

## XL-SSM

## Product data sheet

### Machineable composite

XL-SS-M has been especially engineered for use in repairs requiring final machining. A filled material, XL-SS-M has very good overall chemical resistance and physical strength. It can be easily built up to thickness of 1 inch or more and its cure time facilitates quick finished repairs. Shaft repairs may include applications subjected to sludge, oil, petrochemicals, acids, slurries, etc. XL-SS-M has an excellent track record with a wide variety of materials.

#### FEATURES

- Easily machined
- Very good wear resistance
- Excellent corrosion resistance
- Good temperature resistance
- Easily worked with in thick applications
- Excellent compressive strength
- Machine able with conventional tools

#### PACKAGING

1 kg. (2.2 lb.) units; approximately 38 cubic inches

#### COVERAGE

XL-SS-M can be applied up to 1 inch or more. Theoretical coverage at 500 mils in thickness is 0.55 ft<sup>2</sup>/kg.

#### MIXING RATIO

3 parts base (B) to 1 part (A) hardener by weight  
 3 parts base (B) to 1 part (A) hardener by volume

#### POT LIFE

For a 1 kg unit mix at 70 F, pot life is approximately 25 minutes. High temperatures or larger mass will shorten this time, lower temperatures or smaller mass will extend it. Pot life can also be extended by spreading the mass out to dissipate heat.

#### COLORS

XL-SS-M is steel gray in color.

#### TECHNICAL DATA AND INFORMATION

##### Basic Chemical Resistance at Room Temperature:

Inorganic Acids Dilute	Good-Very Good
Organic Acids	Good-Very Good
Solvents	Good-Very Good
Alkalis	Excellent
Salts	Excellent
Alcohols	Excellent
Hydrocarbons	Excellent

##### Typical Physical Properties of Cured System :

Density	1.59
% Solids	100
Flexural Strength @ 70 F	17,600 psi
Tensile Strength @ 70 F	11,500 psi
Tensile shear @ 70 F	3,000 psi
Compressive Strength @70F	18,000 psi
Service Temperature Maximum	300 F
Operating pH Range	2-14.0

#### SURFACE PREPARATION

The area to be repaired should be machined down so that it is undercut to a minimum of 1/16 of an inch. The surface of the cut should be rough; a thread pattern or gramophone cut should be used. The ends of the cut should be keystoneed or undercut as far as the bit can cut, leaving a fine edge on the shaft. After machining, the area must be thoroughly cleaned with MEK or similar solvent to remove all traces of cutting or lubricating agents.

#### MIXING

Mix ALL of Part A with ALL of Part B. Mixing may be done on a large mixing board or container large enough to hold both the base and hardener. The selected mixing surface must be clean and dry. Mix the material thoroughly until no streaks of any kind are visible. If materials are cold, warm them to 70 F before mixing.