

RESIFLEX 401 GP 60 Putty

Resiflex 401 GP 60 Putty is a two component solvent free urethane repair compound. The product has been specifically developed for repairs to rubber linings, gaskets, conveyor belts and moulding applications.

Typical Applications

Suitable for emergency repairs or part of planned maintenance to equipment such as line process equipment to dampen noise, repairs to conveyor belts, gasket sealing, lining of process equipment such as pumps, valves, chutes and hoppers.

Surface Preparation

All existing dirt, oil and grease should be removed from the repair surface using an appropriate solvent cleaner such as MEK (Methyl Ethyl Ketone).

Rubber Surfaces: Any frayed or fragmented rubber should be cut away to provide a sound repair area. Edges of repair areas of belts, hoses etc should be undercut. The surface of the rubber should then be roughened using a handheld mechanical grinder with a coarse pad or MBX Bristle Blaster.

Metal Surfaces: the metal surface must be abraded using a handheld mechanical grinder with a coarse pad. A cross hatch pattern must be made on the metallic surface. Make sure the surface is etched and not polished. Once all surfaces have been abraded they must be cleaned with an appropriate solvent cleaner such as MEK (Methyl Ethyl Ketone).

Priming of metal and rubber surfaces: Apply by brush the fast curing **Resiflex 402 Multi-surface Primer** to the repair surface and leave for a minimum 20 minutes at 20°C (68°F).

Mixing and Application

Do not apply when the ambient or substrate temperature is below 5°C or the relative humidity is above 90%.

Resiflex 401 GP 60 Putty is supplied in a 420gm cartridge with the base and activator components already pre-measured. Heat the cartridge to 20-25°C prior to use. Cut off the end of the mixing nozzle to ensure you have the largest dispensing capacity. Unscrew the cap on the end of the 420gm cartridge and place in the cartridge gun. Attach the mixing nozzle. Dispense the mixed product onto the repair surface and smooth out the repair using the applicator tool provided.

If required, Resiflex 401 GP 60 Putty can be used in conjunction with 808 reinforcement tape to create a multi layered reinforcement system.

If it is not practicable to heat the cartridge to 20-25°C, then do not use the mixing nozzle. Unscrew the cap on the end of the 420gm cartridge and place in the cartridge gun. Dispense the base and activator components onto a clean mixing surface. Using the green spatula provided, mix the base and activator components until you have a uniform mixture. Then apply the mixed material to the primed repair surface.

Coverage Rates

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 repaired.

Cure Times

At 20°C 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	4-5mins
Touch Dry	45mins
Machining	1 hour
Hard Dry	6 hours

Pack Sizes

This product is available in the following pack sizes –
420gm (400ml) cartridge

Colour

Mixed material - Black
Base component – Black
Activator component – Opaque

Over-coating times

Minimum - the applied material can be over-coated as soon as it is touch dry.
Maximum - the over-coating time should not exceed 3 hours.

Storage Life

1 year if unopened and store in normal dry conditions (15-30°C)

Technical data and Performance

Tensile Strength ASTM D412	70 kg/cm ² (1000psi)
Tear Strength ASTM D624	36kg/cm ² (200psi)
Elongation ASTM D412	400%
Shore A hardness ASTM D2240	64
Peel Adhesion ASTM D903	9kg/ cm ² (Cohesive failure of 401 GP 60 Putty)
Maximum Operating Temps	Dry 120°C Wet intermittent 80°C Immersion 50°C
Dielectric Strength ASTM D149	16KV/mm

Health and Safety

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

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