

Wear Compound– Large Bead – K-050

Description:	Wear Compound-Large Bead is a two-component, large ceramic bead filled epoxy system specifically designed to resist abrasive wear and corrosion.	
Ordering Information:	K-050-24 (24lb Unit)	
Product Advantages:	Wear Compound-Large Bead is specifically designed to resist abrasive wear and corrosion in pump casings, slurry lines, pipe elbows, pneumatic transport systems, chutes, cyclones, fans, coal breakers, pulverizers, coal heads, and other high wear areas.	
Application Guideline:	Maximum Service Temp 250°F Working Time 30 minutes Functional Cure 7 Hours Mix Ratio 2/1 by Volume (2/1 by weight)	
Coverage:	Approximate coverage per pound is 25 in. ² (161 cm ²) at 0.5 in. (1.27 cm) thickness. The working time of Wear Compound-Large Bead (the time you have to apply the material before it sets) will vary according to the air temperature, the temperature of the material itself, and the surface to which is applied.	
Physical Properties:		<u>Tests Conducted</u>
	Compressive Strength	12,500 psi ASTM D 695
	Tensile Strength	4,200 psi ASTM D 638
	Flexural Strength	7,700 psi ASTM D 790
	Tensile Shear Strength	1,150 psi ASTM D 1002
	Hardness, Shore D	90 ASTM D 2240
Surface Preparation:	The surface to be coated must be free of all rust, scale, dirt, dust, grease, oil, release agents, or other contaminants. Preheat the surface to 100 °F or 37.7 °C (this will drive off any moisture). For smoother surfaces or where vibration is a concern, tack weld an open mesh screen or expanded metal approximately 1/16 to 1/8 in. (1.59 - 3.18 mm) above the surface. Chip off weld slag.	
Measuring:	Wear Compound-Ceramic kits are supplied with the resin and hardener pre-measured in the correct mixing ratio. It is best to empty the entire contents of both the resin and hardener containers on a mixing board to insure the proper mixing ratio is maintained. If less than a full kit is required for the job, both the resin and the hardener must be accurately measured. DO NOT ATTEMPT TO "EYEBALL" THE AMOUNT NEEDED. If the kit is colder than 60 °F (15.6 °C), preheat both the resin and hardener by placing the cans in a hot water bath. The water temperature should not exceed 90 °F (32.2 °C) as high heat will reduce the working time of the mix. Heating of the cans with a torch is NOT recommended.	

Mixing:

After the components have been measured on a clean, flat mixing board, mix thoroughly with a trowel until a uniform color is achieved, (usually about 2 minutes).

For mixing the largest kits, a mixing paddle and heavy duty, slow speed drill may be used. However, the mechanical energy put into the mix by the drill may result in a shortened working time and a reduction of the non-sag characteristics of the Wear Compound-Large Bead.

Remember that incomplete mixing will result in poor curing, loss of physical properties, and "soft spots".

Application:

Initially apply a thin, wet coat to the surface to create tack. Build upon the tack coat to the desired thickness. If a screen or expanded metal is used for reinforcement, apply an excess of material at one end of the area and push it through the screen. Push the material so that it "wets" the surface below the screen and moves in a continuous mass toward the other end of the area.

Curing Procedures:

Cure at least 7 hours at 77 °F (25 °C) before returning equipment to service. For maximum physical properties cure 4 hours at 200 °F (93.3 °C) after curing 2 hours at 72 °F (22 °C).

Curing procedure may be shortened by applying heat with a heat gun or heat lamp. Do not exceed 120 °F (48.9 °C).

SAFETY PRECAUTIONS

Avoid breathing of vapors. Forced local exhaust is recommended to effectively minimize exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (such as heated polymers, sanding) may cause high vapor concentrations. **DO NOT WELD ON, BURN OR TORCH ON OR NEAR, ANY EPOXY MATERIAL. HAZARDOUS VAPOR IS RELEASED WHEN AN EPOXY IS BURNED.**

Avoid skin or eye contact. Wash skin with soap and water if contact occurs. If eye contact occurs flush with water for 15 minutes and obtain medical attention. Read and understand all cautions on can labels and safety data sheets before using this material.

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