

3M™ Scotchkote™ Urethane Ceramic Rebuild EG 515

(formerly Cerami-flex EG)

Data Sheet and Application Guide

Product Description

Scotchkote Urethane Ceramic Rebuild EG 515 has been specifically developed as a 100% solids repair system with a degree of flexibility for rebuilding and resurfacing equipment operating in fluid flow environments.

Product Features

- Combines good application characteristics with good cavitation and erosion resistance.
- Designed for application by trowel or spatula at thicknesses up to 6 mm (0.24 in.).
- Provides outstanding protection against impingement.
- Primarily designed for use on propellers, kort nozzles, guide vanes, and turbines.

Surface Preparation

Steel surfaces should be abrasive blasted to NACE No. 2/SSPC-SP10 Near White Metal, ISO 8501:1, Grade SA2½. A minimum blast profile of 75-100 microns (3-4 mils) should be achieved. Where blast cleaning cannot be carried out the surface should be mechanically abraded to remove all loose scale and produce a surface which is clean, dry and free from rust or dust.

When treating existing equipment which may have become salt impregnated due to service conditions, surfaces should first be wet blasted then dry blasted and tested for presence of salts. This process should be repeated until all salts are removed.

Product Mixing

Scotchkote Urethane Ceramic Rebuild EG 515 is a two component material comprising Part A and Part B components which must be mixed together prior to use.

Add all the contents of the Part B container into the Part A container and mix thoroughly, alternatively measure three volumes of Part A and one volume of Part B into a clean container and mix thoroughly. The two components initially are fluid, but on mixing form a paste material. To ensure thorough mixing, the paste should be transferred to a mixing board and further mixing carried out to produce a streak free material.

The mixed material should be used within 20 minutes of mixing at 20°C (68°F). This time will be reduced at higher temperatures and extended at lower temperatures.

Application Procedures

Scotchkote Urethane Ceramic Rebuild EG 515 should not be applied when the relative humidity exceeds 90% or when the surface to be coated is less than 3°C (5°F) above the dew point.

The mixed product should be applied by trowel or spatula and should be applied to give a uniform even thickness.

Ideally Scotchkote Urethane Ceramic Rebuild EG515 should be applied in a single high build coat. If a second coat is required for any reason, overcoating must be carried out within 24 hours of application of the preceding coat. If the overcoating time is extended thorough mechanical abrading or flash blasting of the first coat should be carried out once the coating is hard dry.

Properties

Property	Value
Color	Grey
Ratio	3:1 By volume 3:1 By weight
Drying & Cure times at 20°C (68°F)	
Useable life	20 mins
Touch Dry	2½ hours
Hard Dry	4 hours
Maximum Overcoating	24 hours
Full Cure	7 days
Volume Solids	100%
Specific Gravity (Average Mixed)	1.2
Film Thickness	Up to 6 mm (0.24 in.)
Volume Capacity	835 cc (53 cu in) per kilo
Tensile Strength	20 Mpa (2825 psi)
Dielectric Strength	> 20 KV @ 6 mm
Abrasion Resistance (ASTM D4060)	0.08 mg loss per 1000 cycles, 1 kg load, CS17 wheel



Packaging and Storage

Supplied in 1 kilo packs

Use within 2 years of purchase. Store in original sealed containers at temperatures between 5°C (41°F) and 30°C (86°F).

Handling and Safety Precautions

Read all Health Hazard, Precautionary and First Aid, Material Safety Data Sheet, and/or product label prior to handling or use.

Ordering Information/Customer Service

For ordering technical or product information, or a copy of the Material Safety Data Sheet, call:

Phone: 800/722-6721 or 512/984-9393

Fax: 877/601-1305 or 512/984-6296

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80-6111-8540-8