

Pit Putty 200

INSTRUCTIONS FOR USE

1. MINIMUM SURFACE PREPARATION

Pit Putty 200 is tolerant of surface contamination and can be applied directly to wet and oily surfaces, however it is recommended that the best possible surface preparation is carried out. As a minimum, the substrate must always be clean, dry and tight.

CLEAN THE SURFACE THIS WAY:

- Blast clean the metal surface to achieve the following minimum standard of cleanliness:
ISO 8501-1 Sa 2 thorough blast cleaning
SSPC SP-6 commercial blast cleaning
Swedish Standard Sa 2 SIS 05 5900.
- or
- UHP Hydroblasting (2000 - 2500 bar) to remove previous coatings and expose original profile.
- or
- Power tool clean to achieve an SSPC-SP11 bare metal power tool cleaned surface.

It is important to remove contaminants such as salt from above water surfaces.

2. MIX PART A (Base, SKU992A) & PART B (CATALYST, SKU992B)

Transfer the entire contents of the Base and Catalyst containers on to the enclosed work surface. Mix thoroughly together until color uniformity.

1. MIXING AT LOW TEMPERATURES

In the case of low product temperature preheating contents to 68-77°F (20-25°C) will ease in mixing.

2. WORKING LIFE

From the start of mixing, Pit Putty 200 must be used within the times shown below.

Temperature	Working Life
41°F/5°C	32 min.
50°F/10°C	24 min.
68°F/20°C	16 min.
86°F/30°C	14 min.
104°F/40°C	12 min.

3. MIXING SMALL QUANTITIES

For mixing small quantities of Pit Putty 200 use: 2 parts Base to 1 part Catalyst by volume

3. APPLICATION AFTER MIXING:

- Apply the Pit Putty 200 directly on to the prepared surface with the enclosed plastic applicator
- Press down firmly to fill all cracks, remove entrapped air, displace water and ensure maximum contact with the surface.
- Over cracks, gaps and holes, work in Pit Putty 200
- Sculpt the Pit Putty 200 to the correct profile with the plastic applicator or alternatively, allow to cure and then machine down.

APPLICATION AT LOW TEMPERATURES

Pit Putty 200 should NOT be applied at temperatures below 41°F (5°C).

CLEANING

MEK (Methyl Ethyl Ketone, CAS# 78-93-3) is best for cleaning uncured product

4. DRY (CURE) TIME

Allow Pit Putty 200 to dry as follows prior to putting in to service.

Temperature	Machining and/or light loading	Full mechanical or thermal load
41°F/5°C	6 hours	4 days
50°F/10°C	4 hours	2 days
68°F/20°C	2 hours	1 day
86°F/30°C	1 hour	16 hours
104°F/40°C	0.5 hours	12 hours

These times are for a thickness of approximately 0.25 inch (6 mm); cure times will increase for thicker builds and be reduced for thinner builds

5. SECONDARY APPLICATION

When applying an additional layer of Pit Putty 200 over the original layer, surface preparation of the first layer is not required when done within 24 hours.

Application of subsequent layers after 24 hours require the original surface to be roughened before application of the new layer.

6. Health, Safety and additional information can be found here:

www.royalcoatings.net/industries/oem/

