

WORKING INSTRUCTIONS

1. Surface Preparation

Repair areas – excessive dirt, oil and grease should first be removed. The area then should be cleaned with Aceton or a similar degreaser. The surface should thoroughly roughened using sandblasting SA 2 ½ Angle grinder, needle gun or similar equipment to ensure a coarse profile is achieved.

Important !

After cleaning with Aceton or similar degreaser wait for minimum 30 min. to ensure that the cleaner Has disappeared even from inside the pores.

Areas where UNIREP compounds are not required to bond must be treated with UNIREP 95 Release Agent. In case that surface to be treated had been in contact with salt water or salty solutions, salt contaminations my sweat out within 24 hours and must again be removed before application.

2 Mixing

2.1. Paste Materials

should be mixed on a mixing board or other suitable clean surface. Put base and activator according to the tabula – MIXING RATIO AND CURE TIMES - in the volumes required.

Make use of different spatulas when taking out the base and the activator.

The two components should then thoroughly bee mixed until the mass is completely streak free.

The mixed material should then be applied within the usable life time of the specific material (see a.m. tabula).

2.2. Fluid materials

Fill in the activator component into the base container and stir till completeand streak free mixing is completed. It is advisable to go on stirring for one more minute.

3 Application

3.1.Paste materials

by spatula. The material should thoroughly been worked into the surface and open pores. Press firmly onto the prepared area. Work the material into any cracks and surface defects.

3.2. Fluid materials

By stiff brush or squeegee. The material should be applied on the surface very soon after surface preparation. If more than 24 hours have passed, check thoroughly for flash rusting if possible remove before application.

When required, UNIREP 96 reinforcement tape should be stippled into the first UNIREP lay.

Always provide a sufficient overlapping of the defect area.

Once the UNIREP compound reaches his initial set, material can be removed from areas previously treated with UNIREP 95 Release Agent.

4 Machining

Once the material has reached its machining cure time (see tabula MIXING RATIO AND CURE TIMES) It can be machined as per engineering practice.

Important! UNIREP 12, 13 and 20 are not formulated for machining, just grinding.

Machining on lathe: cutting speed 200 ft / min. / feed rate 50 thou/rev. / finishing 10 thou/rev.

**Don`t work under following conditions: Temperature below 5°C / Humidity exceeding 90%/
rain,snow,fog**