

EXTENDED LIFE SUPER METAL REBUILDING SYSTEM

ThistleBond

A Division of E. Wood Ltd., U.K.



ThistleBond 'Extended Life Super Metal Rebuilding System' is a high performance multi purpose synthetic metal repair compound specifically developed for metal repairs requiring good mechanical strength combined with easy machining properties and where additional working time is essential during application period.

ThistleBond 'Extended Life Super Metal Rebuilding System' is formulated on a complex range of polymer resins combined with a polyamino curing system reinforced with a phosphor steel alloy to enhance corrosion and chemical resistance of the whole system.

The superior compressive strength, hardness along with its adhesive tensile strength makes 'Extended Life Super Metal Rebuilding System' suitable for repairing worn out metal components, it can be machined, ground, drilled and tapped to the required accurate dimensions.

SURFACE PREPARATION & APPLICATION PROCEDURE

Parts which are to be repaired and rebuild should be thoroughly cleaned with ThistleBond 'Cleaner'. Worn out surface must be roughened by filing, nurling, emery cleaning preferably by at least 1mm depth 12 TPI thread cutting to increase surface contact area for proper adhesion. If shaft, housing or end cover fitted on lathe for repair, the surface is advisable to clean once again with 'Cleaner'. 'Extended Life Super Metal Rebuilding System' to be mixed in the advised ratio and mix properly until single colour paste appears. Apply material over prepared surface and wet surface properly then apply remaining material over the surface and press firmly to remove entrapped air. Ensure to apply material at least 1 mm in excess than required dimension, required for machining. Applied material will get initial setting in 45 minutes then do machining exactly after 2 hours as per instruction mentioned above. After machining excellent smooth surface can be achieved with superior hardness and the repaired area will attain required engineering properties to take care of high compressive loads.

EXTENDED LIFE SUPER METAL REBUILDING SYSTEM

PHYSICAL PROPERTIES

Flexural Strength	560 kg/cm ²
ASTM D790	(8000 psi)
Compressive Strength	700 kg/cm ²
ASTM D695	(10000 psi)
Tensile Shear Adhesion	175 kg/cm ²
ASTM D1002	(2500 psi)
Heat Distortion	60 °C
ASTM D648	
Hardness (Shore D)	85
ASTM D2246	
Corrosion Resistance	5000 hours
ASTM B117	

PHYSICAL CONSTANTS

Mixing Ratio	Resin	Hardner
By volume	1	1
Appearance	Resin	Hardner
Paste	Dark Grey	Light Grey
Drying Time @ 20°C		
Usable Life	60 Minutes	
Initial Set	4 Hours	
Machining	12 Hours	
Volume Solids	100%	
VOC	Nil	
Operating Temperature	Maximum	Continuous
Dry Heat	250 °C	120 °C
Wet Heat	120 °C	70 °C
Shelf Life	5 years	

CHEMICAL RESISTANCE *

Acetic Acid 0-10%	Good
Hydrochloric Acid 0-20%	Excellent
Nitric Acid 0-10%	Excellent
Hydraulic Oil / Transformer Oil	Excellent
Nitrous Oxide	Excellent
Liquid Petroleum	Excellent
Chlorine	Satisfactory
Sulfuric Acid 0-20%	Excellent
Sulphur Dioxide	Excellent
Sea Water	Excellent

SUPPLY INFORMATION

Stock No : TR115

Description : Extended Life Super Metal Rebuilding System

Pack Size : 3 kg

* for further information see Chemical Resistance Chart

RECOMMENDED APPLICATIONS

- Worn shafts, oversized bearing housings, motor end covers
- Cracked cases / casings & blocks, gearbox housings, metal cracks
- Damaged flanges, scored hydraulic rams, rebuilding of collors
- Leveling of base plates, machine beds
- Repair of pinholes / blow holes, pitting in castings
- Rebuilding / machining of parts to accurate dimensions

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