

PRODUCT SPECIFICATION SHEET:

REPCO 1104 ST Fluid Stick

PRODUCT DESCRIPTION

RepcO 1104 ST Fluid Stick is a two component fast curing solvent free epoxy metal repair fluid. The product has been designed for use on a wide range of surfaces and is tolerant of less than ideal surface preparation and surfaces contaminated with low viscosity oil/ lubricants.

TYPICAL APPLICATIONS

Suitable for emergency repairs to worn surfaces, as an anti-slip system for metallic substrates and for resurfacing and sealing leaking transformers.

The material can also be used as a gap filling adhesive.

GENERAL PRODUCT INFORMATION

Appearance

Base: Black Fluid
Activator: White Fluid
Mixed: Mid grey Fluid

Mixing Ratio

By weight: 1:1
By volume: 1:1

Density

Base: 1.8
Activator: 1.8
Mixed: 1.8

Volume Capacity

555cc/Kg

Solids content

100%

Slump Resistance

Nil at 3mm

Working life

Working life will vary with temperature. Increases in temperature will reduce the working life of the product. As a guide the usable life of the material is:

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

Cure Times

At 20°C (68F°) the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. Times will be extended at lower temperatures and reduced at higher temperatures As a general rule these times will be doubled at 10°C and halved at 30°C.

Temperature	Movement without load or immersion	Machining and light loading	Full mechanical Loading	Full Immersion
10°C/50F°	2 Hours	4 Hours	16 Hours	16 Hours
20°C/68F°	45 Mins	2 Hours	8 Hours	8 Hours
30°C/86F°	30 Mins	1 Hours	4 Hours	4 Hours
40°C/104F°	15 Mins	30 Mins	2Hours	2 Hours

Coverage Rate

200gm (0.44lb) of fully mixed product will give the following coverage rates –
0.111m² at 1mm 1.2ft² at 40mil

800gm (1.76lb) of fully mixed product will give the following coverage rates –
0.444m² at 1mm 4.75ft² at 40mil

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

Storage life

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

CHEMICAL RESISTANCE

The product resists attack by a wide variety of low concentration inorganic acids, alkalies, salts and organic media. Refer to the Resimac Technical Centre for advice.

HEAT RESISTANCE

Tested to ASTM D648 at 264psi fibre stress.

20°C Cure 60°C
100°C Cure 98°C

Heat Resistance

Suitable for long term water immersion at temperatures up to 60°C.

Resistant to dry heat in excess of 130°C dependent on load.

PRODUCT SPECIFICATION SHEET:
REPCO 101 Metal Repair Paste

MECHANICAL PROPERTIES

Testing is typically done under laboratory conditions at a temperature of 20°C unless otherwise specified.

Adhesion

Tensile Shear when tested in accordance with ASTM D1002 on abrasive blasted mild steel with a 75 micron profile will typically be:

185kg/cm² 2,630 psi 18.1 MPa

Compressive strength

When tested in accordance with ASTM D 695, typical values will be:

185kg/cm² 2,630psi 18.1 MPa

Corrosion Resistance

When tested in accordance with ASTM B117 the material shows no sign of corrosion after:

Minimum 5000 hours Exposure

Flexural Strength

When tested in accordance with ASTM D790 typical values will be:

703kg/cm² 10,000psi 68.9 MPa

Hardness

Rockwell R

Tested to ASTM D785 typical value will be: 85

Lap Shear

Tested to ISO 4587

240kg/cm² 3400psi 23.4 MPa

Food Contact

USDA compliant for incidental food contact.

HEALTH AND SAFETY

Please refer to the product safety data sheet for detailed information on handling, storage, shipping and disposal.

TECHNICAL SUPPORT

Zoom Corrosion Technology offer complete technical support and assistance, from discussing application requirements to training approved local contractors. For further information please contact a REPCO representative or your nearest REPCO authorised dealer.

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RepcO products are manufactured for:

Zoom Corrosion Technology
Pembroke Lodge, 3 Pembroke Road, Ruislip,
HA4 8NQ, England, UK
Tel: +44 (0) 794 934 1074
Email: sales@zoomct.com
www.zoomct.com

