

PLASMET

Plasmet HTE

Product reference: 5/05

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Product title: Plasmet HTE

Valid from: 3rd December 2007

Last reviewed: May 2018

Type

A viscous, solvent free, two or three pack, amine cured epoxy, containing both stainless steel flakes, glass flakes and silicon carbide.

Suggested use

Areas requiring abrasion (and chemical) resistance. This material has been used in cyclones, chemical process vessels, sugar beet pulping drums etc. It is also useful for building up damaged areas of pump impellers and casings where impact or abrasion, are prevalent.

Limitations

Dependent upon environment, Immersed conditions: 135°C. Non-immersed conditions: 170°C.

Health & safety

Before handling or using this product the material safety data sheet should be read and all precautions observed.

Surface preparation

To obtain optimum adhesion the substrate should be grit blasted to Swedish Standard Sa 2½ with 75 micron profile. If grit blasting is not possible, smooth surfaces should be roughened and scored by grinding to give the coating a key. Under these conditions there will be some reduction in adhesion properties. A release agent should be used for any surface to which the coating should not adhere.

Application equipment

Trowel, putty knife, stiff brush or other suitable implement.

Application

This material is intended for application at thicknesses between 1.5 to 4mm. It not normally applied at less than 1mm thickness

but can be built up to any desired thickness provided care is taken to avoid pronounced exothermic temperature rises. Material should only be applied when the surface temperature is between 8°C and 40°C. The surface temperature should be 5°C above dew point and humidity below an RH value of 90%. **It is advisable to check for 'amine bloom'.** Where this is suspected by visual appearance or where the environmental and ambient temperatures are outside the above limits. A suitable 'bloom' test kit may be used.

Mixing ratio

2.3 Parts base to 1 part activator by weight.

Mixing instructions

Remove lids from both components A-Activator and B-Base and scoop out all of component A putting into component B. Mix thoroughly, ensuring that no unmixed material remains. Remove all mixed material from base tin and remix on a clean flat surface or shallow receptacle. After mixing, the material remains usable for a limited period dependent upon temperature, after which time application becomes difficult.

Mix only sufficient material that can be applied with the limited pot life.

Pot life

Temp °C	20	30	40
Usable time (minutes)	50	20	15

To increase pot life at high ambient temperatures refrigerate material prior to use to a minimum temperature of 10°C. Gel times will vary depending on temperature and quantity.

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Thinners

DO NOT THIN. Any addition of solvent will be detrimental to performance.

Packaging

1 or 5 and 10 kilo composites.

Storage life

2 years minimum in unopened tins, stored at 5°C-40°C.

Colour availability

Speckled grey.

Recommended DFT

As a general lining 2mm, any desired thickness build up.

Theoretical spreading rate

1m²/litre at 1mm thickness.

Volume solids

100%.

Practical spreading rate

0.85m²/litre at 1mm thickness.

Note: This information is given in good faith but may increase dependent upon environment conditions, the geometry and nature of work undertaken, and the skill and care of application. Corrocoat accept no responsibility for any deviation from these values.

Specific gravity

1.37gcm³ mixed.

Flash point

Greater than 110°C.

Activator type

Formulated Amine.

Mixing ratio

2.3:1 Base to Hardener W/W

Adhesive strength

Greater than 10 MPa

Hardness

45 to 50 Barcol

Cure time

24 hours at 20°C.

Although the cold cured properties of this material are excellent they may be improved further by post curing. This can be achieved by applying heat at 60 to 100°C for periods up to 24 hours at which time maximum possible cure will have been attained. Post cure for shorter periods will also improve the characteristics of this material.

Overcoating time

Maximum over-coating time is 12 hours at 20°C. The minimum over-coating time is 1 hour at 20°C (2mm coating thickness). At different temperatures these times will vary, being shorter at higher temperatures and longer at lower temperatures. Amine bloom may cause intercoat adhesion failure. Refer to 'Application' above.

Cleaning solvent

Acetone, Methyl Ethyl Ketone, Xylene.

Chemical resistance

Excellent.

Reviewed 11/2007
Reviewed 02/2014
Reviewed 05/2016
Revised 05/2018