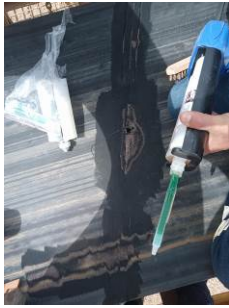


## MATO BOND - Repair of cracks and surface damages with Multiface 1.5



Hole repair



Splice repair



Belt edge repair



Crack repair in copper mine Steel cord belt rip



Steel cord belt edge repair



Repaired belt edge



Rip repair beside bolt plate fasteners



OTR tire repair



Sidewall belt repair

### Vulcanizing material Multiface 1.5

- Highly elastic hybrid vulcanizing material
- High adhesion on rubber, PVC and PU
- For heavy duty conveyor belts made of rubber and light duty conveyor belts made of PVC or PU
- Easy preparation and finishing with an angle grinder
- No use of solvents or primer or glue for the preparation
- Application with a cartridge gun and static mixer
- Cartridges resealable for using the remaining quantity during the next weeks
- Long pot time and open time for comfortable application on wide surfaces and accelerated curing time
- Installation even at low temperature and high humidity (even in foggy conditions)
- Restarting the belt after applying in less than 30 minutes at +23°C/73°F or 60 minutes at +5°C/41°F
- Restarting the belt in less than 20 minutes by using a heat gun at sub-zero temperatures
- Resistant to water, oil, gasoline, alkalis, acids and suitable to temperature from -40°C / -40°F to +120°C / 248°F
- Product without any danger to the people and transport and storage
- Food contact approved according to EG 1935/2004 and EU 10/2011

	<b>Multiface 1.5</b>
Material	2-component PU hybrid system
Special feature	Real chemical crosslink to rubber like a hot vulcanizing, ensuring best adhesion and stability
Solvent	100 % solvent free and VOC free.
Safety	No hazardous product; not subjected to transport and storage regulations.
Standard color	Black (self-levelling) or black thixotropic (non-sag) or transparent or white thixotropic or blue (self-levelling). All are food contact approved. Other colors on demand.
Preparation of the contact surface	Thoroughly grind and roughen the surface to be bonded. Then remove the dust particles with an unsoiled hand brush. <u>Do not clean the surface with usual solvents or chemical cleaners</u> since it may cause an unexpected reaction with Multiface®, thus weaken or even prevent the adhesion. <u>Do not apply a primer or a contact glue</u> since it will generally take some additional time and consequently increase the risks of contamination during the necessary drying time.
Application on the bonding surface	Apply first a <b>thin layer</b> of Multiface® with the cartridge gun on the contact surfaces and rub it into the pores with a brush. Do it within the pot time to avoid changing the static mixer. For wide rips, add a fabric reinforcement. <b>Then fill up</b> the gap with Multiface®, and if necessary, smooth the surface with a spatula.
Pot time (max. interruption time during application)	1.5 minutes
Max. applying time	Can be continuously applied and overcoated wet on wet or wet on half dry or wet on dry on very wide surfaces (no typical overcoating time window).
Dry surface at +23°C/73°F (*1)	< 15 minutes (< 30 min. at +5°C/41°F)
Final works	After curing, grind and equalize the surface if necessary.
Ready to start at +23°C/73°F (*2)	< 30 minutes (< 60 min. at +5°C/41°F)
Ready to start by heating at 80°C	< 15 minutes by heating at 80°C/176°F (< 20 minutes at temperature < 0°C)
(*1): The hardening depends on the temperature and the layer thickness. With increasing layer thickness, the curing time is reduced (exothermic reaction)	
(*2): Hardening time until functional strength as crack and surface damage repair. Full hardness, thermal and chemical resistance only after > 24 hours.	
For splicing application, the full functional strength is achieved after 2 hours (at 23°C).	

## Repairing cracks, holes and surface damages with Multiface 1.5

The repair of transmission belts and conveyor belts made of rubber or PVC or Polyurethane can be carried out particularly easily and fast with **Multiface®**. If necessary, the procedure and the adhesion should be tested before first use.

