

## Precast Form Repair Compound- K-100

### Description:

FORM REPAIR is a two-component, 100% solids, BGE-free, epoxy gel system specifically formulated to bond to a variety of materials. The smooth, paste-like consistency makes FORM REPAIR easy to handle and apply to horizontal and vertical surfaces. It is designed to repair steel, wood or concrete forming beds for precast.

### Product Advantages:

FORM REPAIR may be used as a patching compound and filling material for all types of precast forming beds. FORM REPAIR is designed for repairing holes, dents and spalls.

### Application Guidelines:

Simply overfill and sand or grind to leave a smooth, very hard surface. FORM REPAIR is conveniently packaged in kits containing pre-measured containers of resin and hardener.

### Handling Properties:

MIXING RATIO, by volume	1-1	
SPECIFIC GRAVITY, g/cm <sup>3</sup>	0.88	ASTM D 792
WORKING TIME @ 77°F (25 °C), min	15-20	
GEL TIME @ 77°F (25 °C), min 16 oz. mass	25	ASTM D 2471

### Physical Properties:

COMPRESSIVE STRENGTH, psi (MPa)	2,800 (20)	ASTM D 695
TENSILE STRENGTH, psi (MPa)	1,300 (9)	ASTM D 638
FLEXURAL STRENGTH, psi (MPa)	2,600 (18)	ASTM D 790
TENSILE SHEAR STRENGTH, psi (MPa)	2,400 (17)	ASTM D 1002
MAXIMUM CONTINUOUS SERVICE TEMPERATURE, °F (°C)	200 (93)	
LAP SHEAR BOND STRENGTH (AL TO AL), psi (MPa)	1,670 (11.5)	ASTM D 1002
HARDNESS @ 72 °F (22 °C), Shore D	74	ASTM D 2240

### Surface Preparation:

**Preparation of metal forms:** Metal surfaces should be sand blasted or ground to a "white metal" condition. Apply FORM REPAIR within 24 hours of blasting. Wipe or tack the surface with isopropyl alcohol or mineral spirits just prior to application. The surfaces must be dry and have no standing water. FORM REPAIR compound may be sanded or ground smooth in 4-5 hours at 72°F.

**Preparation of wood forms:** Remove all oil, grease or loose coatings from the wood form. The surface must be dry and have no standing water. The repair compound can be sanded or ground smooth in 4-5 hours at 72°F.

**Preparation of concrete forms:** Sandblast, shotblast or grind the concrete surface. The surface must be dry and have no standing water. The repair compound can be sanded or ground smooth in 4-5 hours at 72°F.

**Mixing:**

To use, simply mix the resin and hardener in a 1:1 ratio by volume and apply. Unmixed material remaining in the cans can be resealed for future use.

**Curing  
Procedures:**

The working time (the time you have before it sets) of FORM REPAIR will vary depending on the air temperature and the temperature of the form. The average working time at 77°F (25°C) will be 15-20 minutes for one pint (0.5 l) of mixed material. In cooler weather, you will have more time to work with the material; in hotter weather, you will have less time. The cure time (the time before the parts can be used) will also depend on the air temperature and the temperature of the form. The average cure time from the last application to start-up at 70°F (21°C) will be 4 to 5 hours. Preheating the parts will accelerate the cure time. Do not heat parts hotter than 100°F (38°C).

**PACKAGING/YIELD/COVERAGES**

K-100-26.6: 3.6 Gallon = 832 in.<sup>3</sup> = 7.34 lbs./gal.  
31.4 in<sup>3</sup> per pound  
31.4 in<sup>2</sup> per pound per 1 in. thick  
62.8 in<sup>2</sup> per pound per 1/2 in. thick  
125.6 in<sup>2</sup> per pound per 1/4 in. thick  
251.2 in<sup>2</sup> per pound per 1/8 in. thick

**SAFETY PRECAUTIONS**

Uncured FORM REPAIR can be removed from tools and equipment with non-flammable COPPS ENVIRO KLEEN, isopropyl alcohol or xylol.

Avoid breathing of vapors. Forced local exhaust is recommended to effectively minimize exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (such as heated polymers, sanding) may cause high vapor concentrations. **DO NOT WELD ON, BURN OR TORCH ON OR NEAR, ANY EPOXY MATERIAL. HAZARDOUS VAPOR IS RELEASED WHEN AN EPOXY IS BURNED.**

Avoid skin or eye contact. Wash skin with soap and water if contact occurs. If eye contact occurs flush with water for 15 minutes and obtain medical attention. Read and understand all cautions on can labels and safety data sheets before using this material.

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