



MetaLine 680

Coatings made in Germany - since 1960

Pack-size
MetaLine 680 - 1.05 kg cartridges

Processing
MetaLine APPLICATOR S700

Solids Content (DIN EN ISO 3251)
100 % by volume/weight

Mixing ratio
2 : 1 by volume (cartridge based)

Consumption per 1 mm (40 mils) thickness
1.2 kg/m² (0.24 lbs/ft²)

Processing time (20°C/68° F - material temp.)
10 minutes (exothermic reaction)

Preparation time (microwave heat transfer)
< 1 minute (at 850 watts) not mandatory

Solidification at 20°C (68° F)
> 1 day – dependent on stress

Hardness (A.S.T.M. D2240-68)
80 Shore A

Density (DIN EN ISO 1183-2)
1.05 g/cm³ (0.038 lb/in³)

Tensile bond strength (A.S.T.M. D4541)
> 15 N/mm² (> 2,175 psi) Steel 1.0037 / A36

Tensile strength (A.S.T.M. D412-16)
14 N/mm² (2,000 psi)

Tensile modulus (A.S.T.M. D412-16)
7 N/mm² (990 psi) at 100 % elongation

Elongation at break (A.S.T.M. D412-16)
370 %

Bashore resilience (DIN 53 512)
41 %

Coefficient of thermal conductivity (ISO 8302)
0.2 W/K · m (0.11 BTU/h · ft · °F)

Dielectric surface resistivity (DIN EN 62631)
> 7 x 10¹⁰ Ohm

Dielectric breakdown voltage (DIN EN 60243)
> 5,000 Volts/mm

High temperature resistance
+100 °C (212 °F) dry / +60 °C (140 °F) wet

Low temperature resistance (dry)
- 50 °C (- 58 °F)

Dynamic abrasion (DIN ISO 4649)
65 mm³ (0.004 in³)

Coefficient of static friction (DIN EN ISO 8295)
μ(0) = approx. 0.6

Approvals for pharma & food conformity (dry)
FDA 177.1680 (21) - pending!

Standard colour
clear/translucent (self-tinting possible)

Trowelable elastomeric repair compound

Based on MetaLine's famous Series 700 coating technology, the **MetaLine 680** offers a similar resistance and performance, but extruded as "putty" from a cartridge

- cartridge based processing without proportioning
- convenient air-free auto-mixing
- stands up to 25 mm without sagging on verticals
- absolutely free of shrinking or swelling

The need for a high-build, groutlike re-surfacing compound ever has existed. Low quality patch materials like polyurea or fast setting fillers cannot meet the engineering demands in high-end surface protection.

MetaLine 680 is the first **OEM level-like**, fluffy, high-build paste. Reinforceable with synthetic mesh or metal wires/screens. Overhead applicable. VOC-free meeting the latest environmental standards with a tension free polymerisation! Dynamic abrasion resistance (erosion/cavitation) **beyond stainless steel!**

Stand-alone system

to smoothen out surface irregularities and fill gaps, seams or voids. Compatible with all MetaLine primers like 900/910/920, bonding it to metal, steel, rubber, polyurethane, polyurea, neoprene, concrete, wood, or polar plastics. Grindable after 2 hours

Sandwich system

for trowel operations prior the overcoating with MetaLine Series 700. No waiting time and NO primer is required if overcoated within 30 minutes "wet-in-wet" using MetaLine 760/785/795. Works on top of Series 700 as well

Repair system

for permanent repairs to worn rubber parts or linings. Resists bending forces and massive dynamic loads. Not affected by hydrolysis and perfectly suitable for the servicing of tribofinishing equipment. Can be used within 24 hours after curing at 20 °C (68 °F)



MetaLine Surface Protection GmbH | DE-71157 Hildrizhausen (Germany) | Robert-Bosch-Str. 5-11
Tel. +49 (0)7034 3100-0 | Fax +49 (0)7034 3100-5 | www.metalline.com | info@metalline.de

Subject to technical modifications! Information and application examples in this document are provided to the best of our knowledge. However, they also apply without guarantee in reference to the exclusive rights of third parties and do not release the user to check the products and processes for their suitability and material tolerance regarding their intended use. We do not assume liability for the application results. Copyright by MetaLine Surface Protection GmbH, DE-71157 Hildrizhausen (1960 - 2020). MetaLine is a registered trademark of our company.