



## **204 HEAVY DUTY CERAMIC REPAIR PASTE**

- Two components
- Solvent free Epoxy
- Ceramic enhanced
- 3 to 1 mixing ratio
- Good chemical resistance
- Ideal for fluid flow environments
- Excellent impact resistance
- Good abrasion resistance

### **DESCRIPTION**

**Resimetal - 204 Heavy duty Ceramic Repair Paste** is a high performance, two pack, solvent free epoxy repair system ideal for use on metallic surfaces and is designed for repairs to worn or damaged components and equipment in a fluid flow environment including -

- Worn impellers
- Damaged valves
- Eroded separator housings
- Damaged pump casings
- Eroded/corroded end plates
- Eroded pipe work
- Eroded propellers
- Corroded water boxes

### **SURFACE PREPARATION**

The following surface preparation guidelines must be followed for optimum performance

- All Oil and Grease removed using a suitable Resimetal cleaner
- Use a cleaner which does not leave a residue such as Methyl Ethyl Ketone
- All loose material, rust & coatings must be removed using abrasive blasting
- Minimum surface preparation level of Swedish standard SA 2.5, angled grit, minimum 75 micron profile
- Ensure all blasted surfaces are de-greased using a suitable Resimetal cleaner
- All surfaces must be coated before any oxidation takes place

PLEASE NOTE: For salt contaminated surfaces the area must be blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After 24 hours wash the surface of the substrate and re blast to Swedish standard SA2.5, angled grit minimum 75 micron profile



## **MIXING AND APPLICATION**

**Resimetal - 204 Heavy duty Ceramic Repair Paste** is a two component system which must be mixed together prior to application

- Measure 3 base & 1 activator on the mixing board provided
- Mix the two components together until they are streak free
- Apply the mixed material to the prepared surface using the applicator provided
- Ensure that the mixed material is pressed into any holes or cracks
- Wipe away the excess material and leave to cure

## **TECHNICAL DATA**

<b>Resimetal - DRYING AND CURING TIMES (AT 20C)</b>	
Usable life	60mins
Initial set	180 mins
Overcoating time	8hrs
Full cure	5 days
Volume solids	100%
VOC	0
<b>Resimetal Mixing Ratios</b>	
Base 3    Activator    1    by volume	
Base 4    Activator    1    by weight	
<b>Physical Performance</b>	
Tensile Shear Adhesion	148kg/cm <sup>2</sup> (2000psi)
ASTM D1002	
Compressive Strength	1089kg/cm <sup>2</sup> (15,000psi)
ASTM D695	
Rockwell Hardness	100
ASTM D785	



## **Health and Safety**

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

Please speak to the Resimetal Technical Centre if you require further technical information or clarification.

### **LEGAL NOTICE**

The data contained within this Technical Data Sheet 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. Resimetal accepts no liability arising out of the use of this information or the product described herein.

### **Resimac Ltd.**

Knarborough Technology Park  
Manse Lane  
Knarborough  
HG5 8LF  
North Yorkshire  
United Kingdom



Office Tel: + 44 1765 677757  
Office Fax: + 44 1765 677757  
Email: [info@resimac.co.uk](mailto:info@resimac.co.uk)  
Website: [www.resimac.co.uk](http://www.resimac.co.uk)