

204 Heavy Duty Ceramic Paste

- Solvent free epoxy repair paste
- Low to medium solids content abrasion
- Low level fine particle abrasion

Cure Times

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

Usable Life	50mins
Minimum overcoating time	4 hours
Maximum overcoating time	8 hours
Full cure	4 days

Coverage Rates

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

1.46m ² at 2mm	15.70ft ² at 80mil
0.73m ² at 4mm	7.848ft ² 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.

Colour

Mixed material –
Mid grey or red

Base component –
Mid grey or red

Activator component –
Dark grey

Typical Applications

Eroded pump casings
Chutes
Hoppers
Pipe bends
Separator housings
Internal pipe surfaces

Technical specifications and characteristics

Mixing ratios	By weight	4:1
	By volume	3:1

Volume capacity	Metric	584cc/kg
	Imperial	36cu 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 8 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 3 equal measures of base material, clean the spatula, then take 1 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 product



STEP 5

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

