

A.W.F. E.M. ALL PURPOSE METAL

AWF All Purpose Metal is a high performance multi purpose synthetic metal repair compound specifically developed for metal repairs requiring good mechanical strength combined with easy machining properties.

AWF All Purpose Metal can be applied to any damaged component in one easy application and is ideal for repairing worn shafts, oversized bearing housings, cracked cases and blocks, damaged flanges, sloppy keyways and scored rams.



Preparation

Heavy contamination due to oil or grease must first be removed using AWF All Purpose Cleaner. All loose material, rust and surface contaminants including existing coatings, must be removed and the surface roughened by using an angle grinder, needle gun or abrasive blasting. Where grinder or needlegun is used the surface must be cross-scored to improve adhesion. Care must be taken when angle grinding to avoid polishing rather than roughening metal surfaces. Where possible, abrasive blasting is the preferred surface preparation especially fluid flow repairs. Surfaces should finally be carefully degreased using AWF All Purpose Cleaner.

Parts (for example threads or bearing surfaces) which remain in position during application but must not adhere to All Purpose Metal must be coated with AWF Release Agent or similar prior to application of E.M. All Purpose Metal.



Mixing Ratio

AWF E.M. All Purpose Metal is a two part material consisting of a Base & Activator Resin. Measure 3 volumes of base component and 1 volume activator component onto a clean mixing board or other suitable surface. The two components should then be thoroughly mixed until streak free. The mixed material should be used within 25 minutes of mixing at 20°C. This time will be reduced at higher temperatures and extended at lower temperatures.

<u>Mixing ratio:</u>	<u>Base</u>	<u>Activator</u>	
	3	1	by volume
	5	1	by weight



Curing Time

Drying, Curing times@ 20°C.

Initial set:	60 mins
Machining:	2 hours
Full mechanical:	3 days



Pot Life

Once you have mixed the Base & Activator together, you have approximately 25mins to use the mixed material



Use within 5 years of purchase.

Store at temperatures between 5° and 30°C.



As long as good practice is observed AWF All Purpose Metal can be safely used.

Protective gloves should be worn during use.

A fully detailed Material Safety Data Sheet is available on request.

If you have any questions or queries regarding this data sheet or the application of this product, please contact us before you use the product.