

RR&C Metal Repair Paste Fast Cure

SELECTION & SPECIFICATION DATA

Type	Novolac Epoxy
Description	RR&C Metal Repair Paste Fast Cure is a fast-setting version of RR&C Ceramic Repair Paste High Temp, a high-performance paste-grade novolac repair compound for shop and field repair and rebuilding of equipment. It is ideally suited for fixing tank leaks, piping, and electrical bushings and for setting keyways or taper fits when fast turnaround is critical.
Features	<ul style="list-style-type: none"> • Fast cure for emergency repairs • Complies with ASME PCC-2, Article 4.1 as long-term repair • Outstanding bond strength • Excellent chemical resistance • Machinable • Non-shrink and low-slump for repair of vertical surfaces • Surface tolerant and moisture tolerant
Uses	<ul style="list-style-type: none"> • Metal cooling tower pans • Emergency tank and pipe repairs • Weld repairs • Electrical bushings • Setting keyways and taper fits • Repair of metal, fiberglass, composite, PVC and similar plastic materials
Color	Dark gray
Finish	Satin
Solids Content	99 - 100% by volume

SUBSTRATES & SURFACE PREPARATION

All	Surfaces must be clean, dry and free of contaminants.
Steel	<p>Immersion: SSPC-SP 10/NACE 2 Near White Metal Blast with angular profile of 2.5 - 3.5 mils.</p> <p>Non-immersion: SSPC-SP 6/NACE 3 Commercial Blast with angular profile of 1.5 - 3.0 mils, SSPC-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.</p> <p>Self-priming on steel.</p>
Weld Repair	Use a flame to sweat out oil from deeply impregnated surfaces. Stabilize cracks by drilling the extremities. Long cracks should be drilled, tapped and bolted every few inches. Vee-out all cracks using a file. Degrease using clean rags.

MIXING & THINNING

Mixing	Thoroughly mix the two parts, supplied in pre-measured sachet packs, until no streaks are seen.
	Mix no more product than can be applied in 5 minutes.
Pot Life	5 minutes at 77°F (25°C)
	Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.
Multiple Layers	If building layers or pipe wrapping with reinforcing cloth, apply the coating within the recoat window. If this is not possible, allow the compound to cure, then create a mechanical profile by grit blasting, grinding or power tool sanding the surface before coating.
Cleanup	MEK or Acetone

APPLICATION GUIDELINES

Conditions	Substrate surface temperature 50°F – 140°F (10°C – 60°C) and at least 5°F (3°C) above the dew point and rising. If surface temperature is above 140°F (60°C), consult with your Sherwin-Williams representative for guidance.
Application	Apply directly onto the prepared surface with the spreader or mixing knife provided. Press down firmly to remove entrapped air, fill all cracks, and ensure maximum contact with the surface. Use reinforcement tape over holes and cracks. Fully machinable using conventional tools once cured.
Brush & Roller	Brush or roller can be used to smooth uncured surface with solvent if desired.

CURE SCHEDULE & RECOAT WINDOW

	50°F (10°C)	68°F (20°C)	86°F (30°C)
Working time	10 minutes	5 minutes	2.5 minutes
Recoat window	40 minutes	20 minutes	10 minutes
Machining	1 hour	30 minutes	15 minutes
Mechanical service	1 hour	30 minutes	15 minutes
Chemical service	6 hours	3 hours	1.5 hours

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PACKAGING, ESTIMATING & HANDLING

ITEM#	PRODUCT	PACKAGING
MRPFC-BAGKT-SW	RR&C Metal Repair Paste Fast Cure, Dark Gray - Part A Resin, Dark Gray - Part B Hardener - Mixing knife, spreader, mixing board, latex gloves, sandpaper, alcohol wipe	2 x 6 oz (170 g) Kits Plastic Pouch Plastic Pouch
Theoretical Coverage	Each 170 g bag kit covers about 50 square inches at 1/8-inch thickness. Allow for loss in mixing and application.	
Storage & Shelf Life	Maintain product in original packaging and sealed until ready for use. Estimated shelf life is 2 years when stored in a dry area at 75°F (24°C). Actual shelf life may vary with storage conditions. Do not store below 40°F (4°C) or above 110°F (43°C). If there is any question with respect to the quality of the components, check reactivity prior to use. Consult with your Sherwin-Williams representative for assistance.	

SAFETY

Safety	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.
Ventilation	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

SERVICE TEMPERATURE

SERVICE	MAXIMUM TEMPERATURE
Dry	250°F (121°C)
Spill/splash	212°F (100°C)
Immersion	140°F (60°C)

Temperature limitations will vary with chemical exposure. Consult with your Sherwin-Williams representative for guidance.

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