

PRODUCT INFORMATION

REMAFIX H

PRODUCT DESCRIPTION

REMAFIX H is an anthracite coloured, reaction-hardening, solvent free repair cement (putty/mastic/paste) based on epoxy resin.

FIELDS OF APPLICATION

REMAFIX H is applicable for repair areas up to a max. diameter of 100 mm. Larger areas must be repaired with vulcanised hard rubber plates and **REMAFIX H**. Another application of **REMAFIX H** is the hard rubber lining of flanges on construction site. In such cases, pre-cut vulcanized hard rubber rings or segments are applied to the flange surface area.

APPROVALS & CERTIFICATES

REMAFIX H has an approval for nuclear power plants according AVS D 6.1/50 Rev. A

FEATURES

- Strong adhesion
- Solvent free
- Easy application

CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

SUBSTRATE

Substrates are components made of non-ferrous metals, cast iron or ferrite steel. Components to be rubber lined shall be designed and manufactured in accordance with EN 14879-1.

SURFACE PRE-TREATMENT

All surfaces to be repaired must be dry and free of contaminants. All contaminants, including non-visible detectable contaminants, must be removed in accordance with DIN TR 55684 or EN ISO 8502.

Non-alloyed steel surfaces shall be abrasive blasted to "Near White Metal" in accordance with EN ISO 12944-4. A surface preparation degree of SA 2½ (SSPC-SP 10; NACE No. 2) as specified in EN ISO 8501-1 and a "medium (G)" roughness degree as specified in EN ISO 8503-2 must be achieved. A minimum surface profile of $R_z \geq 60 \mu\text{m}$ is required.

ENVIRONMENTAL CONDITIONS

Throughout the repair process, the temperatures of the substrate and repair materials shall be maintained within the range specified by TIP TOP. All surfaces shall be maintained at a temperature at least 3K above the dew point in order to prevent condensation.

APPLICATION

The application needs to be done in an ambient temperature between +15°C and +45°C. At lower temperatures the mastic hardens very slowly, and most likely inadequate. Short before use same amounts of **REMAFIX H COMP. A & B** need to be mixed thoroughly and carefully to avoid air traps until a uniform, spread able mixture is achieved.

If **REMAFIX H** is stored at too low temperatures, **REMAFIX H COMP. A** must be warmed in a warm environment, such as a water bath or other heat sources at 40 - 60 °C. The prepared mixture is applied onto the pre-treated surfaces using a trowel. At +25°C the trowelled mixture completely hardens within approx. 8 - 10 hours. The hardening time can be considerably reduced by means of a thermal treatment (hot air or radiant heater at approx. +60°C). Once the hardening is complete, the repaired spot can be refinished / retouched e.g. by sanding.

MIXING RATIO

REMAFIX H is supplied in pre-measured units so that weighing or measuring of the components is kept to a minimum. After the unit has been mixed it shall be used within the specified pot life.

Product	Parts by Weight
REMAFIX H COMP. A	100
REMAFIX H COMP. B	100

CONSUMPTION

Product	Thickness [mm]	Coverage [g/m ²]
REMAFIX H	1	ca. 2000

POT LIFE / WORKING TIME [min]

Product	15°C	20°C	30°C
REMAFIX H	-	ca. 30	-

CLEANING

Clean all equipment with **SOLVENT CF-CE** immediately after use.

SPARK TEST

The spark test (holiday test) is carried out according EN 14879-4 by using a high voltage tester. For carrying out the spark test, only the high voltage testers of Elmed model Isotest II RT or P as well as the test pistols of Wegener model WEG 20 or 22 or 100 are allowed. The test voltage is set analogue of the repaired hard rubber lining.

SAFETY MEASURES

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.



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PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
REMAFIX H COMP. A & B	1 kg (each 0.5 kg)	525 0563
SOLVENT CF-CE	10 l	595 9163

STORAGE

The products must be stored in a cool and dry place, away from direct sunlight. At the specified storage temperatures a shelf life of the products is given of at least for the following periods:

Product	Temperature	Shelf Life
REMAFIX H COMP. A & B	5 - 25°C	12 Months
SOLVENT CF-CE	5 - 25°C	60 Months

If the storage time is exceeded, the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof. In addition, the DIN 7716 must be observed.

Technical Data	Standard	Unit	Value
Polymer Base	-	-	Epoxy resin
Colour	-	-	Anthracite
Density	-	g/cm ³	1.85 ± 0.02
Hardness Shore D	ISO 48-4	-	80 ± 5

Information given in the fact sheet above corresponds to the current knowledge available to us regarding our products at the time of its drafting and is intended as a guideline for informational purposes. However, because of the multiple possibilities regarding possible applications, processing and on site conditions, any information given in the fact sheet above is not legally binding, in particular, without being limited to, such information shall not be interpreted as a warranty of merchantability or of fitness for a particular purpose. Customer therefore is advised to conduct its own testing or make an inquiry with our technical department before ordering. We reserve the right to change the product at any time, in particular, without being limited to, minor changes because of advancements in technology. If by way of exception, the information given in the fact sheet above is incorporated by reference into any contract concluded with us under German Law, such information, shall only be interpreted as determining the specific requirements of the contractual products as set out in § 434 BGB (German Civil Code) and shall not be interpreted as constituting a guarantee of condition.

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