

HUDCO Industrial Products, Inc.
Machinable

HUDCO CMP Metal Fix

HUDCO CMP METAL FIX is formulated from high performance polymers filled with 316L stainless steel to provide excellent repair capabilities for damaged metal. Metal Fix forms an exceptionally strong bond to many substrates, including steel, cast iron, stainless steel, wood, concrete, and many rubbers and plastics. It is machinable using common metal cutting equipment. Metal Fix cures at temperatures down to 32° F enabling repairs to be made in adverse conditions.

Typical Applications

Permanent repairs with HUDCO CMP METAL FIX include:

- Scored/worn areas on shafts
- Cracked castings with exception strength
- Worn out bearing housing to new specs
- Scored hydraulic rams
- Heat exchange housings
- Valve bodies
- Damaged keyways

Physical Properties

Mixing Ratio (R:H)	2:1 by Weight
Color	Grey
Initial Cure Time	6-8 Hours @ 75° F
Final Cure Time	24 Hours @ 75° F
Pot Life	40 Min. @ 75° F
Lap Shear Strength	4,200 PSI
Compressive Strength	12,100 PSI
Specific Gravity	2.3
Temperature max	200° F

Packaging

Resin	Curing Agent	Coverage	Kit Weight
1.46 lbs.	.73 lbs.	2.84 Sq. Ft. @ 1/16" Thick	2.2 lbs.
2.92 lbs.	1.46 lbs.	5.68 Sq. Ft. @ 1/16" Thick	4.4 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 Fix Resin to 1 part of CMP Metal Fix 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 20 min. Initial cure will occur in 6 - 8 hours. Final Cure occurs in 1 Day. 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 Fix 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 Fix 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 Fix 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.

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