

KALFLIX-HT HIGH TEMPERATURE ADHESIVE

KALFLIX-HT is a 100% solids epoxy specifically formulated for high temperature applications. KALFLIX-HT is a general purpose adhesive formulated specifically for the applications of porous materials to clean substrates. Typical applications are for bonding clean metals to each other, or wood, fibreglass, concrete, ceramic tile, pump casings, chutes, etc. The substrates should be sandblasted and washed with KALFLIX solvent before applying KALFLIX-HT.

APPLICATIONS INSTRUCTIONS

1. Prepare surface to be bonded by sandblasting or scarifying to eliminate all surface scale, rust and unclean matter. Wipe with a clean cloth, soaked with solvent. Do not apply adhesive onto substrate that is below 50°F.
2. Mix 1 part hardener to 1 part resin on a separate board until uniform in color.
3. Apply mix components to surface of tile and surface to be bonded. Press tile onto substrate to evacuate air.
4. Do not move tile after 90 minutes or after initial cure.

TYPICAL PROPERTIES OF KALFLIX-HT HIGH TEMPERATURE ADHESIVE

-Tensile Strength ASTM D-695	6,000 psi
-Compressive Strength ASTM D-695	14,000 psi
-Impact Strength	.21ft. lbs. / in. notch
-Operating Temperature with ½" Tile Applied to Metal Substrate	350°F-400°F
-Mix Ratio	1-1 by Volume
-Mixed Color	Manila (off white)
-Consistency	Thick Creamy Paste
-Cure Room Temperature	4-5 Hours
-Weight per Kit (net)	20 lbs. per kit
-Coverage	25 Sq.Ft. at ¼" thick

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KALFLIX-HT HIGH TEMPERATURE ADHESIVE WEARING COMPOUND

KALFLIX-HT wearing compound is a ceramic filled, non-sag, epoxy wearing compound designed for ambient and high temperature applications. KALFLIX-HT WC exhibits excellent adhesion to metals, fibreglass, concrete, wood and ceramic tiles. This 100% solids, abrasion resistant compound is recommended for repairing and reshaping pipe elbows, chutes, feeders, pump casings, cyclones, fans, housings, crushers, slurry pumps and other equipment exposed to sliding, wear, abrasion and impact.

KALFLIX-HT WC can be used to fill in irregular shaped surfaces and to repair lose or broken ceramic tile. This wearing compound can be featheredged to contoured surfaced such as chippers, screening decks and separators.

KALFLIX-HT WC can be used in temperature environments of 400°F intermittently. This product also exhibits good chemical resistance and good thermal shock properties.

APPLICATIONS INSTRUCTIONS

1. Prepare surface to be bonded by sandblasting or scarifying to eliminate all surface scale, rust and unclean matter that may affect the adhesion of the compound. A course wheel or disc can be used to remove rough, uneven areas of previously applied adhesive or tile. Wipe surface with a clean cloth soaked with KALFLIX-HT solvent.
2. Empty contents of Part A (resin) into 2 gallon pail containing Part B (hardener). Use power drill mixer to blend the components until uniform in color. Scrape sides and bottom of pail to insure proper ratio. For lesser quantities: Mix 1 Part A and 1 Part B on separate board with trowel until uniform in color.
3. Maintain component between 50° and 90° F. Apply a thin layer of mixed KALFLIX-HT WC and rub into the surface. Proceed to build up the layers of ¼" – ½" to desired thickness.
4. The cure can be accelerated by waving a torch over the surface for about thirty minutes or heat Part A (resin) to 100°F before mixing. This procedure will shorten the pot life of the material due to the temperature sensitivity of epoxy resins.
5. A smooth, slick surface can be accomplished by dipping a trowel in the KALFLIX-HT solvent then smoothing over already applied, uncured KALFLIX-HT WC. Clean tools with KALFLIX-HT solvent and clean clothes or skin with warm, soapy water.
6. Do not apply material below 50° F unless surface and material is maintained above 80° F to insure proper adhesion.

TYPICAL PROPERTIES OF KALFLIX-HT WC HIGH TEMPERATURE WEARING COMPOUND

-Tensile Strength ASTM D-638	6,000 psi
-Compressive Strength ASTM D-695	14,000 psi
-Impact Strength	21ft. lbs. / in. notch
-Operating Temperature with ½” KALFLIX-HT WC applied to Metal Substrate	400°F-450°F
-Mix Ratio	1-1 by Volume
-Mixed Color	Manila (off white)
-Consistency	non-sag
-Cure Room Temperature	4-5 Hours @ 75°F
-Weight per Kit (net)	30 lbs. per kit
-Coverage	12 Sq.Ft. at ¼” thick

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