



IRACORE

ADVANCING WEAR TECHNOLOGY

IRAPAIR 255

IRAPAIR 255 is an outstanding general-purpose two component trowel grade urethane compound. It can be easily trowelled to thicknesses or one inch on a vertical surface without sagging. Use it as a protective lining against abrasion, heat, humidity or moderate concentrations of mineral acid or alkalines. Seal and protect joints in tanks, slurry pipelines and as a high-build lining in areas of concentrated impact and abrasion.



IRAPAIR 275 FASTFIX

To facilitate and expedite field and in-plant repair of equipment and surfaces, the IRAPAIR KIT contains all materials and tools for making fast, durable repairs on such items as conveyor belts, pump liners, or any rubber, metal or urethane surface. The kit features IRAPAIR FASTFIX, the high performance urethane compound which readily cures at room temperatures allowing equipment to return to service in 4 to 6 hours.



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APPLICATION

Pipe or pumps with rubber, urethane or IRACORE™ lining

Surface Preparation

1. Prepare the part and ready all materials before mixing FASTFIX. Warm parts A and B to 70° F for best mixing and handling.
2. Remove damaged rubber or urethane by cutting or shaving with a sharp knife.
3. Exposed metal should be grit blasted per SSPC-SP 5-63 "White Metal Blast Cleaning". A 2-4 mil surface profile is desirable.*
4. Scrub the repair area including exposed metal with IRASOLVE CLEANER and paper towels. Use rubber gloves.
5. Scrub the rubber or urethane to be repaired with an abrasive pad wetted with IRASOLVE CLEANER. Then wipe entire repair area again with IRASOLVE CLEANER and paper towels. Repair area is clean when color does not transfer to towels. Allow to dry.
6. Apply metal primer FL10 to exposed metal in 2 coats using a foam or natural bristle brush. Be careful not to get metal primer on clean rubber or urethane liner. Allow to dry tack-free for 20-30 minutes after each coat.

Application

1. Apply adhesive FL20 to repair area (including primed metal). Allow to dry track-free for at least 20 minutes and no longer than 1 hour before applying mixed FASTFIX.
2. Mix FASTFIX according to package directions.
3. Remove FASTFIX from mixing container and spread on work surface using a trowel. Since the pot life of this material is short (10-15 minutes at 75° F / 20°C), it is best to remove entire contents from the mixing container as soon as possible. Be careful not to apply FASTFIX past adhesive area.
4. Allow FASTFIX to cure 4 hours at 75° F / 20°C before returning pump to light service. Cure rate is accelerated at higher temperatures.
5. Once cured, the repair area can be ground flush if desired. Use of 36 grit sanding disc (aluminum oxide is preferable). Keep grinder moving over surface, and keep at low rpm so as not to overheat the FASTFIX repair.

Conveyor Belts

Surface Preparation

1. Prepare the conveyor belt and ready all materials before mixing FASTFIX.
2. Remove damaged rubber by cutting or shaving with a sharp knife.
3. Scrub the repair area with IRASOLVE CLEANER and paper towels. Use rubber gloves.
4. Scrub repair area with an abrasive pad wetted with IRASOLVE CLEANER. Wipe area again with IRASOLVE CLEANER and paper towels. Repair area is clean when black color does not transfer to towels. Allow to dry

Application

1. Apply adhesive (FL20, found in IRAPAIR KIT, or use IRABOND UU-56) in a single thin coat using a foam or natural bristle brush. Allow to dry tack-free for at least 20 minutes and no longer than 1 hour before applying FASTFIX.
2. Mix FASTFIX according to package directions.
3. Remove FASTFIX from mixing container and spread on work surface using a trowel. Since the pot life of this material is short, (10 to 15 minutes at 75° F / 20°C.), it is best to remove entire contents from the mixing container as soon as possible. Be careful not to apply FASTFIX past adhesive area.
4. Allow FASTFIX to cure 4 hours at 75° F / 20°C before returning belt to light service. Cure rate is accelerated at higher temperatures.
5. Once cured, the repair area can be ground flush if desired. Use a 36 grit sanding disc (aluminum oxide is preferable). Keep grinder moving over surface, and keep at low rpm so as not to overheat the FASTFIX repair.

Conveyor Belt Mechanical Lacing

Surface Preparation

1. Prepare the conveyor belt and ready all materials before mixing FASTFIX. Warm parts A and B to 70° F / 20° C for the best mixing and handling.
2. Remove damaged rubber. Application area should extend a minimum of 3 inches beyond the mechanical lacing.
3. Scrub the repair area with IRASOLVE CLEANER and paper towels. Use rubber gloves.
4. Scrub repair area with an abrasive pad wetted with IRASOLVE CLEANER. Wipe area again with IRASOLVE CLEANER and paper towels. Repair area is clean when black color does not transfer to towels.

Application

1. Apply strips of duct tape (or similar tape) to the bottom side of the belt lacing to prevent material from falling through.
2. Apply adhesive (FL20 or IRABOND UU-56) to both the conveyor belt and mechanical lacing. Allow to dry tackfree 20 minutes and no longer than 1 hour before applying mixed FASTFIX.
3. Mix FASTFIX according to package directions.
4. Remove FASTFIX from mixing container and spread on both conveyor belt and mechanical lacing, using a trowel. Since the pot life of this material is short, (10 to 15 minutes at 75° F / 20°C), it is best to remove entire contents from the mixing container as soon as possible.