



resimac<sup>co</sup>

## 204 UHD Paste

A two component solvent free epoxy with ceramic beads for extreme impact and sliding abrasion. It provides high adhesion for protecting metal substrates from aggregates and wet slurries.

- Apply to abrasive blast cleaned surfaces
- High mechanical adhesion to metal substrates
- Ideal for impact and sliding abrasion

2024 Product Sheet

## Typical Applications

204 UHD Paste is a two component solvent free repair compound based on an energy absorbing epoxy resin blend and ceramic beads for extreme impact & sliding abrasion environments from aggregates & wet slurries.

- Slurry pumps
- Bins & hoppers
- Fan blades & housings
- Internal pipe surfaces
- Wear plates
- Pipe elbows
- Chutes
- Transport screws
- Pulverisers
- Ceramic tile lined chutes

## Characteristics

### Appearance

Base	Mid Grey paste
Activator	Black paste
Mixed	Mid Grey paste

### Solids Content

100%

### Volume Capacity

420cc/kg

### Sag Resistance

Nil at 20mm

### Density

Base	2.4
Activator	2.29
Mixed	2.37

### Mixing Ratio

By weight	2.12:1
By volume	2:1

### Storage Life

2 years if unopened and stored in normal dry conditions (15- 30°C) (59-86°F)

## Cure times

### Usable Life

10°C/50°F	100 mins
20°C/68°F	50 mins
30°C/86°F	25 mins
40°C/104°F	12.5 mins

### Min machining time

10°C/50°F	12 hours
20°C/68°F	6 hours
30°C/86°F	3 hours
40°C/104°F	1.5 hours

### Max overcoating time

10°C/50°F	24 hours
20°C/68°F	12 hours
30°C/86°F	6 hours
40°C/104°F	3 hours

### Full Cure

10°C/50°F	8 days
20°C/68°F	4 days
30°C/86°F	2 days
40°C/104°F	24 hours

## Coverage

5kg (11lb) of fully mixed product will give the following coverage rates:

0.35m <sup>2</sup> at 6mm	3.76ft <sup>2</sup> at ¼"
0.21m <sup>2</sup> at 10mm	2.26ft <sup>2</sup> at 0.4"

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

## Mechanical Properties

### Abrasion Resistance

Taber H10 Wheels/1kg load 29mm<sup>3</sup> loss/1000 cycles

### Compressive Strength

Tested to ASTM D695 790kg/cm<sup>2</sup> (11,150psi)

### Corrosion Resistance

Tested to ASTM B117  
Minimum 1000 hours

### Flexural Strength

Tested to ASTM D790 415kg/cm<sup>2</sup> (5860psi)

### Heat Resistance

Full immersion resistance Tested water/hydrocarbon immersion to 60°C (140°F) Pass (no blisters)

Dry heat resistance Tested to ASTM D2485 Pass 120°C (248°F)

### Adhesion

Tensile Shear to ASTM D1002 on abrasive blasted mild steel with 75 micron profile 236kg/cm<sup>2</sup> (3330psi)

Pull off Adhesion to ASTM D4541 on abrasive blasted mild steel with 75 micron profile 258kg/cm<sup>2</sup> (3645psi)

### Impact Resistance

Tested to ASTM D256 66J/m

## Details & Legal

### Chemical Resistance

The product resists attack by a wide variety of inorganic acids, alkalis, salts and organic media. For more detailed information refer to the Resimac Technical Centre for advice.

### Pack Sizes

This product is available in the following pack sizes:  
5kg

### Quality

All Resimac Products are supplied under the scope of the company's fully documented quality system.

### Warranty

Resimac warrants that the performance of the product supplied will conform to the typical descriptions quoted within this specification provided material is stored correctly and used according to the procedures detailed in the Technical Data Sheet for the material.

# Application Guide

## A. Surface Preparation

### 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 85 01/4 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.
- 5 For enhanced adhesion (e.g., vertical surfaces) apply a primer layer of 202 Ceramic Repair Fluid to the substrate. Allow it to become tack dry (approx. 1 hour) before applying the 204 UHD Paste.

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

### Health & Safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves and other recommended personal protective equipment must be worn during the mixing and application of this product.

Before mixing and applying the material please ensure you have read and fully understood all information.

## Quick Application Guide



### Step 1

Ensure you have:

1 x base unit

1 x activator unit

1 x spatula

1 x applicator

1 x clean mixing area



### Step 2

Take equal 5 equal measures of base material, clean the spatula, then take 2 measure of the activator.



### Step 3

Mix the two components using the spatula provided, ensure any unmixed material around the edges is mixed.



### Step 4

To ensure the product is fully mixed create a diamond pattern on the surface and look for any unmixed areas.



### Step 5

Once the material is fully mixed use the applicator tool provided to apply the beaded ceramic repair paste to the surface.

## About Resimac

**A UK based manufacturer of epoxy and polyurethane coatings and repair materials.**

From our head office in the heart of rural North Yorkshire, England we supply our range of Epoxy, Polyurethane & Silicone coatings and repair materials to the Oil & Gas, Petrochemical, Marine, Paper & Pulp, Water, Power Generation & Chemical Industries.

## Legal Notice

The data contained within this Product Specification 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 the products suitability for use. Resimac accepts no liability arising out of the use of this information or the product described herein.

## Information & Enquiries

For more information and technical data please visit our website or contact us.

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