

DESCRIPTION

RezRok[®] 180 is a two component paste for repairing and rebuilding machinery and equipment as well as for being used as a high strength structural adhesive. The system is based on toughened epoxy novolac resins, silicon steel alloy, and fillers for chemical and corrosion resistance.

TYPICAL APPLICATION

• Optional	Appropriate Metal Primer
• Body Coat	RezRok [®] 180 @ 1/8" thickness

PERFORMANCE DATA

Compressive Strength . ASTM C-579.....	11,000 psi
Tensile Strength ASTM C-307.....	2,400 psi
Bond Strength ASTM D-4541	>1,000 psi
Hardness (Shore D) ASTM D-2246	87
Density	165 pcf (2.64 gm/cm ³)
Heat Resistance	30 0°F

STORAGE & INSTALLATION

Storage Environment.....	Dry area, indoor: 65–80°F
Application Temperature, ambient	40–95°F
Application Temperature, substrate	40-95°F
Shelf Life	12 months
Pot Life, @ 77°F.....	40 minutes
Tack Free Time, @ 77°F	2.5 hours
Light Movement @ 77°F.....	4 hours
Full Loading @ 77°F	2 days
Contact with Chemicals @ 77°F	3 days

Material cures more slowly at cooler temperatures, and working time will be substantially reduced at higher temperatures. In hot weather, material should be cooled to 65°F to 80°F prior to mixing and application to improve workability and avoid shortened pot life. The data shown above reflects typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result.

CONSIDERATIONS & LIMITATIONS

1. Do not thin with solvents unless advised to do so by PolySpec.
2. Prepare substrate according to "Surface Preparation" portion of this document.
3. Always use protective clothing, gloves and goggles consistent with OSHA regulations during use. Avoid eye and skin contact. Do not ingest or inhale. Refer to Material Safety Data Sheet for detailed safety precautions.
4. For industrial/commercial use. Installation by trained personnel only.
5. Do not apply when the temperature is below 40°F (5°C) or the relative humidity is above 85%.
6. Do not apply when there is moisture on the metal surface or is likely to be deposited by subsequent condensation.
7. Do not apply when the working environment is likely to be contaminated by oil/grease from adjacent equipment or smoke from kerosene heaters or tobacco smoking.
8. Metal must be a minimum of 5 °F above the dew point at the time of application and throughout the cure cycle.

RezRok[®] 180

TECHNICAL DATA SHEET

Epoxy Novolac Engineering Repair Compound

BENEFITS

- Excellent dry-heat abrasion resistance
- Excellent impact resistance
- Excellent chemical and corrosion resistance
- Long working times
- Cures down to 40°F

RECOMMENDED USES

- Pipes
- Tanks
- Flange Faces
- Casings
- Shafts
- Bushings
- Bearing Houses
- Tiles

GENERIC DESCRIPTION

Epoxy Novolac

STANDARD COLOR

Gray

PACKAGING

2 Gallon Unit

MIX RATIO 1:1 BY VOLUME

COVERAGE

25 ft² / unit @ 1/8" thickness

SURFACE PREPARATION

This product can be applied to the following substrate(s) that have been prepared according to PolySpec Surface Preparation Guidelines:

Apply only to blast cleaned surfaces.

1. Clean up loose contamination and degrease with a rag soaked in an effective cleaner, e.g. methyl ethyl ketone (MEK), which does not leave a residue.
2. Use only an angular abrasive to give a minimum depth of profile of 3 mils.
3. Blast-clean the metal surface to achieve near white finish SSPC SP 10.
4. After blasting, metal surfaces should be coated before any possible oxidation.

Metal must have < 3µg/cm² chloride and <5µg/cm² sulfate contamination.

INSTALLATION STEPS

1. **Mixing:** Preblend Part A and Part B before beginning. Measure equal volumes of Part A and Part B. Place Part B into part A and mix together using a mechanical mixer, such as a Jiffy mixer, scrape the sides and bottom of the container and mix an additional minute to ensure material is homogeneous.

Warning: *Improperly mixed material will not cure properly.*

2. **Application:** Apply RezRok[®] 180 onto prepared surface with a plastic applicator, spatula, or trowel blade. Press down firmly to remove entrapped air and insure maximum bonding to the surface. If necessary, additional layer should be applied when the first layer is still soft, within 2 hours at 77°F. If the over-coating time is exceeded, brush blast the cured material before any further application.
3. **Cleaning:** Clean tools with PolySpec[®] All Purpose Cleaner a low evaporating cleaner. Always wear gloves when using this product. Wash hands, arms and face with warm soapy water.

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