



TECHNICAL DATA SHEET

Flexibilised Ceramic Carbide Compound

ThistleBond 'Flexibilised Ceramic Carbide Compound' is a high performance solvent free flexible poly ceramic repair compound designed for the rebuilding and resurfacing of equipment operating in fluid flow environments.

ThistleBond 'Flexibilised Ceramic Carbide Compound' is based on a complex blend of high molecular weight and urethane polymers blended with inert pigments and silicas reacted with an amine accelerated isocyanate resin which produces a system with the optimum physical and mechanical strength.

ThistleBond 'Flexibilised Ceramic Carbide Compound' offers a resilient high performance system with outstanding protection against impingement, entrainment, cavitation and erosion corrosion and is ideal for resurfacing, propellers, kort nozzles, guide vanes and tube sheets etc.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

All dirt, and contamination should be removed, then surfaces should be degreased using **ThistleBond 'Cleaner'**. Surfaces should now be abrasive blasted to Sa2½ BS7079: PART A1 1989, or equivalent with a medium to coarse profile.

Equipment that has been salt impregnated should be heated to sweat out salt contamination then the surface reblasted. This process should be repeated until all salt contamination is eliminated.

All residual abrasive dust should be blown clear of the prepared surface. Surfaces which are not required to bond to the **ThistleBond 'Flexibilised Ceramic Carbide Compound'** should be treated with **ThistleBond 'Release Agent'**.

MIXING

ThistleBond 'Flexibilised Ceramic Carbide Compound' is a two component solvent free material comprising resin and hardener components which must be mixed together prior to use.

Add all the contents of the hardener container into the resin container and mix thoroughly, alternatively measure three volumes of resin and one volume of hardener into a clean container and mix thoroughly.

The two components initially are fluid, but on mixing form a paste material. To ensure thorough mixing, the paste should be transferred to a mixing board and further mixing carried out to produce a streak free material.

The mixed material should be used within 20 minutes of mixing at 20°C (68°F). This time will be reduced at higher temperatures and extended at lower temperatures.

APPLICATION

Application should be carried out as soon as possible after the surface preparation is complete, and certainly within 4 hours otherwise flash blasting will be necessary before application.

The mixed material should be applied by spatula, pressing the material into the surface taking care not to trap air in deep cavities.

All equipment must be cleaned IMMEDIATELY after use with **ThistleBond 'Cleaner'**.

Volume Capacity

835cc (53cu ins) per kilo

PHYSICAL CONSTANTS

Mixing Ratio	Resin	Hardener	
	3	1	By Volume
	3	1	By Weight

Appearance	Resin	Light Grey Thixotropic Liquid
	Hardener	Brown Liquid

Drying & Cure times at

20°C (68°F)	Usable Life	20 minutes
	Touch Dry	2 hours
	Hard Dry	4 hours
	Full Cure	7 days

Volume Solids	100%
----------------------	------

V.O.C.	Nil
---------------	-----

Shelf Life	Use within 5 years of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F).
-------------------	---

Operating Temperature

	Maximum	Continuous
Dry Heat	150°C (300°F)	80°C (176°F)
Wet Heat	80°C (175°F)	50°C (122°F)

PHYSICAL PROPERTIES

Tensile Strength ASTM D412	200 kg/cm ² (2825 psi)
Abrasion Resistance ASTM D4060	0.08 ml loss per 1000 cycles 1 kg load CS 17 Wheel
Corrosion Resistance ASTM B117	Unaffected after 5000 hours exposure
Impact Resistance ASTM D256	20 Joules (175 ins lbs)
Flexibility ASTM D522-4	30%

FOR FURTHER INFORMATION PLEASE CONTACT

HEALTH AND SAFETY

As long as normal good practice is observed **ThistleBond 'Flexibilised Ceramic Carbide Compound'** can be safely used.

Protective gloves should be worn during use.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 1kg packs.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.



www.thistlebond.com

ThistleBond Division of E. Wood Ltd.

Standard Way, Northallerton, N. Yorks. U.K. DL6 2XA

Tel: +44(0)1609 780170 Fax: +44(0)1609 780438 & 777905

E Mail: info@thistlebond.com