

204 HEAVY DUTY REPAIR PASTE

Resimetal 204 Heavy Duty Ceramic Repair Paste is a two component solvent free epoxy repair compound which contains 0.2mm – 1.5mm ceramic beads. The product is ideal for resurfacing and protecting metallic substrates subject to medium sliding abrasion.

Typical applications

Pipe bends, Chutes, Hoppers, Valves, Pumps, Pipe surfaces

Characteristics

Appearance

Base: Grey or Red Paste
Activator: Dark Grey Paste
Mixed: Grey or Red Paste

Mixing Ratio

By weight: 4:1
By volume: 3:1

Density

Base: 2.10
Activator: 1.40
Mixed: 1.96

Volume Capacity

584cc/Kg

Solids content

100%

Sag Resistance

Nil at 15mm

Coverage

5kg (11lb) of fully mixed product will give the following coverage rates –

1.46m² at 2mm
15.70ft² at 80mil
0.73m² at 4mm
7.848ft² at 160mil

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

Cure Times

The applied material should be allowed to harden for the times indicated below before being subjected to the conditions indicated:

Usable life

10°C 100 minutes
20°C 50 minutes
30°C 25 minutes
40°C 12.5 minutes

Minimum overcoating

10°C 8 hours
20°C 4 hours
30°C 2 hour
40°C 1 hour

Maximum overcoating time

10°C 16 hours
20°C 8 hours
30°C 4 hours
40°C 2 hours

Full Cure

10°C 8 days
20°C 4 days
30°C 2 days
40°C 24 hours

Storage life

5 years if unopened and stored in normal dry conditions (15-30°C)

Mechanical Properties

Abrasion Resistance

Taber H10 Wheels/1 Kg load
66mm³ loss/1000 cycles

Adhesion

Tensile Shear to ASTM D1002 on abrasive blasted mild steel with 75 micron profile
148kg/ cm² (2100psi)

Pull off Adhesion to ASTM D4541 on abrasive blasted mild steel with 75 micron profile
272kg/ cm² (3840psi)

Compressive strength

Tested to ASTM D695
990kg/cm² (13985psi)

Corrosion Resistance

Tested to ASTM B117
Minimum 1000 hours

Flexural Strength

Tested to ASTM D790
420kg/cm² (6000psi)

Impact Resistance

Tested to ASTM D256
16J/m

Hardness

Shore D to ASTM D2240
89

Heat Resistance

Full immersion resistance
Tested water/ hydrocarbon immersion to 50°C
Pass (no blisters)

Dry heat resistance

Tested to ASTM D2485
Pass 120°C

Chemical Resistance

The product resists attack by a wide variety of inorganic acids, alkalis, salts and organic media.

For more detailed information refer to the Resimac Technical Centre for advice.

Quality

All Resimac Products are supplied under the scope of the company's fully documented quality system.

Warranty

Resimac warrants that the performance of the product supplied will conform to the typical descriptions quoted within this specification provided material is stored correctly and used according to the procedures detailed in the Technical Data Sheet for the material.

Health and safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves and other recommended personal protective equipment must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read and fully understood the detailed Material Safety Data Sheet

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