



TECHNICAL DATA SHEET

Metal Fit

ThistleBond 'Metal Fit' is an anaerobic high performance press fit repair compound designed to refit worn parts.

ThistleBond 'Metal Fit' is based on a specially selected di-methacrylate resin system which produces a rapid curing system with optimum adhesion properties which seals out moisture to prevent corrosion.

ThistleBond 'Metal Fit' is simple, safe and easy to use and when applied to worn parts as a strip or spot to the outer face of a bearing, prevents spinout but allows easy assembly. **ThistleBond 'Metal Fit'** will also take up the wear on close fitting metal parts to enable temporary repairs to be made until replacement parts arrive.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

Ensure parts to be repaired are clean dry and free from oil, grease and other surface contaminants.

MIXING

ThistleBond 'Metal Fit' is supplied ready for use and requires no mixing, however shaking the product to incorporate any slight separation is advised before use.

APPLICATION

Apply the **ThistleBond 'Metal Fit'** to the damaged area in an even film directly from the applicator.

Keyways can be repaired without migration into unwanted areas. If a split shaft is being repaired, spread an even coat in a thin film on both surfaces and when assembled, wipe the excess away. **ThistleBond 'Metal Fit' will harden once parts are assembled.**

PHYSICAL CONSTANTS

Mixing Ratio Supplied ready for use.

Appearance Thixotropic Metallic Silver/Grey liquid.

Drying and Cure Times at 20°C/68°F

Cure time 10 - 15 minutes
Full Cure 2 - 4 hours

Volume Solids 100%

V.O.C. Nil

Shelf Life Use within 12 months of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F) out of direct sunlight

PHYSICAL PROPERTIES

Typical Strength Values

Tensile Shear Strength >30N/mm²
Breakaway Torque >25N/mm²
Operating Temperature -55° to +150°C (-67 to 302°F)

HEALTH AND SAFETY

As long as normal good practices are observed **ThistleBond 'Metal Fit'** can be safely used.

Safety glasses should be worn.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 50 ml units.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.

FOR FURTHER INFORMATION PLEASE CONTACT



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