

PRODUCT DESCRIPTION

Repcomp 3302 Epoxy Repair Paste is a high performance two component, solvent free epoxy repair system for use on metallic surfaces. Repcomp 3302 Epoxy Repair paste is ideal for applications where only minimal surface preparation can be carried out.

- Apply to mechanically & abrasive blast cleaned surfaces
- Hi Build capability up to 20mm
- Bonds to a wide range of metallic substrates

TYPICAL APPLICATIONS

Suitable for building substrates suffering corrosion pitting, contouring, flange forming such as -

- Internal external pipelines
- Internal external of storage tanks
- Ships Hulls
- Offshore structures

SURFACE PREPARATION

STEEL SUBSTRATE

This product is tolerant of less than ideal surface preparation and will adhere to surfaces prepared using hand tools, Mechanical Tools and Hydro-blasting. All surfaces must be mechanically abraded using handheld grinders to *ISO 8501/4 ST2 (SSPC SP3 ST2)*.

Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be repaired before rusting or oxidation occurs.

MIXING AND APPLICATION

PRECAUTIONS

Ensure the Base component is 15-25°C (60-77°F) before mixing and do not apply when the ambient or substrate temperature is below 5°C (40°F) or less than 3°C (37°F) above the dew point

MIXING

If part mixing the unit of material please follow the instructions below:

1. Using the spatula provided place 1 equal measure from the base unit onto the mixing board provided.
2. Clean the spatula thoroughly.

3. Then take 1 equal measure from the activator unit and place alongside the base measure.

4. Mix the 2 components together until you have a streak free mix on the mixing board.

5. Ensure there is no unmixed material on the spatula or mixing board.

If mixing a complete unit of material (200gm/1kg/3kg) please follow the instructions below:

1. Dispense as much of the base and activator units onto a clean mixing surface.

2. Mix the 2 components together until you have a streak free mix on the mixing board.

3. Ensure there is no unmixed material on the spatula or mixing board.

From the commencement of mixing, the material should be used within 30 minutes at 20°C (68°F).

APPLICATION

Using a spatula or applicator tool, apply the material to the prepared surface. Ensure the product is firmly pressed into any pitting, holes, scars or cracks. Once the repair has been completed smooth off any imperfections using a gloved hand before the product fully cures. The material can also be dressed down by sand paper, files or grinder.

COVERAGE RATES

A 1kg (2.2lb) of fully mixed product will give the following coverage rates –

0.625m² at 1mm 6.7ft² at 40mil
0.313m² at 2mm 3.3ft² at 80mil
0.208m² at 3mm 2.2ft² at 80mil

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

TECHNICAL DATA SHEET: REPCOMP 3302 EPOXY REPAIR PASTE

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. These times will be extended at lower temperatures and reduced at higher temperatures:

Usable life	35 minutes
Touch Dry	6 hours
Hard Dry	12 hours
Full Cure	2 days

OVERCOATING TIMES

Minimum - the material can be over-coated as soon as it is touch dry.

Maximum - the over-coating time should not exceed 24 hours.

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.

UNIT SIZES

Product is available in the following pack sizes –

200gm (0.44lb)
1kg (2.2lb)
3kg (6.6lb)

COLOURS

Mixed Material	Dark Brown
Base Component	Dark Brown
Activator Component	Light Brown

STORAGE LIFE

The shelf life of the product is typically 5 years if unopened and stored in cool dry conditions (15-30°C/ 60-86F°).

TECHNICAL DATA

Please see the REPCOMP 3302 Epoxy Repair Paste Product Specification Sheet for detailed technical and performance data.

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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