204 XHT Paste

Designed for extreme wear environments, this solvent free epoxy withstands high operating temperatures, abrasion, and particle flow, offering long lasting protection in wet slurry and sliding wear applications.

- Suitable for high operating temperatures up to 240°C (464°F)
- Resists medium to large particle aggregate flow
- Resists extreme sliding abrasion
- High mechanical adhesion to metal substrates

2025 Product Sheet

Typical Applications

204 XHT Paste is a two component, solvent free epoxy novolac repair compound formulated with ceramic beads to provide abrasion resistance in environments where particles and wet slurries cause wear. The solvent free formulation ensures safer handling and minimal environmental impact, while still offering high performance in extreme conditions.

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

Characteristics

Appearance

Base	Dark grey paste
Activator	Blue paste
Mixed	Dark blue paste

Solids Content

100%

Volume Capacity

448cc/kg

Sag Resistance

Nil at 10mm

Density

Base	2.21
Activator	2.26
Mixed	2.23

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		Max overcoating time		Full Cure	
10°C/50°F	60 mins	10°C/50°F	24 hours	10°C/50°F	6 days
20°C/68°F	30 mins	20°C/68°F	12 hours	20°C/68°F	3 days
30°C/86°F	15 mins	30°C/86°F	6 hours	30°C/86°F	1.5 days
40°C/104°F	7.5 mins	40°C/104°F	3 hours	40°C/104°F	18 hours

Coverage

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

0.747m² at 3mm	8.03ft² at 120mil
0.373m² at 6mm	4.01ft² at ¼"

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
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: 85

Impact Resistance
Tested to ASTM D256 22J/m

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 (3840 psi)

Heat Resistance
Full immersed resistance:
Tested water/hydrocarbon immersion to 130°C (266°F)
Pass (no blisters)

Dry heat resistance:
Tested to ASTM D2485
Pass 240°C (464°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:
1kg (2.2lbs)
3kg (6.6lbs)

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 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.

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 part mixing the unit of material:

1. Using the spatula provided place 2 equal measures from the base unit onto the mixing board provided.
2. Clean the spatula thoroughly.
3. Then take 1 equal measure from the activator unit and place alongside the base measures.
4. Mix the 2 components together until you have a streak free mix (mid grey) on the mixing board.
5. Ensure there is no unmixed material on the spatula or mixing board.

If mixing a complete unit of material:

1. Dispense as much of the base and activator units onto a clean mixing board.
2. Mix the 2 components together until you have a streak free mix (dark blue) on the mixing board.
3. Ensure there is no unmixed material on the spatula or mixing board.

PLEASE NOTE: From the commencement of mixing, the material should be used within 30 minutes at 20°C (68°F).

D. Application

Step 1

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

Step 2

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

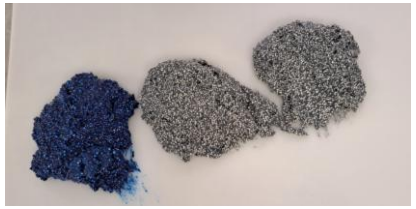
Step 3

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 x applicator
1 x clean mixing board



Step 2

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

Step 3

Use the provided spatula to mix both components, ensuring all material, including edges.

Step 4

To ensure the product is fully mixed create a diamond pattern on the surface and for any areas which are not blue in colour.

Step 5

Once fully mixed, use the provided applicator 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.

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