



Cerami-Tech HTX

Data Sheet and Application Guide

Product Description

Thortex Cerami-Tech HTX has been specifically developed as a 100% solids epoxy coating for resurfacing and lining equipment operating at high temperatures.

Product Features

- Combines good application characteristics with good corrosion and temperature resistance.
- Designed for application by brush or plural feed hot spray.
- Provides a high build protective system capable of resisting wet heat up to 150°C (300°F).
- Primarily designed for resurfacing and lining metal components.
- Excellent adhesion to correctly prepared metal surfaces.

Surface Preparation

All dirt and loose material should be scraped away. Oil and grease should be removed with solvent-based cleaner. Surfaces should then be abrasive blast cleaned to a minimum NACE No. 2/SSPC-SP10 Near White Metal, ISO 8501:1, Grade SA2½. or equivalent with a minimum blast profile of 75 microns (3 mil). All loose abrasive dust and debris must be blown clear or vacuum cleaned away.

Existing steel surfaces which have corroded in a chemical environment may be contaminated by soluble iron salts within corrosion pits. To prepare these surfaces it is recommended that one of the following treatments be carried out prior to final dry abrasive blasting to the specified standard.

- a) Blasting with a mixture of clean water and abrasive.
- b) Initial dry blast cleaning to remove corrosion and surface coatings followed by high pressure clean water jetting (minimum 1000 psi/66 bar).

Product Mixing

Thortex Cerami-Tech HTX is a two component product supplied as a Base component and an Activator component which must be mixed together immediately prior to use.

Stir the contents of the Base component, continue stirring and gradually add the total contents of the Activator container, stir the combined mix until completely homogeneous. The mixed material must be used within 45 minutes of mixing at 20°C (68°F). This time will be reduced at higher temperatures and extended at lower temperatures.

Where additional applications are required to build up thickness, the additional application must be carried out within the touch dry time of the previous application, otherwise the surface of the previous application must be abraded.

Recommended Film Thickness

Wet 750 microns (30 mils)
Dry 750 microns (30 mils)

Properties

Property	Value
Color	Light Grey and Off White
Ratio	4:1 By volume 5:1 By weight
Drying & Cure times at 20°C (68°F)	
Useable life	45 mins
Touch Dry	6 hours
Minimum Overcoating	6 hours
Maximum Overcoating	24 hours
Full Cure	7 days
Volume Solids	100%
Film Thickness (Typical)	750 microns (30 mils)
Coverage Rate	1.00 m ² /kilo at 750 microns (10.75 ft ² /kilo at 30 mils)
Tensile Shear Adhesion	19.5 Mpa (2800 psi)
Compressive Strength	142 Mpa (20730 psi post cured)
Flexural Strength	67 Mpa (9700 psi post cured)
Abrasion Resistance	0.086 mg loss per 1000 cycles, 1 kg load, CS17 Wheel (ASTM D4060)
Heat Distortion Temperature	149°C (295°F) Post Cured at 120°C for 24 hours
Tensile Shear Adhesion	19.30 Mpa (2800 psi)

Packaging and Storage

Supplied in 1 kilo units.

Use within 5 years of purchase. Store in original sealed containers at temperatures between 5°C (41°F) and 30°C (86°F).

Handling and Safety Precautions

Read all Health Hazard, Precautionary and First Aid, Material Safety Data Sheet, and/or product label prior to handling or use.

Ordering Information/Customer Service

For ordering technical or product information, or a copy of the Material Safety Data Sheet, please contact us:

Phone: 610-831-0222

Fax: 610-831-1910

Email: info@thortex.com

Important Notice

All statements, technical information, and recommendations related to Thortex's products are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using this product, you must evaluate it and determine if it is suitable for your intended application. You assume all risks and liability associated with such use. Any statements related to the product which are not contained in Thortex's current publications, or any contrary statements contained on your purchase order shall have no force or effect unless expressly agreed upon, in writing, by an authorized officer of Thortex.

Warranty; Limited Remedy; Limited Liability.

Because conditions of product use are outside of our control and vary widely, the following is made in lieu of all express or implied warranties: this product will conform to Thortex's published product specifications and be free from defects in material and manufacture on the date of your purchase. **THORTEX MAKES NO OTHER WARRANTIES INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** If this product is defective upon your receipt, your exclusive remedy shall be, at Thortex's option, to replace the Thortex product or refund the purchase price of the Thortex product. **Except where prohibited by law, Thortex will not be liable for any indirect, special, incidental or consequential loss or damage arising from this Thortex product, regardless of the legal theory asserted.**



Thortex America, Inc.
12 Iron Bridge Drive • Collegeville, PA 19426
Telephone: 610-831-0222
Website: www.thortex.com