RESIMETAL 203 Super Flow –

solvent free flow efficiency epoxy fluid with hardened ceramic fillers

Resimac 203 Super Flow is an erosion-corrosion resistant coating used principally in fluid flow situations for improving flow efficiency. The material can be applied directly to abrasive blasted steel or to surfaces previously rebuilt with Resimac 101 Metal Repair Paste or 201 Ceramic Repair Paste.

- Apply to abrasive blast cleaned surfaces
- Apply to surfaces repaired using 101 Metal Repair Paste/ 201 Ceramic Repair Paste
- Improves fluid flow through process equipment

Typical Applications

impellers & pump casings	valves	heat exchanger end plates
water boxes	separator housings	pipes
propellers	kort nozzles	rudders
bow thrusters	ship hulls/ bow	separators

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.

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.*

Mixing and Application

Prior to mixing please ensure the following:

1. The base component is at a temperature between 15-25°C (60-77F°).
2. The ambient & surface temperature is above 10°C (50F°).

Once these 2 checks have been met, please proceed with mixing the product.

Mix the unit in full (1kg/3kg) please follow the instructions below:

1. Pour the contents of the Activator unit into the Base container.
2. Ensure as much material as possible is drained from the Activator container into the Base container.
3. Mix the 2 components together using the spatula provided.
4. Ensure the product is streak free and a consistent colour before applying to the repair surface.

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

Application

1. Use a short bristle brush to apply the mixed material, with an approximate bristle length of 2cm.
2. Apply the coating at a wet film thickness range of 200-300 microns (8-12mil).
3. Special attention should be paid to detailed areas such as edges, corners and welds where brush application by stippling may be required.
4. Allow the 1st coat of material to cure for approximately 2 hours at 20°C (68°F).
5. Once the 1st coat has cured hard enough apply a 2nd coat of material at a target thickness of 200-300 microns (8-12mil).

Coverage Rates

1kg (2.2lb) of fully mixed product will give the following coverage rates –

3.235m² at 200 microns	34.77ft² at 8mil
2.188m² at 300 microns	23.52ft² at 12mil

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

Resimac Ltd, Unit B, Park Barn Estate, Station Road, Topcliffe, Thirsk, YO7 3SE, United Kingdom
Tel: +44 1845 577498 Email: info@resimac.co.uk Web: www.resimacsolutions.com

Cure Times

At 20°C (68F°) 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	20mins
Minimum overcoating time	2 hours
Maximum overcoating time	6 hours
Full cure	2 days

For Optimum Performance

After an initial curing period of at least 4 hours at 20°C (68F°), raising the cure temperature progressively to 60 - 100°C (140-212F°) for up to 8 hours will result in improved mechanical, thermal and chemical resistance properties

Pack Sizes

This product is available in the following pack sizes –
1kg (2.2lb), 3kg (6.6lb)

Colour

Mixed material - Light grey, Red, Blue
Base component – Light grey, Red, Blue
Activator component –Straw coloured liquid

Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry, approximately 2 hours at 20°C (68°F).
Maximum - the over-coating time should not exceed 6 hours.
Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.

Storage Life

5 years if unopened and store in normal dry conditions (15-30°C/ 60-86°F)

Other Technical Documents

Quick Application Guide	-	Hand application
Safety Data Sheets	-	Base & Activator components
Product Specification Sheet	-	Technical Performance Information

Health and Safety

Please ensure good practice is observed at all times. Protective gloves, goggles & a disposable coverall must be worn during the mixing and application of this product. Before mixing and applying the material ensure you have read the fully detailed Safety Data Sheet.

Legal Notice:

The data contained within this Technical Data Sheet 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 if the product is suitable for use. Resimac accepts no liability arising out of the use of this information or the product described herein.