

PRODUCT INFORMATION

REMAFIX S

PRODUCT DESCRIPTION

REMAFIX S is a solvent free elastic repair cement (putty / mastic) based on a modified polybutadiene rubber (BR).

FIELDS OF APPLICATION

REMAFIX S 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 facings.

Application Examples

- Repairs of Rubber lined drums, rollers, support rollers, chutes, and channels
- Repairs to wear resistant rubber linings of polymers based on natural, Styrene butadiene and Nitrile rubber as well as on Polyurea systems
- Filling of groves and impact areas of rubber lining, such as in hoppers and coal bunkers.
- Repairs of special rubber linings based on Bromobutyl, Chloroprene and Chlorosulfonated Polyethylene polymers

FEATURES

- Strong chemical resistance against non-oxidising mineral acids and bases
- Outstanding adhesion on various substrates such as steel, soft and hard rubber linings, graphite and acid resistant ceramics

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 $R_z \geq 50 \mu\text{m}$ 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

a) Application of the primer

One thin coat of **REMAFIX PR 100** is applied thoroughly to cover the complete repair area. The applied primer should be allowed to dry for at least two hours at $+23^\circ\text{C} \pm 2^\circ\text{C}$.

b) Repair with **REMAFIX S**

In case a thin, hard film is observed on the surface of the **REMAFIX S** paste, it has to be removed before adding the **REMAFIX S H3 HARDENER**.

Short before use, **REMAFIX S** and **REMAFIX S H3 HARDENER** need to be thoroughly mixed avoiding trapped air until a homogeneous paste is formed which can be applied with a trowel. The prepared paste (mastic) is trowelled onto the prepared repair area. Metal surfaces and joint areas shall be covered with a thin layer of mastic and then the mastic shall be trowelled to build the required thickness, at the same time preventing any air pockets and trapped air. When applying the mastic, great care needs to be taken to assure that no cavities remain. The applied product hardens in approximately 24 hours at $+23^\circ\text{C} \pm 2^\circ\text{C}$. The hardening period can be shortened by warming up the area at approx. $+60^\circ\text{C}$ with either warm air or radiators. Following the complete hardening the repair area can be sanded if necessary.

MIXING RATIO

REMAFIX S 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 | Parts by Volume |
|------------------------------|-----------------|-----------------|
| REMAFIX S | 100 | 100 |
| REMAFIX S H3 HARDENER | 5 | 6 |

CONSUMPTION

| Product | Thickness [mm] | Coverage [g/m ²] |
|------------------|----------------|------------------------------|
| REMAFIX S | 1 | ca. 1400 |

POT LIFE / WORKING TIME [min]

| Product | 15°C | 20°C | 30°C |
|-----------------------|---------|---------|--------|
| REMAFIX PR 100 | ca. 240 | ca. 180 | ca. 80 |
| REMAFIX S | ca. 40 | ca. 30 | ca. 10 |

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 5 kV/mm.

REMAFIX S

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.

PACKING UNITS

The products are supplied in the following standard package sizes:

| Product | Size | Article No. |
|-----------------------|----------|-------------|
| REMAFIX PR 100 | 0.25 kg | 525 2901 |
| REMAFIX S BROWN | 0.5 kg | 525 2877 |
| REMAFIX S BLACK | 0.5 kg | 525 2853 |
| REMAFIX S H3 HARDENER | 0.025 kg | 525 2891 |
| 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 PR 100 | 5 - 25°C | 12 Months |
| REMAFIX S BROWN | 5 - 25°C | 12 Months |
| REMAFIX S H3 HARDENER | 5 - 25°C | 12 Months |
| REMAFIX S BLACK | 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 | - | - | BR |
| Abrasion | DIN 53516 | mm ³ | ≤ 250 |
| Density | DIN 53479 | g/cm ³ | 1.17 ± 0.02 |
| Hardness Shore A | ISO 48-4 | - | 75 ± 5 |
| Max. Surface Pressure | - | N/mm ² | 2 |
| Surface Resistance | DIN IEC 167 | - | ≥ 10 ¹¹ |
| Elongation at Break | DIN 53504 (ASTM D412) | % | ≥ 100 |
| Tensile Strength | DIN 53504 (ASTM D412) | N/mm ² | ≥ 3 |
| Max. Continuous Operating Temperature | - | °C | +90 |
| Temperature Range | - | °C | -40 up to +90 |

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.

TIP TOP Oberflächenschutz Elbe GmbH | Heuweg 4 | 06886 Wittenberg / Germany
 Phone: +49 (0) 3491 635 50 | E-Mail: info@tiptop-elbe.de | Internet: www.tiptop-elbe.com

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