

PRODUCT INFORMATION

REMAFIX ST

PRODUCT DESCRIPTION

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

PRODUCT COMPOSITION

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

FIELDS OF APPLICATION

REMAFIX ST is a corrosion-, abrasion- and temperature resistant repair paste which is ideal for the restoration of worn metal surfaces. **REMAFIX ST** can be used for the repair and protection as well as for the filling of metallic surfaces (shafts, rollers, housings and fits) with pitting corrosion, cracks and other corrosive defects.

FEATURES

- High level of hardness
- Wear protection layer
- Good chemical resistance
- Excellent adhesion on steel surfaces
- Excellent mechanical properties
- Solvent free
- Shrink 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 ST** must be roughened.

A largescale 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 ST 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 ST COMP. A	300
REMAFIX ST COMP. B	200

POT LIFE / WORKING TIME [min]

Product	15°C	20°C	30°C
REMAFIX ST	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 ST COMP. A	0.60 kg	525 1251
REMAFIX ST COMP. B	0.40 kg	525 1261
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 ST 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	0.145
Colour	-	-	Dark gray
Density REMAFIX ST COMP. A	EN ISO 2811-1	g/cm ³	1.99
Density REMAFIX ST COMP. B	EN ISO 2811-1	g/cm ³	1.98
Density Mixture REMAFIX ST	EN ISO 2811-1	g/cm ³	1.98
Hardness Shore D	ISO 48-4	-	85
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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