



Magnesium Repair Kit

Instructions for use

Introduction: Helicopter Gearboxes and ancillaries are produced from magnesium, which is factory treated with a special coating to prevent corrosion. If this coating is damaged, then corrosion rapidly sets in, can be very costly and can prevent the helicopter from flying.

This kit has been designed to effect a simple, quick repair to damaged areas of the special coating, and keep the helicopter operational.

READ THESE INSTRUCTIONS FULLY AND CAREFULLY BEFORE STARTING WORK. WEAR GLOVES PROVIDED WHEN HANDLING AND USING ALL CHEMICALS AND COATINGS IN THIS KIT.

Preparation:

- 1.) Clean the damaged area to be repaired using the Magnesium degreasing fluid, **LR2105-010**, applied with one of the lint free cloths, to remove oils, dirt etc. Allow to dry.
- 2.) Depending upon the extent of the damage, and subsequent corrosion, sand the damaged area. For bad corrosion use 240 grit wetordry paper first, followed by 400 grit wetordry paper. For light corrosion, the 400 grit wetordry paper should suffice.
- 3.) Remove surface dust by wiping with a dry lint free cloth
- 4.) Clean the sanded area and surrounding areas of undamaged coating fully with magnesium degreasing fluid **LR2105-010**, using a third lint free cloth and allow to dry.

Pre-treatment: Brush apply 2 coats magnesium pre-treatment **DOW19**, allowing the first coat to dry before applying the second coat. Allow these two coats to dry fully before applying the basecoat.

Cont: over

Base Coat:

This is a two component product, and needs mixing thoroughly before application.

Tip the contents of catalyst can **LR2096-010** into the can of base **LR1718B-010**. Either thoroughly stir, using the provided stirring stick, or re-lid the can and shake vigorously.

Once mixed the material will remain usable for maximum 15 minutes.

Brush apply 1 full coat of basecoat to the damaged area; overlap about ¼- ½ inch onto the surrounding sound undamaged factory applied coating. Allow to dry for 30-45 minutes then apply a second full coat.

Overcoat with Magnesium repair glazecoat between 1 & 2 hours or after 6 hours.

Glazecoat:

This is a two component product, and needs mixing thoroughly before application.

Tip the contents of catalyst can **IP6-CAT** into the can of glazecoat **LR2101-010**. Either thoroughly stir, using the provided stirring stick, or re-lid the can and shake vigorously.

Once mixed the material will remain usable for maximum 15 minutes.

Brush apply 1 full coat of glazecoat to area already coated with basecoat; overlap about ¼- ½ inch onto the surrounding sound undamaged factory applied coating. Allow to dry for 30-45 minutes then apply a second full coat

The repaired area will be hardened after 24 hours, but will require about 7 days drying to achieve full chemical resistance and hardness; avoid contamination of the repaired area with oils and other aircraft fluids during this period.

Dispose of finished mixed containers and all used equipment wherever possible through a hazardous waste disposal area.

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