

PRODUCT INFORMATION

CHEMONIT REPAIRING CEMENT A+B

Application Examples

CHEMONIT REPAIRING CEMENT A+B is a two component, reaction-hardening, paste-like and solvent-free material that is designed for the repair of smaller damages, for example pores and cracks in hard rubber linings.

CHEMONIT REPAIRING CEMENT A+B can be utilized only for repairing surface areas up to a maximum diameter of 100 mm. Larger surface areas must be repaired using a combination of hard rubber sheets and **CHEMONIT REPAIRING CEMENT A+B**.

CHEMONIT REPAIRING CEMENT A+B can be used especially in the field of drinking water. It corresponds to KTW recommendation and to DVGW-Working Sheet W 270.

In addition to this field of application, this material may also be utilized for the on-site lining of flanges with hard rubber. In such cases, pre-cut vulcanized hard rubber rings or segments are applied to the flange surface area.

CHEMONIT REPAIRING CEMENT A+B is shipped with 2 components, A + B. Both components must be mixed together according to the instructions just prior to use.

Product Description

Base:	synthetic resin
Solvent:	solvent-free
Colour:	charcoal grey
Specific weight:	1.85 (g/cm ³)
Hardness:	80 + 5 (Shore D)

Storage

Storage stability: up to a maximum of 9 months in the sealed original packing units.
Storage conditions: store in a dark, dry environment at + 15 °C to + 25 °C in accordance with DIN 7716

Preparation of Substrate

All surface areas to be repaired with **CHEMONIT REPAIRING CEMENT A+B** must be dry, clean, free of oils, grease and/or chemicals. The surface areas to be treated must be sanded and exposed using a rough grinding disk (granulation 24). Exposed steel surfaces will provide greater adhesion if they are abrasive blasted with compressed air. In this case, a minimum standard degree of purity of SA 2½ as specified in DIN EN ISO 12944-4 must be attained, i.e. the depth of roughness Rz must correspond to at least 50 µm.

Processing Instructions

TIP TOP Oberflächenschutz Elbe GmbH	CHEMONIT REPAIRING CEMENT	INDEX G of 22.01.2005
Page: 1/2	API	Replaces Issue: 02.09.2003

A pre-requisite for the proper application is an ambient temperature of + 15 °C to + 45 °C. Lower temperatures will cause the paste to harden very slowly and/or possibly incompletely.

Mixing and Application

Immediately prior to use, identical parts by weight of the components A + B must be thoroughly and carefully mixed until a homogenous, spreadable compound is attained, taking care to avoid air inclusions. The filler compound must be processed and applied within a 30-minute time span.

The prepared paste is applied to the pretreated surface areas using a trowel. The processability of this two-component compound at + 25 °C is limited to approx. 30 minutes (pot life).

Hardening

At + 25 °C the treated area will be completely hardened after approx. 8 – 10 hours. The hardening time can be considerably reduced by means of thermal treatment (hot air or radiant heater at approx. + 60 °C). Once the treated area has hardened, the repaired spot can be refinished by means of sanding, for example.

Safety Regulations

All safety regulations as well as the danger warnings on the packing units must be adhered to!

Remarks

The data furnished in the foregoing is the result of research and trials carried out in the field as well as long-term practical experience. In view of the diversity of materials involved and individual working conditions that are outside of our sphere of influence, we would recommend carrying out a sufficient number of internal field tests prior to use. No warranties – express or implied – can be derived from this data.

Available Packing Units

Product Description	Packing Units	Product-No.
CHEMONIT REPAIRING CEMENT Component A + B	1 kg set of Component A + B each 0.5 kg	525 0563
CHEMONIT REPAIRING CEMENT Component A + B	0.5kg set of Component A + B each 0.25 kg	525 0556

This data sheet is for informational purposes only. All data provided herein is based on in-depth research and testing, however no liability whatsoever can be assumed. Since we are constantly endeavouring to up-date and improve our products, we recommend noting the index and issue date indicated on this data sheet and to inquire as to whether any properties have changed in the interim. This Product Information Sheet replaces all prior issues. Please contact our Technical Consultant for detailed information in case of ambiguities.

TIP TOP Oberflächenschutz Elbe GmbH, Heuweg 4, D-06886 Wittenberg
Phone: (0 34 91) 6 35 – 50, Fax: (0 34 91) 6 35 – 5 52