

M 5 Epoxy Product Packing



945ml part A/B



3.7L part A/B

M 5 Epoxy is a "5-Minute" epoxy filler

M 5 Epoxy with extreme adhesion even to underwater surfaces. Used primarily as a pressure-transfer filler under high-pressure pipeline repair composites.

is based on a unique blend of liquid epoxy polymer and proprietary curing agents, which is able to displace water from wet surfaces in order to make a permanent bond. The formulation is solvent-free to ensure safety and maximum technical performance. KevlarTM* fibers are incorporated for reinforcement and viscosity management to assure reliable application even under adverse conditions.

M 5 Epoxy is supplied in a standard white base, which is mixed with an equal volume of black curing agent to yield approximately Haze Gray when thoroughly mixed. The formula is uniquely field-friendly using advanced low toxicity ingredients and can be shipped airfreight "Non-Regulated" by USDOT, IATA and IMO.

* Kevlar is a trademark of E. I. DuPont de Nemours Co.

Recommended Uses:

REPAIR COMPOUND:

Patching, leak sealing etc. under all conditions.

ADHESIVE:

Excellent all-purpose adhesive for use above and below water.

Product	Part A	Part B	Mixed Color
M 5 Epoxy	White	Black	Dark Grey

Technical Information:

VEHICLE TYPE : Epoxy/proprietary

PIGMENTATION : Colour/Inert/fibrous reinforcement

COLORS : Dark Gray

FINISH : Slight texture

THINNER : Not normally required

CLEANER : MEK or lacquer thinner

MIXING RATIO : 1.0/1.0 v/v

INDUCTION TIME : Not required

POT LIFE : Approx. 3' / 25°C

FLASH POINT : Over 94°C

SOLIDS BY VOLUME : 100%

SPREADING RATE/GAL : 39.4 mil/sq. m²./L

DRY TIME, (Dust free) : 5 mins. at 25°C

DRY TIME, (Service) : 5 – 10 mins. Light duty, full cure in about 12 hours

APPLICATION METHOD : Spatula

STORAGE CONDITIONS : Normal, Freezing OK

VOC : Essentially zero

Initial Preparation:

Before beginning to mix the **M 5 Epoxy** components make a mental "run-through" of the job and prepare as much as possible beforehand. A pot life of 3 minutes gives ample time to take care of most situations but time quickly runs out if tools have to be found or valves turned off during a job

Surface Preparation:

Scrape or remove all loose contamination around the immediate repair site. Abrade the area using coarse abrasive paper or a mechanical grinder to provide a firm anchor for the repair material.

Mixing Procedure:

M 5 Epoxy is supplied in equal volumes of white epoxy base and black curing agent. Remove equal quantities of base and curing agent from their cans and place them side-by-side on a surface of plastic, fibreboard etc. Mixing is easily accomplished by folding the components into each other using a spatula. Once mixing begins there will be about 3 minutes of working time available at 26°C, mixing will consume not more than 1 minute of this time. When mixing is complete the product will be a uniform Dark Gray colour with no streaks of unmixed white or black components. Pot life will be extended underwater by immediately immersing the mixed materials.

Application:

1) **UNDERWATER** Take the mixed **M 5 Epoxy** underwater in a can or bucket, it will free up a hand to have a hook on a belt to hold the can during application. Applicators such as broad putty knives or plastic straight-edged glue spreaders work well on most surfaces. Industrial latex gloves work well on small diameter tubular sections such as risers. **M 5 Epoxy** is resistant to the effects of wave application during curing and will be found to be easier to apply than traditional "splash-zone" compositions and much less messy than lower viscosity underwater "paints". **M 5 Epoxy** has a strong tendency to stick to underwater surfaces and expensive equipment should be protected using plastic suits or sacks to cover exposed surfaces

2) **ABOVE WATER:** Use as a regular adhesive by mixing the quantity desired and applying to clean surfaces until set in 4 – 5 minutes. When used with MAC tape for leak sealing. Apply the tape to the repair area and wrap around holding firm pressure on the free end" as the tape wraps around the pipe it will become possible to pull down very tightly. Over- lap previous wraps by at least 1/2" in a spiral fashion and avoid wrinkles. At least three (4) wraps are recommended for excellent strength around a pipe repair. (Four wraps have been tested to well over 1,000 psi over a 1/4" hole in a 1" diameter test piece 24 hours after application).

Curing Before Service:

MAC Epoxy may be immersed in fresh or salt water immediately after application. It will cure to a hard film within about 14 hours and is suitable for traffic after this time. Allow at least three (3) days at 25°C before subjecting to aggressive chemical service from industrial solvents and similar materials.

WE URGE YOU TO READ THE SAFETY DATA SHEET (SDS) BEFORE USING AND TO CALL METALOK360, AS NECESSARY FOR ADVICE OR INFORMATION BEFORE ANY ACTUAL OR CONTEMPLATED APPLICATION.

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SAFETY: This is a hazardous material if misused. Read and understand the Safety Data Sheet (SDS) before use.

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