



PES 201 Ceramic Repair Paste – solvent free abrasion resistant epoxy with hardened ceramic fillers

PES 201 Ceramic Repair Paste is a two-component solvent free epoxy repair compound containing hardened ceramic fillers designed to fill surface erosion & corrosion on metallic surfaces.

- Apply to abrasive blast cleaned surfaces
- Excellent abrasion and wear resistance
- Apply at thicknesses up to 1"

Typical Applications

worn impellers	damaged valves	separator housings
damaged pump casings	eroded pipe work	propellers
bow thrusters	rudders	corroded water boxes
end plates and tube sheets.		

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 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

Prior to mixing please ensure the following:

1. The base component is at a temperature between 60-77F°.
2. The ambient & surface temperature is above 41F°.

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

If part mixing a unit please follow the instructions below:

1. Using the spatula provided place 3 equal measures from the base unit onto the mixing board provided.
2. Clean the spatula thoroughly.
3. The take 1 equal measure from the activator unit and place alongside the base measures.
4. Mix the 2 components together until you have a streak free mix (mid grey) on the mixing board.
5. Ensure there is no unmixed material on the spatula or mixing board.

If mixing a complete unit of material 2.2 lb/6.6 lb (1kg/3kg) please follow the instructions below:

1. Dispense as much of the base and activator units onto the mixing board provided.
2. Mix the 2 components together until you have a streak free mix (mid grey) on the mixing board.
3. Ensure there is no unmixed material on the spatula or mixing board.

From the commencement of mixing, the material should be used within 30 minutes at 68F°.

Application

1. Using a spatula or applicator tool, apply the material to the prepared surface.
2. Ensure the product is pressed into any holes, scars or cracks.
3. Once the repair has been completed smooth off any imperfections using a gloved hand.



Technical Data Sheet

Coverage Rates

2.2lb (1kg) of fully mixed product will give the following coverage rates –
4.3ft² at 40mil
2.2ft² at 80mil
1.45ft² at 1/8"

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 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	30mins
Minimum overcoating time	2 hours
Maximum overcoating time	6 hours
Full cure	3 days

For Optimum Performance

After an initial curing period of at least 4 hours at 68°F, raising the cure temperature progressively to 140-212°F 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 –
2.2lb (1kg), 4.4 lb (2kg), 6.6lb (3kg)

Colour

Mixed material - Dark Grey
Base component – dark grey
Activator component – light grey

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 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 (60-86°F)

Health and Safety

Please ensure good practice is always observed. 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. PES accepts no liability arising out of the use of this information or the product described herein.