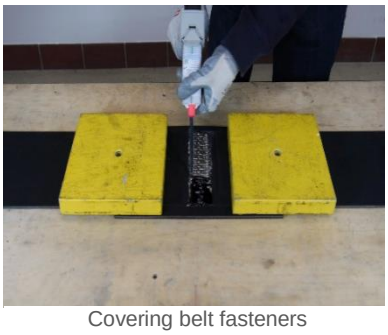
Hybrid Vulcanizing Material Multiface®
Epoxy Adhesive Multi-EP
Acrylic adhesive Multi-PEPP
Cleaning Agent Ester Bio

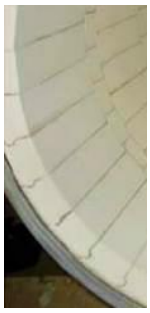

Hole and rip repair


Splice repair


Long rip repair


Covering belt fasteners


Pulley laggings


Ceramics


Off-Road tires repair


Step splicing of multiply belts


Steel cord belt splicing


Finger splicing


Bowl feeder coating


Drive pulley coating


Floor coating


Silos Coating

No solvents, VOC-free,
No primer for the preparation

CMR-free
No toxic ingredients

No hazards
for the environment

Non-flammable
No hazardous transport

Suitable for
food contact

Multiface®

Food contact approved according to EG 1935/2004 und EU 10/2011

Multiface® is a liquid, hybrid vulcanizing material and reactive adhesive that performs the traditional chemical crosslinking of hot vulcanizing material, already at room temperature. Therefore, it can be used for splicing and repairing conveyor belts made of rubber, PU und PVC, for off-road tires, for the elastic bonding pulley laggings, ceramic tiles, wood, textile fabrics, etc. or as protective coating against corrosion and wear. The product is a 2-component PU hybrid system without dangerous ingredients: solvent-free, VOC-free, CHC-free, CMR-free, REACH and RoHS compliant. It's considered as non-dangerous for people, environment, transport and storage. The shelf life under normal storage conditions is at least 2 years. Depending on the application, different pot life and hardness are available. This enables adapted, fast use of the product and best efficiency in terms of dynamic strength.

Cartridges	50 g	200 g	400 g	1,500 g
1 cartridge 2 static mixers 1:1				
Starter Set (small)	50 g	200 g	400 g	1500 g
1 cartridge 3 static mixers 1:1 1 caulking gun (manual) 1 spatula 1 round brush 1 pair of gloves				

Bulky quantity	in kg
Component A in canister or hobbock Component B in bucket or hobbock	
Spraying gun	
Spraying gun or Mixing and spraying unit	

Standard colors	Transparent-Amber	Black	Other colors (min. ordering quantity)	Highly transparent	White	Blue	Red	Gray	Green	Yellow	Orange

On request: thixotropic, gel-like for inclined or vertical positions or self-extinguishing and antistatic (FRAS) for underground.

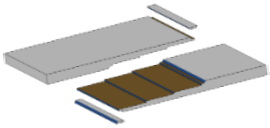
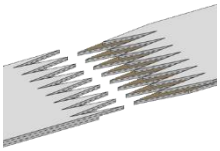
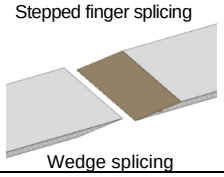
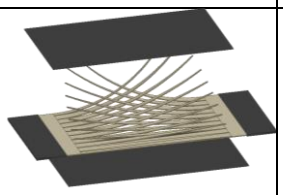
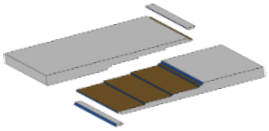
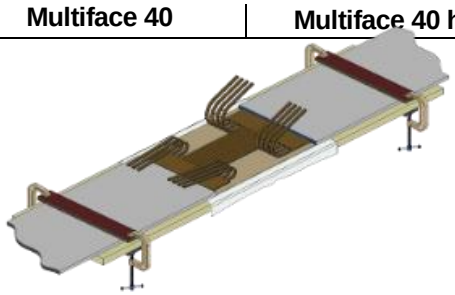
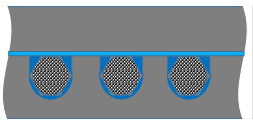
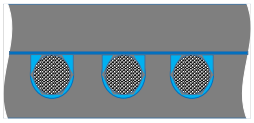
Multiface® as Repair and Filling Material for conveyor belts etc.

- No solvents and no primer or contact adhesive is needed for the preparation: therefore, there is no required waiting time for evaporation. Usable under extreme conditions in terms of temperature, humidity and dust.
- Long processing time with no overcoating time limit and an accelerated curing: the long pot life and open time as well as the properties enable convenient processing for large surfaces, even with short interruptions and an application wet on dry, virtually without maximum overcoating time, even under direct sunlight
- Simple procedure with only few steps: roughening, cleaning the surface with a brush, applying a first layer of Multiface® and working it into the surface with a brush, filling up the damage completely, allowing it to harden, and then, if necessary, leveling it by sanding. That's it!

