



MCBOND COLD WELDING COMPOUND

INSTRUCTIONS FOR USE

McBond is a High performance Metal filled epoxy compound, When mixed together, It reacts quickly to produce a tough & rigid Bond lasting repair or Rebuild critical equipment and quickly return It to service, Minimizing expensive downtime & reducing costs.

Minimum Recommended Preparation:

Power tool cleaning or with Sand paper to achieve a clean rough surface to make an application successful.

1.COMBINING THE REACTIVE COMPONENTS

Transfer the required amount of Resin and Hardener onto a Working Surface in the Ratio of 80:20.

Mix thoroughly together with a plastic spatula to achieve a uniform material free of any streakiness.

1(A). MIXING AT LOW TEMPERATURES

To ease mixing when the material temperature is below 50°F/10°C, warm the containers to between 68°F/20°C and 104°F/40°C.

1(B). WORKING LIFE

From the commencement of mixing, McBond must be used within the times shown below:

Temperature	Working Life
41°F/5°C	40 minutes
50°F/10°C	35 minutes
68°F/20°C	30 minutes
86°F/30°C	20 minutes
104°F/40°C	10 minutes

2. APPLYING MCBOND

- A) Apply the mixed McBond directly on to the prepared surface with a suitable application tool.
- B) Press down firmly to fill all cracks, remove entrapped air, and ensure maximum contact with the surface.
- C) Over cracks, gaps and holes, stipple in McBond (Reinforcement Tape).
- D) Contour the McBond to the correct profile with an applicator or allow the McBond to cure and then machine down if required.

CLEANING

Mixing and application tools should be cleaned immediately after use with the effective solvent e.g. Methyl ethyl ketone (MEK) or acetone.

4. COMPLETION OF THE MOLECULAR REACTION

Allow McBond to solidify as below before subjecting it to the conditions indicated.

Temperature	Machinable	Light Loading	Full Loading
41°F/5°C	2½ hours	5 hours	16 hours
50°F/10°C	2 hours	4 hours	12 hours
68°F/20°C	40 minutes	90 minutes	8 hours
86°F/30°C	30 minutes	60 minutes	5 hours
104°F/40°C	20 minutes	30 minutes	2½ hours

These times are for a thickness of approx. 0.25 in / 6 mm; they will be reduced for thicker sections and extended for thinner sections.

INSTANT CURE

For Instant cure, Use air heaters, heat lamps, etc. by giving heat of 10 -15 Minutes, Mcbond shall Cure within 30 Minutes and is safe for full Load Machining after 45 Minutes.

MC-RIX INDUSTRIES
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