



## SURFACE PREPRATION, MIXING & APPLICATION TECHNIQUES

### **HYPOXY STEELFAST H120 – FOR REPAIRING STEEL & CAST IRON CASTING DEFECTS.**

Surfaces must be clean, dry, free from oil / grease etc.

Take a round rod / bar / screwdriver and mix entire contents of resin jar to ensure no solid material is left at the bottom and no lighter chemicals float on the top of resin jar.

Take another rod / bar / screwdriver and mix entire contents of hardener jar likewise.

Take a flat steel / plastic plate to be used for mixing resin & hardener throughly.

Using resin bar / rod, take out 2.5 PART OF RESIN MATERIAL BY VOLUME from the resin jar and make a puddle on a flat steel mixing plate.

Using hardener bar / rod, take out 1 PART OF HARDENER MATERIAL from the hardener jar and make a puddle aside of resin puddle.

Ensure that resin puddle is 2.5 times bigger ( BY VOLUME ) than the hardener puddle.

**IF COLOUR MATCHING IS NEEDED, THEN MIX VERY SMALL PORTION OF WHITE / BLACK PIGMENT SUPPLIED SEPRATELY IN THE RESIN MATERIAL TAKEN OUT ON THE PLATE SO AS TO GET THE DESIRED COLOUR SHADE.**

**THE COLOUR PIGMENT PORTION IS MIXED IN RESIN IN SUCH A MANNER SO THAT FINAL COLOUR OF THE RESIN + PIGMENT + HARDENER MIXTURE IS CLOSEST TO THE DESIRED COLOUR SHADE OF THE CASTING**

Once done so, now take a third mixing bar / rod and mix resin + pigment (if needed) and hardener throughly on the flat steel / plastic plate.

Mix thoroughly, making certain that all of the hardener mixed with resin + pigment (if needed) & comes in contact with all of the resin.

Apply the mixed compound by hand finger or with putty knife, spatula, or similar tool on the casting which needs to be repaired.

The Hypoxy H120 STEELFAST has a pot life of 5 minutes at room temperature so ensure that all the resin & hardener material mixed for atleast 2 minutes vigorously till you get homogeneous mixture and used and applied on casting before the mixture gets hard.

The applied Hypoxy Steel Fast material on the repaired casting will get hard in 30-40 minutes time.

However keep the repaired casting for atleast 3-4 hours so that complete chemical reaction takes place and the applied titanbond material on the defect area gets full mechanical strength and bond completely with the parent casting surface.

After 4 hours, wipe out the extra material applied on the casting surface by using buffing wheel, grinder, sand paper or suitable tool and ensure to make fine surface finish.

Now send the repaired casting for next process of machining or powder coating or zinc chromating or painting etc as needed.

#### **NON-WARRANTY:**

We can accept no responsibility or liability for lack of results because the storage, handling, and application of the compound is beyond our control.

**PL CALL IN YOUR LOCAL AUTHORISED DEALER TO GET FULL ADVANTAGE OF PRODUCT TRAINING AND KNOW HOW TO MAKE MORE USE OF HY POXY PRODUCTS.**



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