

HPR-518-WM

HPR-518-WM is a two component repair material in stick form which cures underwater after mixing. It is a metal repair adhesive which develops high mechanical strength in a short period of time.

Typical Applications

Suitable for emergency repairs to leaking pipe work, tank seams, and flanges.

Surface Preparation

The material is suitable for application to manually prepared surfaces, all loose material such as old coatings and repair materials must be cleaned from the surface prior to application.

Mixing and Application

The product is supplied in stick form and therefore the base and activator component are premeasured. Simply break off the required amount of material from the stick and using gloved hands knead the product until the green and cream components become a consistent light green. The product once fully mixed has a usable life of 15mins at 20°C.

Once a consistent mix has been achieved apply the material by pressing the putty onto the prepared surface.

Cure Times

At 20°C the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Usable Life	15mins
Hard Dry	45mins
Machining and light loading	45mins
Full loading	90mins
Immersion	90mins

Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry.

Maximum - the over-coating time should not exceed 3 hours.

Where the maximum over-coating time has been exceeded the surface should be abraded and cleaned.

Storage Life

5 years if unopened and store in normal dry conditions (15-30°C)

Technical data and Performance

Compressive Strength ASTM D695	446kg/ cm ² 6350psi
Tensile Shear Adhesion ASTM D1002	70kg/ cm ² 1000psi
Flexural Strength ASTM D790	510kg/ cm ² 7275psi
Hardness Rockwell R ASTM D785	85
Corrosion Resistance (ASTM B117)	5000 hours

Health and Safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read the fully detailed Material Safety Data Sheet.

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