Pot time at 23°C/73°F  
 (= max. interruption until the need to change the static mixer)  
 Open time at 23°C/73°F  
 Curing time for functional strength for repair applications at 23°C/73°F  
 Curing time by heating at 80°C/176°F  
 Curing time in frost conditions for functional strength by heating at 80°C/176°F  
 Consumption

### Multiface 1.5

1.5 minutes

15 minutes

30 minutes

< 15 minutes

< 20 minutes

400 g can fill 1 mm over 0.32 m<sup>2</sup> (3.44 ft<sup>2</sup>) or 327 cm<sup>2</sup> (19.95 in.<sup>2</sup>)  
 and 1,220 g can fill 1 mm over 1 m<sup>2</sup> (10.76 ft<sup>2</sup>) or 1,000 cm<sup>3</sup> (61 in.<sup>3</sup>)

### Equipment recommended:

- Cutter
- Spatula
- Round brush Ø 30 mm or Ø 40 mm
- Angle grinder
- Abrasive discs grit 16 or grit 24
- Metal roughing brush or a carding brush
- Hand brush for cleaning (unsoiled and oil free)
- Heat gun to accelerate the curing
- Adhesive tape
- Pair of disposable gloves
- Some sheets from a roll of cleaning paper



Bevel the damaged area at the edges with at least 30° angle and grind widely the area with 16 grit or 24 grit abrasive disc at low speed (preferably 800 rpm). Both sides of the belt should be treated in case of holes and cracks going through the belt.

### Important:

**The grinding is mandatory!**  
**Otherwise, the surface of the conveyor belt does not allow any adhesion!**



Then roughen the contact surface with a rotating wire brush or a rotating carding brush.

Remark: Carding or brushing will increase the bonding strength. The brushing must be performed perpendicularly to the direction of belt transport, in order to obtain the best possible adhesion strength.



Clean the surface with an unsoiled brush or with compressed air (oil free!).

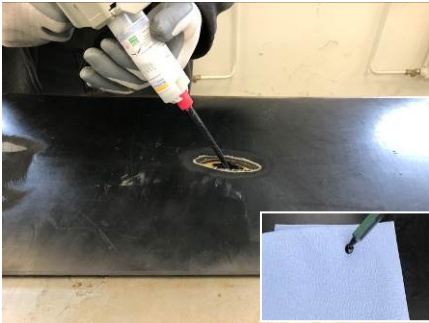
Remark: The contact surface should not be cleaned with a solvent or chemical cleaner since it may weaken or even prevent the bonding. At temperature below the dew point, the bonding surfaces must be dried with some cleaning paper and then heated with a heat gun (max. 60°C/140°F).



For holes and cracks exceeding 1 cm (0.3 inches) width and 10 cm (4 inches) length, add a fabric reinforcement!

**Remark:**

In this case remove the cover of the belt on the edge of the hole to release some cm of the carcass as required to obtain sufficient bonding surface. Holes and cracks through the belt should be sealed with an adhesive tape on the back side.



Prepare the cartridge with Multiface®.

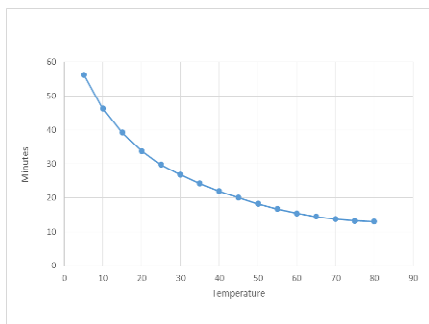
Check if both outputs are not clogged. If necessary, remove the plug of dried material. Then expel a small amount of both components and apply first a thin layer of Multiface® very quickly and immediately rub it into the pores with a short bristle brush to achieve good adhesion.

**Remark:** Do not use the first drops of the cartridges (approx. 1-2 g) to be sure that the mixing is perfect.



Fill up Multiface® quickly and in one operation if possible. If necessary, spread or smooth with a spatula.

**Caution:** due to the very short processing time, Multiface 1.5 starts to harden in the static mixer after an interruption of more than 1.5 minutes. After this waiting time, do not use the first following drops. At least after a longer interruption than the pot time, don't try to push the product by force but rather change the static mixer!



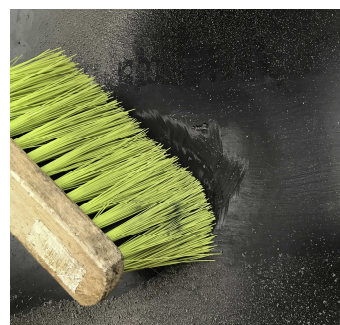
Wait the hardening.

The time depends on the temperature and takes:

- approx. 30 minutes at 23°C (73°F)
- approx. 60 minutes at 5°C (41°F)

Important: the curing time can be accelerated by heating the surface with a heat gun (max. 80°C/176°F!) after few minutes waiting time.

**Attention:** do not burn the Multiface® or the belt by using a higher temperature!



If necessary, equalize the surface by grinding or polishing with an angle grinder. Then clean the surface with a brush.



The belt can be restarted after approx. 30 minutes with Multiface 1.5 (at 23°C/73°F).

Remark:

Using a heat gun (max. 80°C/176°F) allows accelerating the hardening of the Multiface®. It is then possible to restart the conveyor belt after less than 15 minutes, even at very low temperatures and very high humidity.

This is mandatory with temperature below +5°C (41°F)!