

RESIFLEX 401 GP 60 PUTTY – Fast Curing Elastomeric Rubber Repair Paste

Resiflex 401 GP 60 Putty 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 & Natural rubber.

- Fast curing
- Solvent free
- Flexible
- Simple and easy to use

Typical Applications

Conveyor belts Gasket sealing Lining of process equipment

Surface Preparation

Metallic Substrates – Mechanical abrasion

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded using handheld grinders to **ISO 8501/4 ST3 (SSPC SP3 ST3)**.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.

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.

Concrete

1. If the concrete surface is contaminated, pressure wash using clean water.
2. Once the concrete is dry, lightly abrasive blast or scarify taking care not to expose the aggregate.

Rubber (Natural, Neoprene and Nitrile)

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. Rubber substrates must be abraded with mechanical or hand tools capable of creating a rough, furry finish. Depending on the tools used and substrate type/hardness, different speeds or abrasive heads may be required.

Once all surfaces, metallic, rubber or concrete, have been prepared, apply 402 Multi surface primer to all surfaces using a brush. Apply the primer as liberally as possible (avoid ponding) to the surface and leave to cure for a minimum of 20 minutes and no longer than 4 hours at 68°F.

Mixing and Application

Prior to mixing, please ensure the following:

1. The ambient & surface temperature are above 50°F
2. The ambient and surface temperature are not less than 6°F above the dew point.

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

1. Resiflex 401 GP 60 Putty is supplied in a twin compartment (butterfly) bag with the base and activator components already pre-measured.
2. Remove the bag from the outer foil container and where possible, warm to around 68°F to ease mixing.
3. Remove the plastic divider, thoroughly and vigorously mix the 2 components by hand until homogeneous.
4. Cut the end of the foil bag and dispense onto a clean plastic mixing board, check for streaks and further mix with a plastic spatula where appropriate.
5. Transfer the mixed material onto the correctly prepared substrate and smooth with the supplied plastic applicator.
6. If required, encapsulate a layer of 807/808 reinforcing tape to create a strengthened laminate system.





Coverage Rates

500g (475ml) of fully mixed product will give the following coverage rates –

5.11ft² at 39mils

2.48ft² at 78mils

1.72ft² at 117mils

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

Cure Times

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:

	68°F	86°F
Usable Life	4-5minutes	2.5 minutes
Touch dry	30 minutes	15 minutes
Light loading	1 hour	30 minutes
Full loading	4 hours	2 hours
Water immersion	3 days	36 hours
Chemical contact	7 days	3.5 days

Pack Sizes and Color

This product is available in the following pack sizes –

500gm (475ml) sachet

Color – Black

Over-coating times

Minimum - the material can be over-coated as soon as it is touch dry, approximately 1 hour at 68°F.

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

Storage Life

1 year if unopened and store in normal dry conditions (59°F-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.