	Multiface 1.5 self-leveling For normal use, horizontal or with a slight inclination	**Multiface 1.5 thixotropic** Gel-like / non-sagging, for all applications even in an inclined position or overhead	**Multiface 1.5 FRAS** Self-extinguishing / antistatic / thixotropic; for underground or quick applications
Recommended applications	Repair of surface damages, small holes and rips, edge repair, filling butt gaps, shaping profiles, cleats and guides, repair of Off-road tires		
	Repairing of wide holes, very long rips and damaged splices together with Hejatex fabric as reinforcement		
Final hardness	70 ± 5 Shore (A)	70 ± 5 Shore (A)	70 ± 5 Shore (A)
Pot life at 23°C/73°F	1.5 min.	5 min.	1.5 min.
	= max. interruption without having to replace the static mixer		
Available time for spreading at 23°C/73°F	Can be applied continuously wet on wet or wet on dry on large surfaces (Virtually no maximum overcoating time).		
Touch dry depending on the thickness at 23°C/73°F	~ 10-30 min. +5°C / 41°F: < 45 min. +60°C / 140°F: < 5 min.	~ 10-30 min. +5°C / 41°F: < 45 min. +60°C / 140°F: < 5 min.	~ 3-5 min. +5°C / 41°F: < 30 min. +60°C / 140°F: < 2 min.
Hardening time up to functional strength as crack repair at 23°C/73°F	~ 30 min. +5°C /41°F: < 90 min. +60°C / 140°F: < 20 min.	~ 30 min. +5°C / 41°F: < 90 min. +60°C / 140°F: < 20 min.	~ 15 min. +5°C / 41°F: < 30 min. +60°C / 140°F: < 10 min.
Hardening time when heated at +80°C/176°F	< 15 min. by heating to 80°C/176°F < 20 min. at temperature below 0°C/32°F		
Instruction and videos	Gebrauchsanweisung	Video: Belt repair	Video: repair of various damages Video: repair at rain

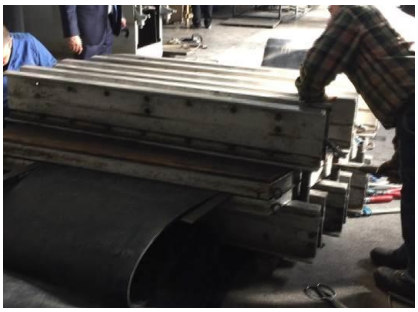
Multiface® as Splicing Material for Conveyor Belts made of Rubber, PVC and PU

- Simple process without solvents and without waiting time for evaporation
  Roughening, cleaning the surface with a brush, applying a single layer of Multiface® and work it into the surface with a brush. The step splice can be closed immediately after application without waiting time as there are no solvents.
- Very short curing time with a vulcanizing press
  For complete vulcanizing, it is sufficient to warm up the surface to +80°C / 176°F without holding time and then immediately allow it to cool passively during 20-30 min. The press can then be opened without further cooling.
- Short curing time with a cold press (at temperature over +5°C / 41°F)
  In case of bad accessibility or short tensioning path, a cold press or a fixing device can be used. A conveyor belt with step splicing is ready for use after 30 minutes fixture time and totally 2 hours curing time at +23°C / 73°F or 4 h at +5°C / 41°F.

	Multiface 5	Multiface 20	Multiface 40	Multiface 40 hart
Recommended applications	 Step splicing  Stepped finger splicing  Wedge splicing	 Finger splicing of multiply & monopoly belts, Aramid belts and steel cord belts up to 2,500 N/mm  Step splicing of conveyor belts	 Steel cord belt splicing  Cover plates	 Along the steel cords
Final hardness	75 Shore (A)	75 Shore (A)	75 Shore (A)	95 Shore (A)
Pot life at 23°C/73°F	5 min.	20 min.	40 min.	40 min.
Available time for spreading at 23°C/73°F	10-15 min.	60-90 min.	90-120 min.	90-120 min.
Curing time at 23°C/73°F up to functional strength	2 h (+5°C / 41°F: 4 h)	8 h (+5°C / 41°F: 18 h)	24 h (+5°C / 41°F: 54 h)	24 h (+5°C / 41°F: 54 h)
Curing time when heated at +80°C/176°F	< 30 min.	< 1 h	< 1,6 h	< 1,6 h
Instruction of use				
Videos	Video: step splicing EP1000/4	Video: step splicing of a sliding belt EP400/3		

Hot splicing with a Waterbag Press

Hot splicing with an Airbag Press

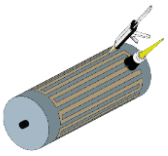
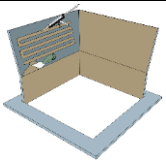
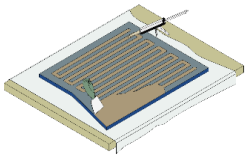


