



DFense Blok™

Description: Alumina ceramic bead-filled epoxy system with outstanding wear and abrasion resistance for severe service conditions.

Intended Use: Repair scrubbers, ash handling systems, pipe elbows, screens, chutes, recontour chippers, bins, hoppers, bunkers, separators, digester tables. Protect exhausters, launderers, housing fans, crushers, and breakers.

Product features: Outstanding Wear and Abrasion Resistance
Able to withstand high impact forces
Resistance to a wide range of chemicals
Non-sagging

Limitations: None

Typical Physical Properties: *Technical data should be considered representative or typical only and should not be used for specification purposes.*

Cured 7 days @ 75° F

Adhesive Tensile Shear	2,616 psi
Coefficient of Thermal Expansion	29 [in / (in x °F)] x 10(-6)
Color	Gray
Compressive Strength	7,145 psi
Cured Hardness	77D
Cured Shrinkage	0.0005 in/in
Dielectric Constant	49
Flexural Strength	7,876 psi
Recoat Time	2 to 3 hours
Specific Gravity	2.21
Specific Volume	12.6 in(3)/lb
Temperature Resistance	Wet 140 °F; Dry 300 °F

TESTS CONDUCTED

Cured Hardness Shore D ASTM D 2240
Adhesive Tensile Shear ASTM D 1002
Compressive Strength ASTM D 695
Coef. of Thermal Expansion ASTM D 696
Cure Shrinkage ASTM D 2566
Dielectric Constant ASTM D 150
Flexural Strength ASTM D 790

Uncured

% Solids by Volume	100
Coverage/lb	47 sq. in/lb @ 1/4"
Cure Time	16 hours
Functional Cure	4-5 hours
Mix Ratio by Volume	2:1
Mix Ratio by Weight	100:45
Mixed Viscosity	Non-Sag Putty
Pot Life @ 75 °F	25 minutes

Surface Preparation:

1. Thoroughly clean the surface with Devcon® Cleaner Blend 300 to remove all oil, grease, and dirt.
2. Grit blast surface area with 8-40 mesh grit, or grind with a coarse wheel or abrasive disc pad, to create increased surface area for better adhesion (Caution: An abrasive disc pad can only be used provided white mesh is revealed). Desired profile is 3-5mil, including defined edges (do not "feather-edge" epoxy).

Note: For metals exposed to sea water or other salt solution, grit-blast and high-pressure-water-blast the area, then leave overnight to allow any salts in the metal to "sweat" to the surface. Repeat blasting to "sweat out" all soluble salts. Perform chloride contamination test to determine soluble salt content (should be no more than 40ppm).
3. Clean surface again with Cleaner Blend 300 to remove all traces of oil, grease, dust, or other foreign substances from the grit blasting.
4. Repair surface as soon as possible to eliminate any changes or surface contaminants.

WORKING CONDITIONS: Ideal application temperature is 50°F to 90°F. In cold working conditions, heat repair area to 100-110°F immediately prior to applying epoxy to dry off any moisture, contamination, or solvents, as well as to assist epoxy in achieving maximum adhesion properties.

Distributed by:

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Mixing Instructions:

---- It is strongly recommended that full units be mixed, as ratios are pre-measured. ----

1. Add hardener to resin
2. Mix thoroughly with screwdriver or similar tool (continuously scrape material away from sides and bottom of container) until a uniform, streak-free consistency is obtained.

INTERMEDIATE SIZES (1,2,3 lb. units): Place resin and hardener on a flat, disposable surface such as cardboard, plywood, or plastic sheet). Use a trowel or wide-blade tool to mix the material as in Step 2 above.

LARGE SIZES: (25 lb., 30 lb., 50 lb. buckets): Use a T-shaped mixing paddle or a propeller-type Jiffy Mixer Model ES on an electric drill. Thoroughly fold putty by vigorously moving paddle/propeller up and down until a homogenous mix of resin and hardener is attained.

Application Instructions:

ADDITIONAL SURFACE PREPARATION INFORMATION:

If grit blasting is not possible and expandable metal cannot be used, it is recommended that DFense Blok™ Surface Wetting Agent be utilized. The DFense Blok™ Surface Wetting Agent can also be used wherever it is desirable to maximize cured adhesion properties (shear, peel, impact). Apply Devcon DFense Blok™ Surface Wetting Agent at 10 to 20 mils to prepare the metal surface. Immediately apply DFense Blok™ over the DFense Blok™ Surface Wetting Agent. It is recommended that the DFense Blok™ be applied within 45 minutes of mixing/applying the DFense Blok™ Surface Wetting Agent. Should this window be exceeded and the DFense Blok Surface Wetting Agent™ becomes firm, a recoat of DFense Blok™ Surface Wetting Agent is recommended.

Spread mixed material on repair area at a minimum thickness of 1/4". Work firmly into substrate to ensure maximum surface contact. DFense Blok™ fully cures in 16 hours. Application Tip: a light coating of Devcon Cleaner Blend 300 (or a greater than 91% concentration of Isopropyl Alcohol (IPA), or denatured alcohol) on the surface of the tool used to transfer/spread the DFense Blok™ material will result in easier "workability".

FOR BRIDGING LARGE GAPS OR HOLES

Place fiberglass sheet, expanded metal, or mechanical fasteners between repair area and DFense Blok™ prior to application.

FOR VERTICAL SURFACE APPLICATIONS

DFense Blok™ can be troweled up to 3/4" without sagging. If greater vertical thickness is desired, apply first layer at 3/4", wait until product is firm and heat of reaction dissipates, apply a second layer of 3/4". Repeat as needed.

FOR OVERHEAD APPLICATIONS

The DFense Blok Surface Wetting Agent is recommended to facilitate ease of application on overhead surfaces. Refer to the first paragraph of the Application Instructions section for details. DFense Blok™ can be applied up to 1/2" to overhead surfaces. If greater thickness is desired apply first layer at 1/2", wait until product has firmed and heat of reaction dissipates, apply a second layer at 1/2". Repeat as necessary.

FOR ± 70°F APPLICATIONS

Applying epoxy at temperatures below 70°F lengthens functional cure and pot life times. Conversely, applying above 70°F shortens functional cure and pot life.

Storage:

Store at room temperature.

Compliances:

None

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75 °F

1,1,1-Trichloroethane	Very good	Nitric 10%	Fair
Ammonia	Excellent	Phosphoric 10%	Fair
Benzene	Very good	Potassium Hydroxide 40%	Excellent
Gasoline (Unleaded)	Fair	Sodium Hydroxide 50%	Excellent
Hydrochloric 10%	Very good	Sulfuric 10%	Very good
Methanol	Poor	Toluene	Excellent
Methyl Ethyl Ketone	Poor	Trisodium Phosphate	Very good
Methylene Chloride	Poor		

Precautions:

Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

**For technical assistance, please call 1-800-933-8266
FOR INDUSTRIAL USE ONLY**

Warranty:

Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer:

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.

Order Information:

11330 30 lb.

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