RESIFLEX 407 GP 80 Fluid – abrasion resistant pourable elastomer

Resiflex 407 GP 80 Fluid is a two component solvent free abrasion resistant urethane elastomer. The product has been specifically developed as an abrasion resistant lining and for repairs to a wide range of rubber surfaces such as nitrile, neoprene & natural rubber.

- Convenient packaging
- Solvent free
- Durable and abrasion resistant
- Simple and easy to use
- Pourable or brush applied

Typical Applications

Gasket sealing lining of process equipment casting of components

Surface Preparation

Metallic Substrates – Mechanical abrasion

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded using handheld grinders to ***ISO 8501/4 ST3 (SSPC SP3 ST3)***.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.

Metallic Substrates – Abrasive blast cleaning

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be abrasive blasted to ***ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)*** minimum blast profile of 75 microns (3mil) using an angular abrasive.
3. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.

PLEASE NOTE: *For salt contaminated surfaces the substrate must be pressure washed with clean water, carefully dried and checked for salt contamination, please refer to the surface preparation and pre-application guide for further information.*

Rubber substrates

1. Remove any surface contamination and degrease with MEK.
2. Use a suitable carding tool or MBX bristle blaster to roughen the surface before brushing away any debris.

Once all surfaces, metallic or rubber, have been prepared, apply Resiflex 402 Multi-surface Primer to all surfaces using a cut down brush. Apply the primer to the surface with a stippling action avoiding ponding and leave to cure until touch dry and for a minimum of 20 minutes at 20°C (68°F).

Mixing and Application

Prior to mixing please ensure the following:

1. The ambient & surface temperature is above 10°C (50F°).
2. The ambient & surface temperatures are not less than 3°C (6°F) above the dew point.

Once these 2 checks have been met, please proceed with mixing the product.

1. **Resiflex 407 GP 80 Fluid** is supplied in a twin compartment bag with the base and activator components already pre-measured.
2. Ensure the product is around 20°C prior to use to ease mixing.
3. Remove the plastic divider and thoroughly mix the two components by hand until homogeneous.
4. Dispense the mixed product into a mixing pot (minimum 600ml).
5. Mix the product in the pot using the spatula provided.
6. Once you have a homogenous mix pour the mixed product onto the repair surface, alternatively the product can be brush applied at thicknesses up to 250-300 microns (9-12mil)

Coverage Rates

500gm (435ml) of fully mixed product will give the following coverage rates –
1,74m² at 250m
0.435m² at 1mm

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

Cure Times

At 20°C the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Usable Life	30mins
Minimum overcoating	4hrs
Max overcoating	36 hours
Water immersion	3 days
Chemical contact	7 days

Pack Sizes and Colour

This product is available in the following pack sizes –
500gm (435ml) foil laminate bag
Colour – Amber

Over-coating times

Minimum - the material can be over-coated as soon as it is touch dry, approximately 4hrs at 20°C (68°F).
Maximum - the over-coating time should not exceed 36 hours at 20˚C.

Storage Life

1 year if unopened and store in normal dry conditions (15-30°C)

Other Technical Documents

Safety Data Sheets	-	Base & Activator components
Product Specification Sheet	-	Technical Performance Information

Health and Safety

Please ensure good practice is observed at all times. Protective gloves, goggles & a disposable coverall must be worn during the mixing and application of this product. Before mixing and applying the material ensure you have read the fully detailed Safety Data Sheet.

Legal Notice:

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine if the product is suitable for use. Resimac accepts no liability arising out of the use of this information or the product described herein.