

12kg PART NUMBER 7459-9837

### TECHINCAL DATA

Components	Two Parts – Resin & Hardener
Appearance (Resin)	Pale Grey / White
Appearance (Hardener)	Black
Kit sizes	12kg

### DESCRIPTION:

**NORDBAK® High Temperature Pneu-Wear** is a trowelable wear-resistant coating designed for pneumatic applications for fine particle abrasion. Contains miniature irregular ceramic beads to provide high efficiency wear protection.

FEATURE	BENEFITS
Fine particle abrasion resistance	Excellent for repair of pneumatic conveying systems.
Ceramic filled	Hard, durable beads provide maximum resistance to wear.
Versatile	No special tools or equipment required.
Fast Curing	Full curing requires only 8 hours.
Easy to use	Pre-measured kits and directions that assure satisfactory results.
Operational Temperature	250°C continuous for pneumatic flow. Immersion temperature dependent on contents

### SURFACE PREPARATION

A properly prepared surface is important to the finished result and lasting durability of **NORDBAK® High Temperature Pneu-Wear**.

- Make certain surface is clean and dry with all loose contaminants removed that would affect positive adhesion. The co-polymer will not adhere to a surface that is coated with grease, oil, dirt, etc as these materials have already filled the pores of the substrate and will prevent the co-polymer from coming in contact with the surface of the substrate.
- Surface to be coated should be cleaned down to the white, rough metal. The general method for cleaning oily contaminants from the surface of the substrate is to remove excess oily material with a clean cloth. **DO NOT USE solvents or degreaser.**
- Then roughen the surface by mechanical means (sand blast, surface grinder, etc.) Just prior to coating with **NORDBAK® High Temperature Pneu-Wear**, torch the surface to drive off and dry up remaining moisture that has collected on the surface of the substrate.

### MIXING:

Read the label directions thoroughly before you begin. The mixing ratio for **Pneu-Wear** products is four parts resin to one part hardener by volume and by weight. To achieve maximum efficiency of the product, conform closely to these measurements. You will notice that both the resin and hardener of **Pneu-Wear** contain irregular beads: this is to provide a maximum density of ceramic in the final mix. When the two components are mixed together, a different shade of grey is obtained. This is a visual indicator that the material has been thoroughly mixed. Any differences in colours from kit to kit have no bearing on the final properties. Mix only enough material that can be used in 20 minutes.

### NOTE:

When the temperature of the material and the surface to be coated is 15°C or less, preheat resin in hot water until the material is 32 - 38°C. The resin will become semi-fluid in this temperature range.

**(CAUTION: DO NOT PREHEAT HARDENER AS THIS WILL GREATLY REDUCE WORKING TIME).**

### APPLICATION

- After the surface has been cleaned and roughened, warm the surface to 38°C, do not exceed 50°C. This procedure allows the co-polymer binder to liquefy and flow freely into the pores of the material providing a positive gripping action.
- **NORDBAK® High Temperature Pneu-Wear** should be applied to at least 6mm minimum thickness for best results.
- **NORDBAK® High Temperature Pneu-Wear** will bond securely to itself, however, be certain surface is clean, dry and in sound condition with no loose or flaky contaminants present.
- If you are renewing a vertical or smooth surface, it is recommended that you rub or “wet” a thin layer of mixture on the area before applying the full coat. This ensures adhesion. (In soldering, this is called “sweating”).
- Working life of **NORDBAK® High Temperature Pneu-Wear** is approximately 30 - 40 minutes at room temperature. This is ample time for large applications and hard to reach areas.

### COVERAGE

12kg kits of **NORDBAK® High Temperature Pneu-Wear** will coat 0,90m<sup>2</sup> at 6mm thick.

### CURE TIME

Cure time will depend on ambient temperatures. At 21°C, curing will occur in 4 to 6 hours. The lower the

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temperature, the longer the cure. After the compound has hardened, reheat the surface to about 65°C for 30 minutes to ensure full cure and positive binding.

**FOR SERVICE UP TO 150°C:** Allow at least 8 hours of cure at 21°C or higher. Then preheat for at least 3 hours at peak operating temperature before applying wear load.

**FOR SERVICE ABOVE 150°C:** Allow 8 hours cure at 21°C or higher. Then preheat for at least 3 hours at 150°C, followed by three hours at 205°C or peak operating temperature.

If preheating procedure is impossible before putting the **High Temperature Pneu-Wear** into service, the following method is recommended:

- Preheat the resin and substrate to at least 38°C. Mix and apply in the manner recommended.
- Once gelled, heat the applied **High Temperature Pneu-Wear** by waving a gas torch over the surface for at least one hour at 38-50°C.
- Using temperature crayons as indicators, raise the temperature of the substrate and **High Temperature Pneu-Wear** to a minimum of 150°C, but not over 260°C, and maintain the temperature in this range for at least two hours. The Pneu-Wear will then have cured sufficiently to begin service. It will continue to cure during normal operating temperatures until a full cure is obtained.

**DO NOT MIX RESIN AND HARDENER UNTIL READY TO COMMENCE.**

#### PROTECTION:

- All work is to be done in a well-ventilated area.
- Overalls and eye protection required.
- Refer to Material Safety Data Sheet.

#### STORAGE:

Store indoors on pallets at temperatures between 10°C and 35°C. Keep container tightly closed and away from acids and oxidizers. If product is removed from container do not return it to original container as contamination may have occurred.

#### DISCLAIMER:

The information provided in this data sheet including the recommendations for use and application of this product are based on our knowledge and practical experience and laboratory tests of the product as at the date hereof. This data sheet shall be used as a guide to the user's application.

This product has been designed for specific applications based on normal working and operating conditions, and although it may be used in different applications and working conditions such instances are beyond our control. Therefore Nordbak shall not be liable for the suitability/merchantability of our product in your application unless we have specifically advised so in writing. Accordingly, we advise that you conduct your own investigations to confirm the suitability of our product, as it ultimately remains the user's responsibility to protect property and persons against hazards emanating from the handling and use thereof. Accordingly, any civil liability as a result of damages, injury, or death, in respect of the information in this data sheet, or any other written or oral recommendation(s) regarding the suitability of this product, are hereby excluded. Furthermore Nordbak shall not be liable under any circumstances for any consequential or incidental damages of any kind, including but not limited to loss of profits.

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