

## PRODUCT DATA SHEET

**8510**

JAN 2013

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY REBUILDING COMPOUND

**DESCRIPTION AND RECOMMENDED USES:** 8510 is a solvent free, unique blend of ceramics and special surface toughening agents which make them the most wear resistant products of their kind on the market. 8510 is designed to be applied in one thick coat, up to 60 mils thick. Making it the ideal material to protect areas of fluid flow equipment that are subjected to high wear. Also good chemical resistance. Insulates against Bi-Metallic Corrosion. Excellent resistance to cavitation.

### FOR INDUSTRIAL USE ONLY

### SPECIFICATION DATA

**TEMPERATURE:** Immersion service  
Max. 200°F; Dry to 350°F

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** Paste

**CHEMICAL RESISTANCE:**

Water:  
Alkalies:  
Inorganic Acids:  
Organic Acids:  
Organic Solvents:

**POT LIFE:** 1 hour

**MIX RATIO:** 1:1 by volume (Base:Activator)  
By Mass: 100 gm base: 99 gm Activator

**COLOR:**

**ABRASION:**

**SHELF LIFE:** 5 years at 55-95°F, 13-35°C

**FLEXIBILITY:**

**FLEXURAL STRENGTH:** 4,700 psi  
(ASTM D790/7 days)

**COVERAGE:** 64 SF @ 60 mils

**COMPRESSIVE STRENGTH:** 10,300 psi  
(ASTM D695/7 days)

**WEIGHT PER GALLON:** 12.4 (5.62 KG)

**TENSILE SHEAR:** 3,850 psi  
(ASTM D1002/steel:steel)

**ORDER INFORMATION:** To place orders  
and/or obtain pricing information contact:

**APPLICATIONS:** Slurry pumps, blades, runners,  
gates in Hydro Electric Plants. Large gate valves, tail  
shaft cladding, kort nozzles and bow thrusters.

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# APPLICATION SHEET

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**SEE MATERIAL SAFETY DATA SHEET BEFORE HANDLING THIS PRODUCT**

**SURFACE PREPARATION:** Metal surfaces are to be cleaned and degreased then abrasive blasted with chloride free abrasive. Exterior applications to SSOPC SP-10 Near white finish minimum 3 mil profile. Immersion applications to SSPC SP-5 White metal, 3 to 5 mil profile. Grind flat all burrs, weld seams, radius sharp edges. Fresh blasted surfaces to be rebuilt as quickly as possible to prevent oxidation of the surface and allow time for proper rebuilding of the damaged area.

**MIXING:**

Thoroughly mix Activator into Base with mixing stick scraping sides and bottom of container or mixing board. By Volume 1:1. By Mass 1 part Base to 7/8 part Activator. Or 100 grams Base to 90 grams Activator. Mix thoroughly to produce and even colored , streak-free material.. Mix thoroughly to produce and even colored , streak-free material.

**THINNING:** Never Thin**APPLICATION:**

Use heavy plastic squeegee or putty knife. Work material into profile of substrate to achieve maximum adhesive and to remove any entrapped air. Contour to correct form with putty knife or plastic applicator. If mold or form is used be sure to coat its surface with a release agent to prevent adhesion of the material. Machining is possible using diomand tipped tools only. Grinding is possible only if done within 2 hours of application at 77°F (add 1 hour for each 10°F below 77°F, subtract 1/2 hour for each 10°F above 77°F).

**APPLICATION TEMPERATURE:**

Material: keep between 55 and 95°F (17-35°C). Substrate: keep between 45-105°F (7-40°C). The difference in temperature of the substrate and the material should never exceed 10°F, 5°C. Substrate shall be a minimum of 5°F (3°C) above dew point. Do not apply if relative humidity exceeds 90%. If necessary heat the metal prior to surface preparation using electric heater or heat lamp. Never use gas, oil or kerosene heaters as they will leave a greasy residue on metal surface. For best results keep all material in warm area overnight (75°F+) for ease of mixing. If necessary Base component of material can be heated by microwave for 30-45 seconds for a 1 KG Base unit or by warm water bath. Heat Activator by warm water bath only. If necessary let material cool before application.

**OVERCOAT/CURE TIME:**

Recoat as soon as possible while material is still soft, within 2 hours at 77°F. 25°C. If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. Full cure before immersion 36 hours at 77°F. Force Cure with heat for best performance for 1 hour at 200°F, 93°C, 12 hours at 120°F, 49°C.

**CLEAN UP:** Clean tools immediately after use with Acetone, M.E.K.. Use ARCLEAN or Isopropyl Alcohol in solvent controlled environments.

**WARNING:** Base contains epoxy resin. Activator contains alkaline amines, a strong sensitizer. May cause skin irritation, sensitization or other allergic responses. Use with good ventilation, particularly if heated or sprayed. Prevent all contact with skin or eyes. Wear protective clothing, goggles, gloves or barrier creams. Keep containers closed when not in use. Wash thoroughly after handling. In case of skin contact immediately wash with soap and water. In case of eye contact, flush with water for 15 minutes. If irritation persists seek medical attention.