

PRODUCT INFORMATION

REMACOAT REPAIR KIT

General properties

REMACOAT REPAIR KIT is a solvent free, elastic, cold hardening, polyurea repair paste.

REMACOAT REPAIR KIT, applied in conjunction with REMACOAT PR 100 Primer, gives an excellent adhesion to various substrates such as steel, soft and hard rubber linings, graphite and acid resistant ceramics.

The excellent properties of **REMACOAT REPAIR KIT** are its good chemical resistance against non-oxidising mineral acids, bases, watery phases and especially against media containing a high amount of solids.

REMACOAT REPAIR KIT can be used in a temperature range from - 40 °C to + 90 °C.

Fields of Application

REMACOAT REPAIR KIT has been developed for the repair of rubber lined vessels, pipes, rollers and drums, chutes, and channels and further for the transition areas of hard and soft rubber lining on flange sealing surfaces.

Application

The **REMACOAT REPAIR KIT** repair system is comprised of REMACOAT PR 100 Primer and a dual component paste consisting of Components A + B. The individual components are to be mixed properly before application.

Mixing the individual components

Mixing Ratios	Weight Ratios [kg]	Volume Ratios [L]
REMACOAT PR 100	100	100
REMACOAT REPAIR KIT		
Component A	100	100
Component B (Hardener)	5	6

Shelf life

The **REMACOAT REPAIR KIT** soft rubber paste can be stored without any loss of quality in originally sealed containers for up to 6 months at temperatures up to + 25 °C. The DIN standard 7716 is to be observed.

REMACOAT PR 100 Primer	12 month
REMACOAT REPAIR KIT , Component A	6 month
REMA Hardener, Component B	24 month

Application Examples

- Repairs of Rubber lined drums, rollers, support rollers, chutes, channels
- Repairs to wear resistant linings of polymers based on Polyurea-, Natural-, Styrol- Butadine- and Nitrile Rubber.
- Filling of groves and impact areas of rubber lining, such as in hoppers and coal bunkers.
- Repairs on soft rubber linings on a hard rubber under-layer, in the soft rubber level.
- Repairs on flange lip areas, which are subsequently covered by flange gaskets. (Max. half the length of the bevel)
- Repairs of special rubber linings based on the polymers Bromine butyl, Polychloroprene and Chlorosulphonated Polyethylene.

Surface Preparation

The substrate must be free from contamination and substances leading to separation. It is necessary to buff grind the substrate mechanically.

Usage

REMACOAT PR 100 Primer:
about 0.2 kg/m²
REMACOAT REPAIR-KIT:
about 1.4 kg/m² (per 1 mm thickness)

Application Time (Pot Life)

Temperature	Primer	Paste
+ 15 °C	Approx. 240 min.	Approx. 40min.
+ 20 °C	Approx. 180 min.	Approx. 30 min.
+ 30 °C	Approx. 80 min.	Approx. 10 min.

* Note: The Pot Life and hardening times are dependant on the environmental influences such as ambient temperature, air humidity, ventilation etc. The times indicated are to be understood as guidelines only; the ideal times must be determined locally, with consideration to the prevailing climatic conditions.

Surface Preparation

The surface to be repaired must be free from oil, grease and chemicals and is to be ground with a 24 grit grinding disc and if necessary cleaned with cleaning fluid.

Application

a) Application of the REMACOAT PR 100 primer

Apply one thin coat of the REMACOAT PR 100 primer to thoroughly cover the complete repair area. This applied primer should be allowed to dry for at least 2 hours at +23 C± 2°C.

b) Repair with **REMACOAT REPAIR KIT**

Shortly before use, mix components A and B of the **REMACOAT REPAIR KIT**, avoiding trapping air as far as possible, until a paste is produced which can be applied with a trowel.

Apply the paste with a trowel on to the prepared repair area.

Metal surfaces and joint areas should be covered thinly with the paste, before these areas are filled to the required thickness, preventing any blisters or air being trapped.

When applying the paste, assure that no cavities remain.

Hardening

The product hardens in approx. 24 hours at + 23 °C ± 2 °C. This period can be shortened by thermally treating the area, at approx. + 60 °C with either warm air or radiators.

Where necessary the repair area could be ground level after hardening.

Safety Measures

Observe the safety instructions on the containers.

Available Packing Units

Product Description	Packing [kg] *	Product No.
REMACOAT PR 100 primer	0.25	590 3290
REMACOAT REPAIR KIT		
Component A grey	0.5	590 3470
Component B (Hardener)	0.025	525 2891

Special container sizes can be supplied on request

Mechanical - Physical Characteristics

Properties	Units	Standard	Value
Polymer		DIN ISO 1629	BR
Tensile Strength	[MPa]	DIN 53 504	> 3
Elongation at Break determined on:	% [Stab S2]	DIN 53 504	> 100
Hardness	[Shore A]	DIN 53 505	75 ± 5
Rebound Elasticity	[%]	DIN 53 512	> 30
Wear	[mm ³]	DIN 53 516	< 250
Density	[g/cm ³]	DIN 53 479	1.17+ 0.02
Bonding Strength on Steel	[MPa]	DIN EN ISO 4624	> 2
Surface Conductivity	[Ω]	DIN 53 482	>10 ¹¹
Test Voltage	[KV/mm]	DIN 28 055	5
Operation Temperature	[°C]		< 90
Compressive Strength	[MPa]		> 2

The information given above is based on approved test results and represents statistical product data; which does not necessarily guarantee the specific properties of this product. We reserve the right to changes to technical specifications without prior notice, provided that they ensure technical improvement without major modifications to the product itself.

Please pass this data sheet to the person in charge of coating application. Above data and recommendations are based on extensive tests and are to be considered only as guidelines without any obligations. As we are continuously developing and improving our products we recommend to consider the date of this data sheet and, if necessary, to ask if there were changes in the meantime. In case of further questions please contact one of our technical advisors for detailed information at:

REMA TIP TOP GmbH
Business Unit Industrie
Gruber Straße 63
85586 Poing

Telephone: +49-(0) 81 21 / 7 07 – 2 55 or -106
Fax: +49-(0) 81 21 / 7 07 – 2 22
e-mail: bernd.dietz@tiptop.de

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