

PRODUCT INFORMATION

REMAFIX 111

PRODUCT DESCRIPTION

REMAFIX 111 is a two-component, solvent-free, gray coloured repair paste, highly filled with special fillers, based on epoxy resin with high chemical and thermal resistance.

PRODUCT COMPOSITION

REMAFIX 111 consists of **REMAFIX 111 COMP. A** and **REMAFIX 111 COMP. B**. A primer is not necessary.

FIELDS OF APPLICATION

REMAFIX 111 is a corrosion-resistant repair paste for the repair of defects in metallic surfaces under hard or soft rubber linings or the restoration of defective metallic surfaces. The application in the autoclave under vulcanized rubber linings is shortly possible up to +140°C. **REMAFIX 111** is also suitable for fixing hard rubber plates on flange connections.

FEATURES

- High level of hardness
- Good chemical resistance
- Excellent adhesion on steel surfaces
- Applicable under rubber linings vulcanized in the autoclave (+140°C)
- Excellent mechanical properties
- Suitable for fixing hard rubber plates on flange connections
- Solvent free

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.

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 $R_z \geq 70 \mu\text{m}$ 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 weighed components must be mixed with a scraper until the mass is homogenous and uniformly coloured. Apply the mass cavity-free and as smooth as possible onto the area to be repaired. The maximum thickness of the layer should not exceed 10 mm. Otherwise multiple layers must be applied. After 24 hours the hardened mass can be processed mechanically. Before the application of the rubber lining the surface of **REMAFIX 111** must be roughened.

Large scale compensation with relatively high layer thickness should be avoided. The application must be carried out layer by layer. For large scale application please contact TIP TOP.

MIXING RATIO

REMAFIX 111 is supplied in pre-measured units. Otherwise weighing is required. After the unit has been mixed it shall be used within the specified pot life.

Product	Parts by Weight
REMAFIX 111 COMP. A	300
REMAFIX 111 COMP. B	200

CONSUMPTION

Product	Thickness [mm]	Coverage [g/m ²]
REMAFIX 111	1	ca. 2000

POT LIFE / WORKING TIME [min]

Product	15°C	20°C	30°C
REMAFIX 111	ca. 60	ca. 40	ca. 20

CLEANING

Clean all equipment with **SOLVENT T-200** immediately after use.

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 111 COMP. A	0.60 kg	525 1211
REMAFIX 111 COMP. B	0.40 kg	525 1221
REMAFIX 111 COMP. A	9 kg	525 1230
REMAFIX 111 COMP. B	6 kg	525 1240
SOLVENT T-200	4 kg	590 0610
SOLVENT T-200	8 kg	590 0611

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 111 COMP. A & B	5 - 25°C	24 Months
SOLVENT T-200	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
Abrasion	DIN 53754	g	0.093
Colour	-	-	Gray
Density REMAFIX 111 COMP. A	EN ISO 2811-1	g/cm ³	1.95
Density REMAFIX 111 COMP. B	EN ISO 2811-1	g/cm ³	1.90
Density Mixture REMAFIX 111	EN ISO 2811-1	g/cm ³	1.91
Hardness Shore D	ISO 48-4	-	80
Max. Operating Temperature	-	°C	-40 up to +140

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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