

204 HD

Resimetal 204 HD Paste

is a two component solvent free epoxy repair compound containing ceramic beads for extreme wear environments from fine particles & wet slurries.

Typical applications

Slurry pumps, Bins & hoppers,
Fan blades & housings, Internal
pipe surfaces, Wear plates,
Pipe elbows, Chutes,
Transport screws

Characteristics

Appearance

Base: Light Grey Paste
Activator: Black Paste
Mixed: Mid Grey Paste

Mixing Ratio

By weight: 2:1
By volume: 2:1

Density

Base: 2.28
Activator: 2.26
Mixed: 2.27

Volume Capacity

440cc/Kg

Solids content

100%

Sag Resistance

Nil at 10mm

Coverage

1.5kg (3.3lb) of fully mixed product will give the following coverage rates –

0.219m² at 3mm
2.245ft² at 120mil
0.111m² at 6mm
1.193ft² at ¼"

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

0.73m² at 3mm
7.848ft² at 120mil
0.37m² at 6mm
3.978ft² 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.

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 60 minutes
20°C 30 minutes
30°C 15 minutes
40°C 7.5 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
42mm³ loss/1000 cycles

Adhesion

Tensile Shear to ASTM D1002 on abrasive blasted mild steel with 75 micron profile
272kg/ cm² (3840psi)

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

Compressive strength

Tested to ASTM D695
1046kg/cm² (14880psi)

Corrosion Resistance

Tested to ASTM B117
Minimum 1000 hours

Flexural Strength

Tested to ASTM D790
475kg/cm² (6710psi)

Impact Resistance

Tested to ASTM D256
22J/m

Hardness

Shore D to ASTM D2240
89

Heat Resistance

Full immersion resistance
Tested water/ hydrocarbon immersion to 60°C
Pass (no blisters)

Dry heat resistance

Tested to ASTM D2485
Pass 150°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

Legal Notice: The data contained within this Product Specification is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. Resimac accepts no liability arising out of the use of this information or the product described herein.