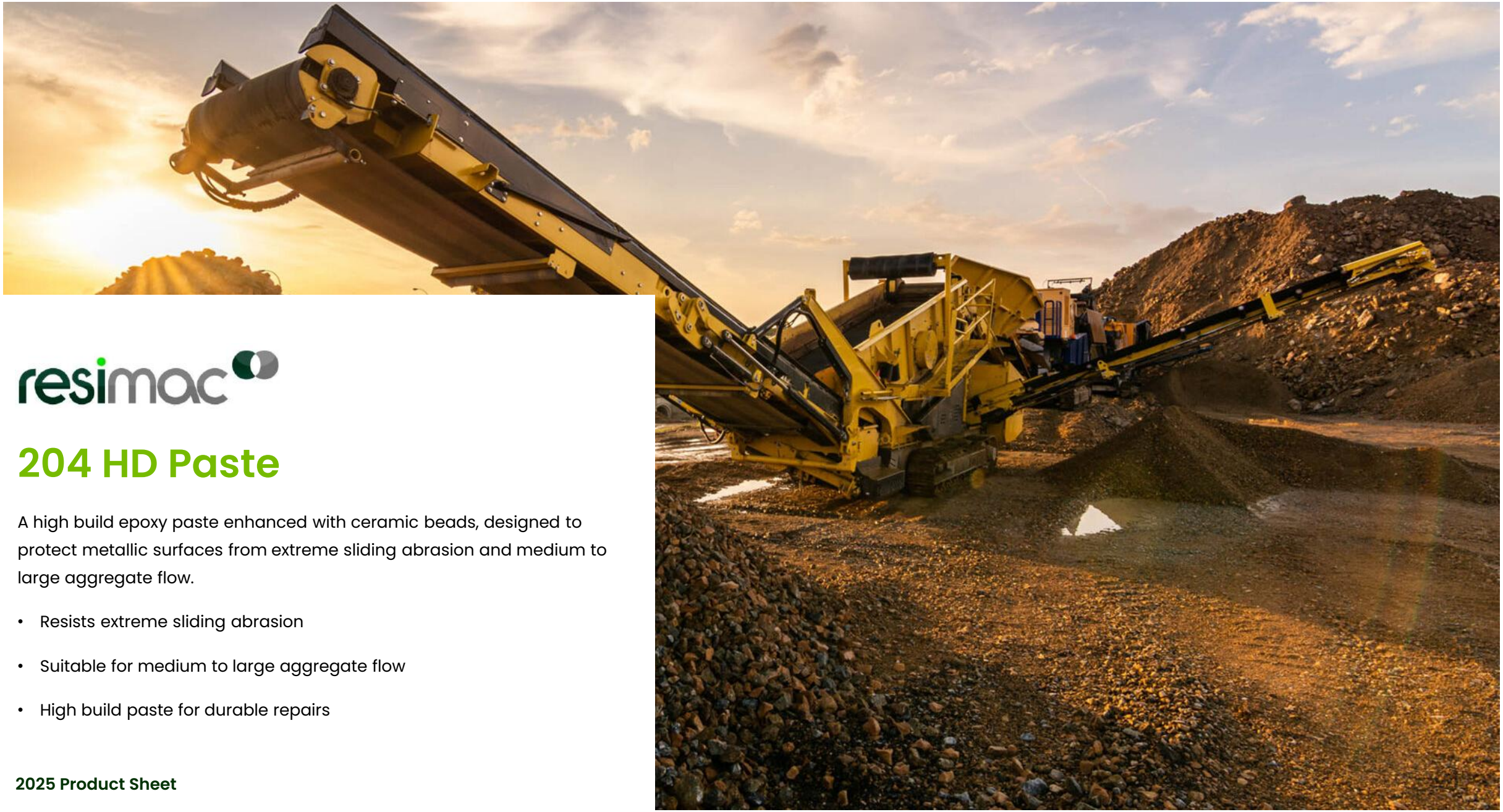


204 HD Paste

A high build epoxy paste enhanced with ceramic beads, designed to protect metallic surfaces from extreme sliding abrasion and medium to large aggregate flow.

- Resists extreme sliding abrasion
- Suitable for medium to large aggregate flow
- High build paste for durable repairs

2025 Product Sheet

Typical Applications

204 HD Paste is a two component, solvent free epoxy repair compound containing 0.2mm–1.5mm ceramic beads, designed for extreme wear environments. Formulated for wet slurry abrasion and sliding wear from particles, it is ideal for resurfacing and protecting metal substrates exposed to abrasion and erosion.

