

Product information 259K

HAWOFERRAN R16

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Base

Epoxy resin

Material Group

Repair systems for hard rubber linings

System Description / Application

HAWOFERRAN R16 is a synthetic resin-based repair mortar for hard rubber linings.

The system is used to repair hard rubber linings in tanks and ducts.

It may also be used for the permanent bonding of hard rubber parts, e.g. hard rubber seals for flanges and chamber separator strips.

Please contact our application engineering team to discuss the suitability of our products for your project.

System Design

- Hawoferran R16 Mortar Mixture

Properties

- high thermal stability
- excellent adhesive strength to various substrates, including steel and hard rubber linings

Physical Data

Physical Property	Value	Unit	Testing Standard
Density	1.32 ± 0.02	g / cm ³	DIN EN ISO 1183-1
Adhesive strength	≥ 4	MPa	DIN EN ISO 4624
Elongation at tear	≥ 0.2	%	ASTM C 307
Shore D hardness	78 ± 5		DIN EN ISO 868
Temperature resistance	80	°C	
Tensile strength	≥ 20	MPa	ASTM C 307

The stated values are average values, determined on cured and heat-treated samples.

Chemical Resistance

High resistance to inorganic, non-oxidising acids, alkalis and salts.

For detailed information, please refer to the corresponding resistance list.

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Packaging / Shelf Life

- The shelf life is given in months.
- All components must be stored and transported dry.
- Protect components from sunlight.
- The minimum shelf life applies to a storage temperature of 20 °C. Higher temperatures reduce, lower temperatures increase the shelf life.

NOTE! Observe the relevant safety data sheets for transport, storage and handling!

Component	Item Number	Package	Quantity	Shelf Life
Hawoferran-R16-A	5052001118	Drum	0.57 kg	12
Hawoferran-R16-A	5052001229	Drum	2.28 kg	12
Hawoferran-R16-B	5052002119	Drum	0.43 kg	12
Hawoferran-R16-B	5052002230	Drum	1.72 kg	12
KCH-Cleaner 1	5040016005	Canister	4 kg	24

GISCODE

Mixture	GISCODE
Hawoferran R16 Mortar Mixture	RE30

Working Equipment

grinding machine, narrow spatula, spatula wide, steel mortar mixing plate, plastic mortar mixing plate, flexible mixing cup

NOTE! The materials to be processed may have a corrosive effect on mixing and processing tools due to the substances they contain or their abrasive components. Therefore, only use tools that are suitable for mixing and processing.

Cleaning of Equipment

Tools that are soiled with uncured materials can be cleaned with KCH-Cleaner 1.

Only clean in well-ventilated areas.

Close the cleaner package immediately after use!

NOTE! Follow the safety instructions!

Requirements for the Application**Basic Requirements**

- During application, the temperatures of the substrate, the ambient air and the materials to be applied must be between 15 °C and 30 °C.
- The optimum application temperature is 20 °C. Higher and lower temperatures affect the pot life and consistency of the materials being applied. Consumption and application performance may change as a result.
- The object temperature must have a dew point difference of at least 3 K, and at least 5 K for relative humidity above 70 %.
- During application, the substrate must be kept absolutely dry. No moisture (condensate, mist, etc.) may get onto the surfaces to be protected.
- Unevenness must already be levelled out in the substrate.
- The construction site must be protected from draught and direct sunlight.

Steel and hard rubber linings

The surface must be dry, clean and free of separating substances.

The diameter of the area to be repaired must be ≤ 50 mm. For larger diameters, the repair instructions for the rubber lining used must be followed.

Steel surfaces must be ground to a bare metal finish.

Mixing Ratios / Consumptions / Application

NOTE! Follow the safety instructions!

The application may only be carried out if the conditions set out under 'Requirements for the application' are complied with. This applies for the entire duration of the application.

Bring the materials to be applied to the optimum application temperature of 20 °C by heating or cooling them prior to mixing and application.

Hawoferran R16 Mortar Mixture

Component	small mix kg / mix pre-dosed	large mix kg / mix pre-dosed
Hawoferran-R16-A	0.570	2.280
Hawoferran-R16-B	0.430	1.720
Total	1.000	4.000
Yield for layer thickness 1 mm / m ²	≈ 0.74 m ²	≈ 3 m ²
Number of application steps	see application	
Consumption per m ² and 1 mm layer thickness	1.350 kg = 1 litre	
layer thickness	see application	

Consumption quantities per m² for 1 mm layer thickness

Component	kg / m ²
Hawoferran-R16-A	0.770
Hawoferran-R16-B	0.580
Total	1.350

Application-relevant times

Times	20 °C
Pot life	≈ 60 minutes
Curing time until complete chemical and mechanical resilience	7 days

Mixing

- Place the pre-dosed components onto a mortar mixing plate or into a flexible mixing cup.
- Mix carefully by hand using a spatula until a smooth, lump-free mixture is achieved.
- When mixing in the mixing cup, run the spatula along the base and sides of the cup.

Application

- Remove the damaged rubber lining down to the steel.
- Grind exposed steel surfaces to a bare metal finish.
- Bevel the intact rubber lining over a length of 40 - 50 mm towards the steel.
- First, apply a thin layer of Hawoferran R16 Mortar Mixture using a spatula.
- Then fill the entire area with Hawoferran R16 Mortar Mixture using a spatula.
- The filling is even with the surface of the existing rubber lining.

Testing

Testing of tightness

The tightness test is carried out by spark testing with a spark tester.

The test voltage is 3 kV / mm.

Safety / Disposal

- Ensure sufficient ventilation, especially when working in closed rooms, pits or containers.
- No smoking / no fire.
- Observe the safety data sheets, hazard warnings and safety advice on the containers.
- Wear the appropriate personal protective equipment. Avoid direct contact of the material with the skin.
- Clean and care for hands with skin protection soap and ointment. Do not use solvents.
- Wear a dust mask when grinding, e.g. during repairs.
- Follow the operating instructions in accordance with §14 Hazardous Substances Ordinance and Technical Rules for Hazardous Substances TRGS 507.
- Comply with the accident prevention regulations of the employers' liability insurance associations.
- Avoid direct contact of the materials with the flame, pay particular attention to welding beads during welding work.
- Preferably use residual quantities.
- Do not pour residues down the sink or into the dustbin.
- Collect residual quantities for disposal separately in durable, sealable and labelled containers.

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