

TECHNICAL DATA SHEET

METAL TECH SG



Fast-curing, two-component epoxy metal repair compound

Thortex Metal Tech SG is a synthetic metal repair compound in stick form, specifically selected for on-site repairs of metal components such as leaking pipes, tanks, ducts, radiators.

Thortex Metal Tech SG is formulated on a unique system of epoxy resins co-agitated with a sulphuroamine mixture and then mixed with specifically selected pigments and fillers, allowing the base and activator to be packaged in close contact with each other. The reaction only occurs when the two components are mixed by hand and the resulting mixture produces a repair material with high physical and mechanical strength.

Before proceeding, please read the following instructions carefully to ensure correct understanding of the application procedure.

SURFACE PREPARATION

Remove all heavy oil and grease contamination with **Thortex Universal Cleaner**.

Remove all loose materials, rust and surface contamination, including existing coatings and roughen the surface using an angle grinder, needle gun or abrasive blasting. Where a sander is used, cross passes should be made to improve adhesion. When angle grinding, take care not to polish rather than roughen metal surfaces.

Surfaces must be thoroughly degreased with **Thortex Universal Cleaner**. Change cloths frequently to avoid spreading contamination. On heavily painted surfaces or porous moulds **Thortex Universal Cleaner** must be worked into the surface with a brush and then washed off using the remaining cleaner.

Surfaces that are to remain in place during application but must not adhere to **Thortex Metal Tech SG** must be coated with **Thortex Release Agent**

MIXING

Before mixing, treat your hands with an appropriate protective cream or wear light disposable gloves.

Cut or break off from the stick a sufficient amount of product for the repair. Work it in by twisting until the colour is uniform without streaks. The two components are colour-coded to ensure complete mixing when the colour is uniform.

Thortex Metal Tech SG must be used within 5 minutes after mixing if at 20°C.

Less time at higher temperatures and more time at lower temperatures.

APPLICATION

The prepared surfaces must be dry. Press the mixed material firmly onto the prepared area, working it into every break and surface defect.

When **Thortex Metal Tech SG** is used to repair leaking pipes, the flow in the pipe must be stopped until the repair is completed and **Thortex Metal Tech SG** applied. Any liquid leakage must be wiped from the surface to make the surface as dry as possible before undertaking the repair.

All tools must be cleaned IMMEDIATELY after use with **Thortex Universal Cleaner**.

Specific volume
66 cm³ per unit.

Detailed instructions are available from the Technical Centre on request.



PHYSICAL CONSTANTS

Mixing ratio

Supplied ready for use.

Aspect

Stick with the consistency of a concentric coloured putty.

Drying and curing times at 20°C

Time of use	5 minutes
Initial curing	30 minutes
Machining time	30 minutes
Full polymerisation	1 hour

Solids Volume 100 %

Volatile Organic Substances None

Shelf Life

Use within 5 years from the date of purchase. Store in original sealed containers at a temperature between 5° and 30°C.

PHYSICAL PROPERTIES

Flexural strength 3250 psi
ASTM D790

Compressive strength 5000 psi
ASTM D695

Shear Tensile Adhesion 650 psi
ASTM D1002

Hardness (Rockwell R) 85
ASTM D785

Corrosion resistance 5.000 hours
ASTM B117

HEALTH AND SAFETY

If the usual rules of caution are used, **Thortex Metal Tech SG** is safe to use.

Protective gloves and other recommended personal protective equipment should be used during use. Before mixing and applying the material, make sure you have read and fully understood the safety data sheet.

PACKAGE

Supplied in 125gm packs.

Health and safety

The information contained in this data sheet is to be considered as general information only. It is given in good faith without any liability on the part of the manufacturer for the use which will be made of the product or this information, since this is beyond the control of Thortex Italia. The user must determine the suitability of the product by his own technical tests.

Legal notes

The data in this data sheet are provided for information only and are believed to be reliable at the time of issue. We cannot accept responsibility for results obtained by others for which methods we have no control. It is the responsibility of the customer to determine the suitability of the product for use. Thortex UK accepts no liability arising from the use of this information or the product described herein.

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