

## 204 UHD

- Solvent free epoxy repair paste
- Extreme wet slurry abrasion resistant
- Extreme impact from medium to coarse aggregates

### Cure Times

At 20°C (68F°) the applied materials should be allowed to harden for the times indicated below:

Usable Life	50mins	
Minimum overcoating	6 hours	time
Maximum overcoating	12	hours
Full cure	4 days	

### Colour

**Mixed material –**

Mid grey

**Base component –**

Mid grey

**Activator component –**

Black

### Coverage Rates

1.5kg (3.3lb) will give the following coverage rates –

0.219m<sup>2</sup> at 3mm  
2.245ft<sup>2</sup> at 120mil  
0.111m<sup>2</sup> at 6mm  
1.193ft<sup>2</sup> at ¼”

5kg (11lb) will give the following coverage rates –

0.73m<sup>2</sup> at 3mm  
7.848ft<sup>2</sup> at 120mil  
0.37m<sup>2</sup> at 6mm  
3.978ft<sup>2</sup> at ¼”

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

### Typical Applications

Slurry pumps, Bins & hoppers, Fan blades & housings, Internal pipe surfaces, Wear plates, Pipe elbows, Chutes, Transport screws, Pulverisers, Ceramic tile lined chutes

### Technical specifications and characteristics

**Mixing ratios** By weight 2.64:1  
By volume 5:2

**Volume capacity** Metric 420cc/kg  
Imperial 25.6cu in/2.2lb

### Surface Preparation

**Metallic Substrates – Abrasive blast cleaning**

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be abrasive blasted to **ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)** minimum blast profile of 75 microns (3mil) using an angular abrasive.
3. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.

*PLEASE NOTE: For salt contaminated surfaces the substrate must be pressure washed with clean water and checked for salt contamination, please refer to the surface preparation and pre-application guide for further information.*

### Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry.  
Maximum - the over-coating time should not exceed 12 hours at 20°C (68F°).

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted

### Mixing and Application

#### STEP 1

Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula, 1 applicator, 1 x clean mixing area.



#### STEP 2

Take equal 5 equal measures of base material, clean the spatula, then take 2 measure of the activator.



#### STEP 3

Mix the two components using the spatula provided, ensure any unmixed material around the edges is mixed.



#### STEP 4

To ensure the product is fully mixed create a diamond pattern on the surface and look for any unmixed areas.



#### STEP 5

Once the material is fully mixed use the applicator tool provided to apply the beaded ceramic repair paste to the surface.

