



Permafex-60SLF CONVEYOR BELT REPAIR SYSTEM

Permafex is a self-leveling, room-temperature fast curing 65A Polyurethane patch material designed to get material processors back-up and running quickly with long lasting repairs for conveyor belting and supporting parts. Packaged for easy on ratio mixing using our dual cartridge 400ml and 1500ml dispensing systems. With surface preparation and a primer, this material seamlessly adheres to standard conveyor belt rubber, polyurethane, and PVC belting.



STARK Vulcanising Products B.V
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8912 AP, Leeuwarden
The Netherlands

PROPERTIES

Prepolymer: MDI Polyether

Hardness Shore A: 65+/-5

Solids: 100%

VOC's: Zero

Mix ratio: 1A:1B

Colour: Black, others available

Flash Point: None

Shelf Life: 3 years unopened

Storage: 15°C-30°C (60°F-86°F) dry, away from sunlight

Tensile strength ASTM D412: 9.31 MPa (1350 psi)

Elongation ASTM D412: 525%

Tear Strength ASTM D624 Die C: 36.78 kN/m (210lbf-in)

Taber Abrader ASTM D4060-19 H18, 1kg, 400cy: 121mg loss

FDA Compliant: Dry bulk food

Operating Temperatures: -56°C (-70°F) to 93°C (200°F)

Chemical Resistance: usually pH 3 - 11

Coverage: 34sqm @ 25micron/kg (166sqft @ .001"/lb)

Per Unit: 200 x 200 cartridge 0.12sqm @ 3mm (1.25sqft @ 1/8")
750 x 750 cartridge 0.44sqm @ 3mm (4.7sqft @ 1/8")

APPLICATION DATA (23°C / 73°F)

Precondition material: > 15°C (60°F)

Working Life: 30 seconds

Buff to level: After 30 minutes

Functional Cure: After 1 hour

Ultimate Cure: 24 hours

Overcoat: After de-gloss/sanding

PRIMER : SUBSTRATE

PF-8400 (1K) : Rubber, PVC belt, Polyurethane

PRODUCT CODE : DUAL CARTRIDGE SIZE

Permafex 200 x 200ml (424g), requires manual dispenser tool
Permafex 750 x 750ml (1590g), requires powered dispenser tool
Includes one mixing nozzle.

SAFETY

FOR INDUSTRIAL USE ONLY. See the **STARK -60SLF** product SDS. Strict adherence to regional health and safety regulations must be practiced.

APPLICATION CONDITIONS

Ambient and surface temperatures should be similar and between 10°C to 45°C (50°F to 113°F). Ensure temperatures are 3°C (5°F) above the current dew point with relative humidity under 85%. It is possible to apply outside this temperature range but expect pot-life and cure times to vary considerably. During colder temperatures Pt A (resin) may become solid or present a waxy appearance. Before mixing, precondition Pt A (resin) back to a clear liquid above 15°C (60°F). Always protect the surface from contaminants and direct sunlight.



The directions for the use of our products are based upon tests believed to be reliable but no warranty is given. Since conditions for the use of this product are beyond the sellers control, all risks are assumed by the user. Please contact your local agent or call STARK vulcanising products for further assistance.

CONVEYOR BELT SURFACE REPAIR INSTRUCTIONS

1. The performance of this product will depend upon the degree of surface preparation.
2. Clean the repair area using a lint free cloth and a suitable solvent like Ethyl Acetate to remove contaminants.
3. Mechanically roughen damaged areas using a slow speed rotary tool such as a stiff wire brush or abrasive disk 24 to 36 grit. Creating 45° beveled edges and allowing 2" beyond repair. Sweep debris and wipe clean with solvent.
4. Shake primer bottle to mix contents, then use a brush, roller, or sprayer to apply one liberal coat to the prepared surface. Allow to dry for 20 minutes or until solvent has fully evaporated. Tenting and warming belting and repair material is an option at low temperatures.
5. Remove the nut and seal, install the mixing nozzle using the nut. Do not cut the mixing nozzle tip.
6. Install cartridge into dispensing gun. Dispose initial material (approx. length of mixer) to ensure uniform mixing.
7. Extrude material from a single starting point. When possible keep tip placement directly into the liquid material to avoid air entrapment. Finish filling repair with a steady output without stopping or until the cartridge is empty. Cartridges that are not fully depleted can be re-sealed and used again with a new mixing nozzle.
8. If necessary, buffing to level the repair area to match the belt cover can be done 30 minutes from application and accomplished using a slow speed sander. For surface repairs, back to service is possible in under 1 hours.