

General Repair and Build-up Applications

Typical Applications :

Machine frames, cast iron housings, transformer lines, keyways, etc.

Outstanding Features :

- Resistance to atmospheric oxidation
- Colour very close to grey cast iron
- Can be machined with tungsten carbide tools, drilled, tapped & painted
- Can be used in all positions

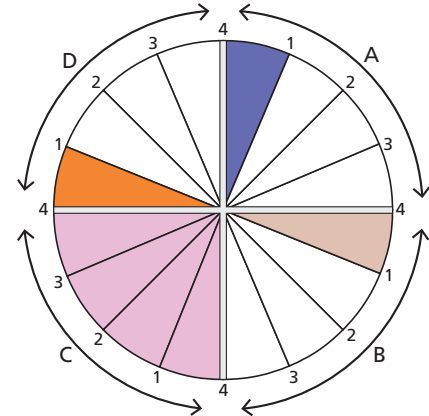
Procedure:

- Mix Ratio (by weight) : 3:1
- Pot-life of mix @ 30°C : 15 – 20 minutes
- Hardening Time @ 30°C : 16 hrs

Clean job surface thoroughly with acetone or industrial thinner to remove grease, oil, paint etc. Activate the surface by grit blasting, grinding, filing or rough machining to achieve surface roughness for the best mechanical bonding of POLYPASTE. The contents in the containers of Compound (X) and Reagent (XX) have distinct colour shades. Transfer entire content of Reagent (XX) into the container of Compound (X) OR measure out Compound (X) and Reagent (XX) in exact proportion as per mix ratio. Mix the two contents thoroughly to obtain a homogeneous paste with uniform colour. First apply a thin layer of POLYPASTE on the job surface with spatula or applicator to wet the surface. Press POLYPASTE firmly in cavities and ensure that no air pockets / voids are left in the deposit. Deposit can be built up to the required thickness by applying more POLYPASTE in thin layers in each stroke with little pressure to avoid air entrapment. Allow the deposit to cure and harden. Finish the deposit to required size by grinding or machining.



Cylinder Head



■ A - Setting Time	1
■ B - Abrasion	1
■ C - Machinability	4
■ D - Corrosion	1

Hardness : Shore D 80

