

HPR-515-C ceramic paste

HPR-515-C is a two component solvent free epoxy metal repair compound. The product has been designed for use on a wide range of metallic surfaces subject to abrasion and impact.

Typical Applications

Suitable for emergency repairs or part of planned maintenance to equipment such as -

worn impellers

damaged valves

separator housings

damaged pump casings

eroded pipe work

propellers

bow thrusters

rudders

corroded water boxes

end plates and tube sheets.

Surface Preparation

All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK.

For optimum performance, the surface should be abrasive blasted to *ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)* and a minimum blast profile of 75 microns using an angular abrasive. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be repaired before gingering or oxidation occurs.

PLEASE NOTE: For salt contaminated surfaces the area must be abrasive blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After this 24 hour period the surface must be washed with MEK prior to brush blasting to remove the surface salts. This process must be repeated until all ingrained contaminants have been sweated out of the surface.

Mixing and Application

Warm the Base component to 15-25°C (60-77°F) before mixing and do not apply when the ambient or substrate temperature is below 5°C (40°F) or less than 3°C (37°F) above the dew point

Mixing of the product can be on full units or by part-mixing. If mixing the whole unit please ensure as much of the base and activator is dispensed from the plastic container onto a clean plastic mixing surface and mix using a spatula until a uniform material free of any streakiness is achieved while ensuring no unmixed material is left on the spatula or the mixing surface. From the commencement of mixing the whole of the material should be used within 25-30 minutes at 20°C (68°F).

For part mixing, using a spatula place 3 equal measures from the base unit onto a clean plastic mixing surface. Clean the spatula thoroughly and then take one equal measure from the Activator unit and place alongside the base measures. Mix as above.

Using a spatula or applicator tool, apply the material to the blast prepared surface, ensuring the product is pressed into any holes, scars or cracks and profile the repair to a smooth finish.

Technical Data Sheet

Coverage Rates

1kg (2.2lb) of fully mixed product will give the following coverage rates –

0.406m ² at 1mm	4.3ft ² at 40mil
0.203m ² at 2mm	2.2ft ² at 80mil
0.135m ² at 3mm	1.45ft ² at 1/8"

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

At 20°C (68°F) the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Usable Life	30mins
Movement without load or immersion	1.5 hours
Machining and light loading	2 hours
Full loading	2 days
Immersion	3 days

For Optimum Performance

After an initial curing period of at least 4 hours at 20°C (68°F), raising the cure temperature progressively to 60 - 100°C (140-212°F) for up to 8 hours will result in improved mechanical, thermal and chemical resistance properties

Pack Sizes

This product is available in the following pack sizes –
1kg (2.2lb), 3kg (6.6lb), 30kg (66lb)

Colour

Mixed material - Dark Grey
Base component – dark grey
Activator component – light grey

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 3 hours.

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

Storage Life

5 years if unopened and store in normal dry conditions (15-30°C/ 60-86°F)

Technical data and Performance

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Technical Data Sheet

Volume capacity	406 cc/Kg
Compressive Strength ASTM D695	1089kg/ cm ² (15,500psi)
Tensile Shear Adhesion (mild steel) ASTM D1002	188kg/cm ² (2675psi)
Flexural Strength ASTM D790	703kg/ cm ² 10,000psi
Hardness Rockwell R ASTM D785	100
Corrosion Resistance (ASTM B117)	5000 hours

Please see HPR-515-C Product Specification Sheet for further technical and performance data.

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 and fully understood the detailed Material Safety Data Sheet.

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. Resimac accepts no liability arising out of the use of this information or the product described herein.