

# HUDCO CMP Metal Fast

HUDCO CMP METAL FAST is highly reactive polymer matrix densely filled with 316L stainless steel. When cured, Metal Fast is machinable and provides excellent results in emergency situations. It offers the only fast-curing ceramic-metal polymer repair system that has superior bond, high performance strength and excellent storage stability. At 75° F, it "gels" in approximately 3 minutes and will cure hard enough to be machined in 15 minutes to 1 hour (depending upon "heat sink" of part).

## Typical Applications

HUDCO CMP METAL FAST Enables Fast Emergency Repairs To:

- Cracked Castings
- Scored Shafts
- Damaged Hydraulic Rams
- Valve Bodies
- Leaky Pipes
- Stripped Threads

## Physical Properties

|                      |                  |
|----------------------|------------------|
| Mixing Ratio (R:H)   | 2:1 by Weight    |
| Color                | Grey             |
| Initial Cure Time    | 45 Min. @ 75° F  |
| Final Cure Time      | 24 Hours @ 75° F |
| Gel Time             | 6 Min. @ 75° F   |
| Pot Life             | 3 Min. @ 75° F   |
| Lap Shear Strength   | 3,450 PSI        |
| Compressive Strength | 10,400 PSI       |
| Specific Gravity     | 1.74 Mixed       |
| Temperature max      | 200° F           |

## Packaging

| Resin        | Curing Agent | Coverage                   | Kit Weight |
|--------------|--------------|----------------------------|------------|
| .42 lbs. x 4 | .21 lbs. x 4 | 5.08 Sq. Ft. @ 1/16" Thick | 2.5 lbs.   |



*This reference guide is not intended as a substitute for the product label for the products referenced herein. Product labels for the above products contain important precautions, directions for use and product warranty and liability limitations that must be read before using the product. Applicators must be in possession of the product label(s) at the time of application. Always read and follow all label directions and precautions.*

## Application Instructions

### Surface Preparation:

(A) Surface of substrates must be clean and sound. Remove grease, oil, or other foreign material with acetone, wire brushing, or sandblasting. Acid etching the surface is acceptable if followed by thorough flushing with clean water.

(B) Roughen surface by grinding or sandblasting (3-5 mil surface profile) Surface must be completely dry with a minimum surface temperature of 75° F before applying.

Mixing: Mix 2 parts of CMP Metal Fast Resin to 1 part of CMP Metal Fast Hardener by weight. Kits are supplied in the correct ratio. Ensure that the sides of the mixing container are scraped into the mixture. Mix several minutes, until consistent color is achieved.

Application: Apply product to prepared surface and use supplied tools to achieve desired finish.

Curing: At 75°F, product will gel in 3 minutes. Initial cure will occur in 45 minutes. Final Cure occurs in 24 hours. Curing can be accelerated by heating the applied product to 140°F. Product properties will also be improved by curing at this elevated temperature.

## Safety Precautions

CAUTION: For Industrial Use Only. Keep Away From Children.

HUDCO CMP Metal Fast Resin contains epoxy resin which is harmful if swallowed. After prolonged exposure it may irritate skin and cause sensitization and/or dermatitis.

HUDCO CMP Metal Fast Curing Agent contains organic amine compounds which are harmful if swallowed. After prolonged exposure or repeated skin contact it may cause irritation, sensitization and/or dermatitis.

### Emergency and First Aid Procedures

- Eye Contact - Irrigate with clean water for 15 minutes and call a physician.
- Skin Contact - Wash with soap and water.
- Inhalation - Remove to fresh air and provide oxygen if necessary.
- Ingestion - Call a physician at once. Give milk or white of egg beaten with water. Then give a teaspoon of salt in a glass of warm water to induce vomiting.

### Protection Procedures

If used in a confined or an enclosed area, use an air supplied mask or respirator with canister for organic vapors and provide mechanical exhaust ventilation. Use protective gloves, safety glasses, and protective clothing. Avoid contact with skin and clothing. Contaminated clothing should be laundered before wearing again. Contaminated shoes should be thoroughly cleaned before wearing again.

## Storage

HUDCO CMP Metal Fast Resin and Curing Agent should be stored in a cool, dry area. Shelf life is a minimum of one year in unopened containers when stored at 70° F – 85° F.

## Warranty

Because the storage, handling and application of these materials are beyond our control, we can accept no liability for the results of their use. Our liability is limited only to replacement of any material proven defective in manufacture. We suggest users try small applications to determine the suitability of the product for their intended use.

### HUDCO Industrial Products, Inc.

3100 Morgan Road  
Bessemer, AL 35022  
**1-800-247-9908**

Fax: 205-425-4011  
Email: sales@hudcoinc.com  
Website: www.hudcoinc.com



*This reference guide is not intended as a substitute for the product label for the products referenced herein. Product labels for the above products contain important precautions, directions for use and product warranty and liability limitations that must be read before using the product. Applicators must be in possession of the product label(s) at the time of application. Always read and follow all label directions and precautions.*