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DURMETAL COLDWELD

QUICK GUIDE TO

DURMETAL®

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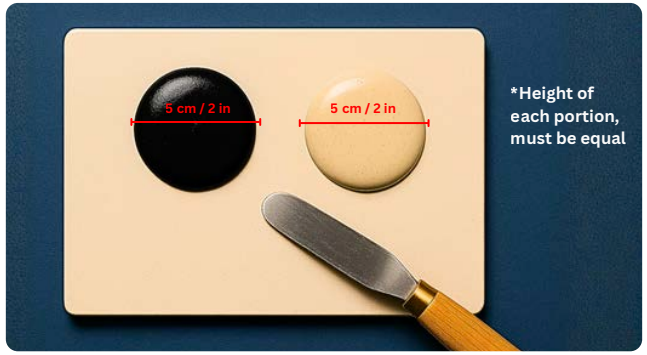
PHASE 1

Wear protective gloves and other personal protective equipment (PPE) when handling DURMETAL® products and always adhere to your own operational safety procedures, independent of DURMETAL® recommendations.

1. Roughen the repair surface with a grinder or rotary tool (such as a DREMEL® tool). If grinder cannot be used due to safety concerns, use a rough file or copper brush. Clean the area with DURMETAL® Special Cleaner. For best results, wait 2 minutes for cleaner to dry.
2. Cut the Kevlar® Tape to desired size, according to the repair.
3. Stir contents of Super CA-HD Rapid® Activator container vigorously. Place a portion 5 cm/2 inches wide on the mixing plate. Do not place entire contents of container onto the mixing plate.
4. Clean spatula with DURMETAL® Special Cleaner until completely clean.
5. Stir contents of Super CA-HD Rapid® Base container and place a portion approximately 5 cm/2 inches wide on the mixing plate. **The height of your Base portion must be equal with the height of your Activator portion.** Do not place entire contents of container onto the mixing plate.

MIXING NOTE: Make sure to use an Activator to Base ratio as close to 1:1 as possible. If the ratio is not correct, DURMETAL® may not harden or work properly. Simply measure each portion carefully by eye before mixing. You should also check the height of each portion to ensure it is the same for both compounds.



EXAMPLE ON A MIXING PLATE

6. After measurements are 1:1, mix both Activator and Base vigorously for 60 seconds. The color of the mixture should be uniform when mixing is complete. No spots of Activator or Base should be visible.
7. Apply the fully mixed Super CA-HD Rapid® to the center of the Kevlar® Tape. Hold the Kevlar® in a concave shape until the Super CA-HD Rapid® warms up (30 to 60 seconds). Once warm, place the mixture face down on the repair area and apply light pressure, to hold back any flow of media (water, oil, gas, etc.). Do not press forcefully or flatten the compound. The cured thickness should be at least 0.6 cm/ 1/4" in height.

Note: If repairing an active leak, pressure must not exceed 90 PSI for a successful DURMETAL® application.

Hold in place for 3-5 minutes on warm surfaces and 6 -10 minutes on cold surfaces.

PHASE 2

DURMETAL® Super CA-HD® Rapid® has cured and hardened, apply DURMETAL® Standard.

1. Place a portion of Standard Activator approximately 8 cm/3 inches wide on your mixing plate. Do not place entire contents of containers onto the mixing plate.
2. Clean spatula with DURMETAL® Special Cleaner.
3. Place a portion of Standard Base approximately 8 cm/3 inches wide on your mixing plate. Do not place entire contents of containers onto the mixing plate.
   *See Mixing note from Phase 1.
4. After measurements are 1:1, mix both Activator and Base for 60-120 seconds. The color of the mixture should be uniform when mixing is complete. No spots of Activator or Base should be visible.
5. Once mixed, use your spatula to apply Standard on top of and approximately 2.5 cm/ 1.0” around your Super CA-HD Rapid® application area. This layer should also be a minimum of 0.6 cm/ 1/4” thickness and height. Standard will cure in 60-90 minutes. It can be sanded and painted after curing is complete.

NOTE: Refer to the complete instruction manual included in the DURMETAL® kit when applying DURMETAL®.