

Technical Data Sheet

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® KERAPALON HE

Soft rubber lining to protect steel and concrete components On-site rubber lining

Description

KERAPALON HE is a vulcanized soft rubber lining based on chlorosulfonated polyethylene (CSM). Depending on the individual requirements, the layer thickness of the rubber sheet can range from 3 - 5 mm.

Typical uses

KERAPALON HE is employed for the protection of chemically stressed structural components made of steel and/or concrete.

The primary scope of application encompasses the lining of process and storage tanks that are exposed to oxidising stress conditions, such as sodium hypochlorite.

Properties

KERAPALON HE is characterised not only by an exceptionally broad chemical resistance spectrum, particularly against all substances having an oxidising effect, but also by its excellent mechanical properties.

KERAPALON HE offers all the advantages of a vulcanised rubber sheet, in particular the trouble-free storage and transport without cooling, and is fully chemically and mechanically resistant immediately after application without any costly vulcanization measures.

Chemical resistance

Information on the chemical resistance properties will be furnished on request.

Substrate

Steel and concrete components may serve as substrate.

The steel structures and concrete components to be rubber lined shall comply with the requirements of DIN EN 14879-1.

Surface pretreatment

Steel: The steel surface must be blasted to a metallic white finish. A preparation degree of Sa 2 ½ as specified in DIN EN ISO 12944-4 and a roughness degree of "medium (G)" as specified in DIN EN ISO 8503-1 must be achieved; minimum

roughness $R_z = 50 \mu\text{m}$ (Segment 2). After blasting, the steel surface must be primed.

Concrete: If required the concrete substrate must be treated by means of blasting in such a way that it is free from cement slurries, cement skin, loose and brittle particles, defects and separating substances. The residual moisture of the concrete surface shall be $< 4\%$.

Concrete substrates are provided with a conductive smoothing coat (thickness approx. 1 mm) of KERAPOX EP 221 to level unevenness' and to serve as counter pole for electrical tightness testing.

Application

The KERAPALON HE rubber lining system consists of the single-component Keratex primer, the three-component adhesive BS and the KERAPALON HE rubber sheet.

Mixing ratios	Parts by weight (kg)	Parts by volume (l)
Adhesive BS		
Solution BS	100	2.00
Accelerator BS	9	0.12
Keratex hardener E	3.4	0.06

Spread the primer on the steel or concrete substrate (KERAPOX EP 221), then apply two layers of adhesive. Treat the rubber sheet with KCH cleaner 1 and brush it twice with adhesive.

The rubber sheets are firmly bonded to the substrate by rolling as specified in DIN 28055-1.

Pot life

Temperature	Adhesive BS
15 °C	~ 160 min
20 °C	~ 120min
30 °C	~ 55 min

Consumption

Keratex Primer: approx. 0.15 kg/m²
 Adhesive BS: approx. 0.2 kg/m² per coat
 KCH Cleaner 1: approx. 0.2 kg/m²

Packing

The following standard quantities are available:

Keratex primer	5.16 kg
Solution BS	5.15 kg
Accelerator BS	5.25 kg
Keratex hardener E	0.75 kg
KCH cleaner 1	8.50 kg

Storage

The products shall be stored in a cool and dry place. With a storage temperature of 23°C the minimum shelf life is as follows:

KERAPALON HE sheet	36 months
Keratex primer	12 months
Solution BS	12 months
Accelerator BS	12 months
Keratex hardener E	12 months
KCH cleaner 1	24 months

Higher temperatures will shorten the shelf life of this products. The packaging drums are to be kept tightly shut and are to be resealed each time material has been removed. All liquid products must be stored frost-free.

Safety

Adequate ventilation shall be provided during the execution of all work. Ventilation is compulsory for all work carried out in pits and closed rooms. All vapours that are produced during processing must be continuously suctioned off at floor or bottom level.

Only such amount of material effectively required to continue work is to be stored at the working place. The instructions for the prevention of fire and explosion are to be observed if required.

Please note and ensure that even smallest quantities of the individual components and/or prepared mixtures are not allowed to reach the sewerage.

All regulations for the prevention of accidents stipulated by the employer's liability assurance association, the regulations for the prevention of accidents prescribed at the site of application and the TRGS 507 „Surface treatment in rooms and tanks“, as well as the safety precautions listed on the packing (label) required by the provisions of the Hazardous Materials Ordinance shall be adhered to. The operating instructions pursuant to § 14 GefStoffV as well as the EC safety data sheets are to be complied with.

Technical data	Test specification	Unit	Parameter
Density	DIN EN ISO 1183-1	g/cm ³	1.18 ± 0,02
Hardness	DIN 53505	Shore A	53 ± 5
Tensile strength *)	DIN 53504	MPa	≥ 4
Elongation at tear *)	DIN 53504	%	≥ 400
Peeling resistance	DIN 28055-2	N/mm	≥ 3
Max. surface pressure		MPa	2
Max. operational temperature		°C	80

*) : The values were determined at 4 mm thick rubber samples.

The technical data contained herein represents the current state of our product knowledge and is intended to furnish general information regarding our products and their application spectrum. In view of the diversity and multitude of application possibilities, this data should be regarded solely as general information, which does not guarantee any specific properties and/or suitability of these products for each concrete case of application. Consequently, when ordering a product, please contact us for detailed information relative to the properties required for a specific application. Our technical service will, upon request, furnish a profile of characteristics for the concrete application without delay.

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