minutes, while the primer is still tacky begin the application of the MeCaFix 144 product. **DO NOT EXCEED 2 HOURS** after application of the primer to apply the MeCaFix 144 product.

## MIXING INSTRUCTIONS

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Preheat the cartridge tubes to 75-90°F (23-32°C), do not exceed 95°F (35°C). Set the pneumatic dispensing gun to 80 psi (5.5 bar). An inline moisture separator and filter should be used to avoid contamination of the material with moisture if the product is to be spray applied. Shake the cartridge tube to ensure that if any settling occurs that it is redispersed into the product. Use the supplied static mixer.

Purge the product through the static mixer to ensure that both A and B components are properly dispensed and that the cartridge plunger depth are equal between both components. Before applying the repair coating always begin to dispense the material off the area to be repaired to ensure that only properly mixed material is used on the repair.

## APPLICATION INSTRUCTIONS

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1) This material must be dispensed with the MeCaSpray pneumatic cartridge gun.

2) MeCaFix 144 is a fast setting repair putty. The product will gel rapidly and sets in about 6 to 8 minutes. The higher the product and ambient temperature the faster the product will cure. For good intercoat adhesion apply successive coats within 30 minutes. After 30 minutes the MeCaFix 144 will need to be roughened before applying a subsequent coat.

3) Once the spraying or casting starts in cannot be stopped as this will cause the material to set up in the static mixer. Plan your work accordingly with minimal start and stops. To begin the application always start off target to ensure the material is properly mixed. Once mixed, the material is applied as a continuous cast to the prepare surface.

## INSPECTION

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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 Schedule	50°F	77°F	86°F
	10°C	25°C	30°C
Pot Life	90 seconds	60 seconds	45 seconds
Dry to Touch	4 minutes	3 minutes	2 minutes
Dry to Handle	25 minutes	15 minutes	8 minutes
Full Load Exposure	4 hours	2 hours	1 hour
Max. Recoat Time	<b>Maximum recoat window at 77°F (25°C) is 30 minutes. Surface needs to be roughened before applying subsequent coat if 30 minutes is exceeded.</b>		

## 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 6 months of receiving.

## 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. 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

