

PRODUCT DESCRIPTION

REFLEX 4401 GP 60 is a two component fast curing solvent free urethane elastomer. The product has been specifically developed for repairs to a wide range of rubber surfaces such as nitrile, neoprene and natural rubber.

TYPICAL APPLICATIONS

Suitable for repairing, lining and casting to damaged equipment such as:

- Conveyor Belts
- Valve seats
- Process equipment lining
- Gasket sealing
- Cutlass bearings
- Chutes and hoppers

SURFACE PREPARATION

STEEL SUBSTRATE

For optimum performance steel substrates should be abrasive blasted to ISO 8501/4 Standard SA2.5 (SSPC SP10/NACE 2) and a minimum blast profile of 75 microns using an angular abrasive. Remove all residual blast debris and the surfaces inspected. Profile checks should be taken and recorded. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be repaired before rusting or oxidation occurs.

PLEASE NOTE: Salt contaminated surfaces must be pressure washed with fresh clean water and checked using a suitable chloride measurement gauge. This process must be repeated until all ingrained contaminants have been sweated out of the surface.

Where abrasive blast cleaning is not possible (excluding salt contaminated surfaces) the surface should be roughened by MBX or a suitable hand held grinder. Under these conditions adhesion levels will not be optimal although still satisfactory for most applications.

FLEXIBLE SURFACES - RUBBER

Clean away any loose or friable rubber and degrease and cleaned using MEK or similar cleaner/degreaser. Any loose edges can be cut back using a sharp knife. If possible undercut the repaired area. Roughen the surface with a rotary wire brush, course ruffing brush or suitable roughening tool.

MIXING AND APPLICATION

PRECAUTIONS

Do not apply when the ambient or substrate temperature is below 10°C (40°F) or less than 3°C (37°F) above the dew point.

MIXING AND APPLICATION

PRIMER

Immediately apply Reflex 4402 GP Primer to all surfaces using a brush. Apply the primer as liberally as possible and force it into the prepared surface. Leave to cure for a minimum of 20 minutes at 20°C or until touch dry.

REFLEX 4401 GP 60

The product is supplied in easy to use 420 gm cartridges with the base and solidifier already pre measured. Warm the cartridge to 20°C-25°C prior to use. Cut the end off the mixing nozzle, remove the cap from the cartridge and attach the nozzle.

Dispense the mixed product onto the surface to be repaired and smooth out with the applicator tool provided. If required the use of 808 reinforcement tape can be stippled into the product to create a multi level reinforced system.

If it is not practical to warm the cartridge to 20°C-25°C, then dispense with the mixing nozzle and unscrew the cap on the end of the 420gm cartridge. Dispense the base and solidifier onto a clean mixing surface. Using the spatula tool provided mix both components until you have a uniform mixture. Then apply as above.

CURE TIMES

At 20°C (68°F) 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	4 - 5 minutes
Touch Dry	30 minutes
Light loading	1 hours
Full loading	4 hours
Chemical immersion	24 days

TECHNICAL DATA SHEET:
REPFLEX 4401 GP 60

COVERAGE RATES

A 420gm (400ml) of fully mixed product will give the following coverage rates –

0.4m² at 1mm
0.2m² at 2mm
0.133m² at 3mm

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

OVERCOATING TIMES

Minimum - the material can be over-coated as soon as it is touch dry

Maximum - the over-coating time should not exceed 36 hours.

UNIT SIZES AND COLOUR

Product is available in the following pack sizes –
420gm cartridge (400ml)
Colour - Black

STORAGE LIFE

The shelf life of the product is typically 1 year if unopened and stored in cool dry conditions (15-30°C/ 60-86°F).

TECHNICAL SUPPORT

Zoom Corrosion Technology offer complete technical support and assistance, from discussing application requirements to training approved local contractors. For further information please contact a REPCO representative or your nearest REPCO authorised dealer.

HEALTH AND SAFETY

Please refer to the product safety data sheet for detailed information on handling, storage, shipping and disposal.

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RepcO products are manufactured for:
Zoom Corrosion Technology
Pembroke Lodge, 3 Pembroke Road, Ruislip,
HA4 8NQ, England, UK
Tel: +44 (0) 794 934 1074
Email: sales@zoomct.com
www.zoomct.com

ZOOM
CORROSION TECHNOLOGY