- Slurry pumps
- Bins & hoppers
- Fan blades & housings
- Internal pipe surfaces
- Wear plates
- Pipe elbows
- Chutes
- Transport screws

Characteristics

Appearance

Base	Light Grey paste
Activator	Black paste
Mixed	Mid Grey paste

Solids Content

100%

Volume Capacity

440cc/kg

Sag Resistance

Nil at 10mm

Density

Base	2.28
Activator	2.26
Mixed	2.27

Mixing Ratio

By weight	2:1
By volume	2:1

Storage Life

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

Cure times

Usable Life		Min overcoating time		Max overcoating time		Full Cure	
10°C/50°F	60 mins	10°C/50°F	8 hours	10°C/50°F	16 hours	10°C/50°F	8 days
20°C/68°F	30 mins	20°C/68°F	4 hours	20°C/68°F	8 hours	20°C/68°F	4 days
30°C/86°F	15 mins	30°C/86°F	2 hours	30°C/86°F	4 hours	30°C/86°F	2 days
40°C/104°F	7.5 mins	40°C/104°F	1 hour	40°C/104°F	2 hours	40°C/104°F	24 hours

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

Coverage

1.5kg (3.3lb) of fully mixed product will give the following coverage:

0.219m² at 3mm	2.245ft² at 120mil
0.111m² at 6mm	1.193ft² at ¼"

5kg (11lb) of fully mixed product:

0.73m² at 3mm	7.848ft² at 120mil
0.37m² at 6mm	3.978ft² at ¼"

Mechanical Properties

Abrasion Resistance
Taber H10 Wheels/1kg load
42mm³ loss/1000 cycles

Compressive Strength
Tested to ASTM D695
1046kg/cm² (14880psi)

Corrosion Resistance
Tested to ASTM B117
Minimum 1000 hours

Flexural Strength
Tested to ASTM D790
475kg/cm² (6710psi)

Hardness
Shore D to ASTM D2240: 89

Adhesion
Tensile Shear to ASTM D1002 on abrasive blasted mild steel with 75 micron profile 272kg/cm² (3840psi)

Pull off Adhesion to ASTM D4541 on abrasive blasted mild steel with 75 micron profile 272kg/cm² (3840psi)

Impact Resistance
Tested to ASTM D256 22J/m

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 150°C (302°F)

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:
1.5kg (3.3lbs)
5kg (11lbs)

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 this document.

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.

B. Product Preparation

Prior to mixing, please ensure the following:

1. The base component is at a temperature between 15-25°C (60-77°F).
2. The ambient & surface temperature is above 10°C (50°F).
3. The ambient & surface temperatures are not less than 3°C (6°F) above the dew point.

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.

C. Mixing

If mixing a complete unit of material (1.5kg/5kg):

1. please ensure as much of the base and activator is dispensed from the plastic container onto a clean plastic mixing surface.
2. Mix using the spatula provided until a uniform material free of any streakiness is achieved while ensuring no unmixed material is left on the spatula or the mixing surface.
3. From the commencement of mixing the whole of the material should be used within 30 minutes at 20°C (68°F).

If part mixing the unit of material:

1. using a spatula place 2 equal measures from the base unit onto a clean plastic mixing surface.
2. Clean the spatula thoroughly.
3. Take 1 equal measure from the Activator unit and place alongside the base measures.
4. Ensure the product is streak free and a consistent colour before applying to the repair surface.

PLEASE NOTE: From the commencement of mixing, the material should be used within 20 minutes at 20°C (68°F).

D. Application

Step 1

Using the spatula or applicator tool, apply the material to the blast prepared surface.

Step 2

Ensure the product is pressed into any holes, scars or cracks and profile the repair to a smooth finish.

Step 3

Apply in a single coat at wet film thickness of 3-6mm.

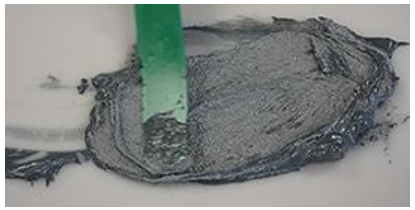
Quick Application Guide

Step 1

Ensure you have:
1 x base unit
1 x activator unit
1 x spatula
1 applicator
1 x clean mixing area

Step 2

Take equal 2 equal measures of base material, clean the spatula, then take 1 measure of the activator.

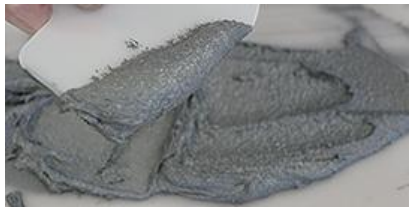


Step 3

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 areas which are not mid grey in colour.



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

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