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### **Repair Instructions for *HYTAC-W*, *WF*, *WFT*, *FLX* small voids (Quick Cure)**

This procedure is for quickly curing small void or cut areas in the *HYTAC-W*, *WF*, or *WFT*, *FLX* product. This should only be used on very small voids, (less than 1/8 inch diameter). This procedure requires that the plug and the syntactic mix be heated separately to temperatures of 200°F and 140°F respectively. The mix is then quickly worked into the void, wiped with alcohol and cured. This process is repeated until the void is filled.

Included are 100 gram containers of *HYTAC-W*, *WF*, or *WFT*, enough room temperature catalyst to be mixed with the container of *HYTAC-W*, *WF*, or *WFT* to speed the cure of the repaired area for you, and tongue depressors to aid in mixing and filling the repair area.

Also enclosed are the MSDS for the *HYTAC-W*, *WF*, or *WFT* syntactic foam and the catalyst.

#### **Procedure:**

Clean the area to be prepared with alcohol making sure all grit, dirt or cutting fluids are removed. Perform a light sand as necessary, and wipe with alcohol. Allow the plug to dry.

Place the plug in an oven at 200°F and allow the plug to come to temperature. (Roughly 1 hour)

Place the mix in an oven at 140°F. Allow the mix to come to temperature at minimum. (About 20 minutes)

When both the plug and mix are at temperature, cut open the catalyst eye dropper and mix the entire contents into the container of repair mix. Mix thoroughly for 2 minutes scraping the sides of the container.

Apply to the area to be repaired, working the syntactic mix into the void. Once the void is satisfactorily filled, lightly wipe the area with a cloth wet with alcohol to bring the level of the syntactic in the void to the level of the plug. Place the plug back in the oven at 200°F and allow the mix to cure. Place the mix back in the oven at 140°F.

Repeat the above step as many times as necessary to fill the void. We expect you to have about 60 minutes of working time with the mix before the viscosity begins to build.

You can then cure the patch in an oven overnight at 200°F to finalize the cure. Lightly sand the surface to get to the desired final surface.

If you have any questions, please call.