



# PermaFix® Polyurethane Belt Repair System

Fix it right the first time, and for a long time, with IMTECH PermaFix.

## IMTECH PermaFix Belt Repair System

IMTECH Perma-Fix is a two-part urethane that will repair, bond, and seal virtually any rubber surface. The product is applied using a dual cartridge dispensing system using, a mechanical or pneumatic dispensing gun with 24 element static mixing tubes for the repair of conveyor belts and rubber products.

The cured hardness of this product is 55/60 Shore A and has excellent abrasion and tear resistance, ideal for repairing damaged conveyor belts and covering mechanical belt fasteners.

IMTECH Perma-Fix is also great for shop and field repairs of elastomeric linings and coatings, and for smaller volume coating jobs as well.

- ▶ **Mechanical Gun uses 200 ML tubes, Part A and Part B**
- ▶ **Pneumatic Gun uses 750 ML tubes, Part A and Part B**
- ▶ **Battery Powered Gun uses 200 ML tubes, Part A and Part B**



## Product Specifications

Characteristic	PermaFix
Print Free	10 minutes @ 21oC (70oF)
Hardness	60 ± 5 Shore A Bashore
Resilience	40% (ASTM D2632)
Impact Resistance	Greater than 160 inch - pounds (ASTM D2794)
Flexibility	Pass 1/8" conical mandrel (ASTM D522)
Tear Strength	66 pli D-470, 210 lbs. Die C
Tensile Strength	950 psi (ASTM D412)
Elongation	400% (ASTM D412)
Abrasion Resistance	0.480 grams weight loss per 1000 cycles, H18wheel, at 1000 gms. (ASTM D1-044)
Operating Temp	-56oC (-70oF) to 93oC (200oF)
Weight of Cured Coating	29 gm./m2 @ 25 microns 0.60 lbs. per 100 ft.2 at .001" thick
Modulus 100%	385 psi (ASTM D412)
Recoat Times	12 hours without surface preparation
Volatile Organic Compound (V.O.C.)	Perma-Fix is a 100% solids formulation and as a result has no VOCs. It is advised to consider local, state, provincial or federal laws pertaining to the application of any coatings prior to use
Flash Point	IMTECH Perm-Fix, Part "A" and "B" are both non-flammable in shipping, storage and application
Coverage	Each 1 kg. of mixed product will theoretically yield: 34.0 m2 @ 25 microns (367 ft2 @ .001")



**Prepare the surface area to be repaired**



**Brush on PF-8400 Bonding Activator**



**Liberalily apply Perma-Fix to damaged area**



**Smooth out repaired area**



**Cure finished product for a minimum of 8 hours (prefer 24 hours) before putting into service**

## How To Apply IMTECH PermaFix

1. Prepare rubber by roughening with either a 24 to 36 grit aluminum oxide sanding disc on a slow speed sander, or by stiff wire brush or carbide sanding tool attached to an electric drill. Clean the repair area thoroughly and degrease with IMTECH STR-Tri Rubber Cleaning Solvent.
2. Apply **IMTECH PF-8400 Bonding Activator** to the area to be repaired. Allow product to flash off for approximately 15 minutes.
3. Prepare application gun by removing any trapped air in the cartridge. Turn cartridge A and the side at a 45 degree angle, squeeze gun until air bubbles are removed. Repeat same steps on cartridge B.
4. Apply **Perma-Fix** product to the damaged area, let stand for at least 1 to 2 hours.
5. Buff excess material from repaired areas using a 16 grit disc, making sure the repaired surface area is level with top of cover belt cover.
6. Do not put into use for 8 hours, but for best results - 24 hours is strongly recommended.

**NOTE:** Check the surface and air temperature (dew-point) to avoid condensation during the coating process. It is preferable not to process at environmental temperatures below 50°F (10°C) or above 104°F (40°C), more than 75% humidity or near the dew point. During application protect against direct sunlight wherever possible (ultraviolet exposure can lead to yellowing).

## IMTECH PF-8400 Bonding Activator

PF-8400-PW is specially formulated to promote optimum adhesion between IMTECH Perma-Fix repair materials and the surface of the conveyor belt or material to be repaired. Formulated to promote a polymeric resinous based adhesive in Ethyl Acetate for bonding of elastomeric repair materials to properly prepared rubber. PF-8400 will provide excellent bonds within several hours at ambient temperature to standard conveyor belt rubbers such as SBR. IMTECH PF-8400 can be brushed, rolled or sprayed on properly prepared rubber surfaces.