Hot splicing with a hydraulic Press

Curing with a fixing unit

Multiface® for the Bonding of Pulley Laggings and Abrasion Resistant Linings

- Simple process without solvents and metal primer
  The prior use of an adhesion promoter is generally not necessary to prepare sandblasted or sanded surfaces!
- Simple procedure with just few steps
  Roughening and cleaning of both surfaces, applying a single layer of Multiface® and work it into the surface with a brush, assembling after 15-30 minutes to get the required initial adhesion and at least wrapping with a stretch foil.
- Only 2 hours curing time at +23°C / 73°F
  The drive pulley is ready for use after a very short time, with the same resistance as in the case of hot vulcanized in an autoclave, additionally with a superior chemical and heat resistance (over +120°C / 258°F).

	Multiface 5 hard	**Multiface 20 hard**
Recommended applications	Bonding of drum laggings made of rubber or PU, bonding of ceramic parts and of wear protection plates, filling butt gaps	
	 	
Finale Härte	95 ± 5 Shore (A)	95 ± 5 Shore (A)
Pot life at 23°C/73°F	5 min.	20 min.
Available time for spreading at 23°C/73°F	10-15 min.	60-90 min.
Waiting time for initial adhesion at 23°C/73°F	15-30 min.	1-2 h
Curing time up to functional strength at 23°C/73°F	2 h (+5°C: 4 h)	8 h (+5°C: 18 h)
Curing time up to functional strength when heated at +80°C/176°F	< 30 min.	< 1 h
Instructions		

Multiface® as putty material with ceramic against wear and caking

- Exceptional protection against impact, wear, cavitation, erosion and corrosion with high elasticity
- Can be used also for the bonding of ceramic tiles

	Multiface 5 Putty material Soft	**Multiface 5** Putty material Medium	**Multiface 40** Putty material Extra hard
Main application as coating	Coating with good abrasion resistance and good rebound elasticity	Coating with good abrasion resistance, slight rebound elasticity and slightly anti-caking	Very hard, shock-resistant coating with excellent abrasion resistance and anti-caking
Finale hardness	70 ± 5 Shore (A)	85 ± 5 Shore (A)	95 ± 5 Shore (D)
Pot life at 23°C/73°F	5 min.	5 min.	40 min.
Overcoating time on vertical surfaces	The product can be applied continuously by hand or with a spatula wet on wet or apply wet on dry to large areas, virtually without a maximum overcoating time.		
Touch dry at 23°C / 73°F	0.5 h (+5°C / 41°F: 1 h)	0.5 h (+5°C / 41°F: 1 h)	3-4 h (+5°C / 41°F: 12 h)
Fully dry at 23°C/73°F	4 h (+5°C / 41°F: 8 h)	4 h (+5°C / 41°F: 8 h)	24 h (+5°C / 41°F: 3 days)
Full chemical resistance	3 days (+5°C / 41°F: 5 days)	3 days (+5°C / 41°F: 5 days)	5 days (+5°C / 41°F: 7 days)
Available also in double cartridges	Yes, can be applied manually without heating the cartridge or with a spraying mixer when the cartridge is preheated		
Data sheet			

Multiface® as surface protection coating against corrosion

- Exceptional resilience and performance
  Multiface® provides an effective barrier against moisture and is resistant to UV light, acids and alkalis in higher concentrations as well as temperatures up to +150°C / 302°F or +180°C / 356°F. Therefore, depending on the selected hardness, it can be used as a protective coating against corrosion, slipping or caking, or as floor sealant or high-end topcoat.
- Easy to apply with virtually no limited overcoating time
  Multiface® can be applied with a brush or a spatula, a roller, or a pneumatic or an airless spraying gun or a mixing and spraying unit.

	Multiface 1.5		Multiface 5		Multiface 40		
	Soft	Normal	Medium	Hard	Soft	Normal	Extra hard
Standard hardness after curing	50 ± 5 Shore (A)	70 ± 5 Shore (A)	85 ± 5 Shore (A)	95 ± 5 Shore (A)	50 ± 5 Shore (A)	70 ± 5 Shore (A)	85 ± 5 Shore (D)
Temperature resistance Dry / Wet	-50°C +150°C / +80°C	-50°C +150°C / +80°C	-50°C +150°C / +80°C	-50°C +150°C / +80°C	-50°C +150°C / +80°C	-50°C +150°C / +80°C	-50°C +180°C / +120°C
Rebounding elasticity	++++	+++	+	0	++++	+++	+
Anti-slip	++++	+++	0	0	++++	+++	0
Anti-caking	0	0	+	+++	0	0	+
Abrasion resistant	+	+	+++	++	+	+	+++
Hydrolysis resistant	++++	++++	++++	++++	++++	++++	++++
Easy to clean	+	+	+	++	+	+	+
Salt water resistant	+++	+++	++++	++++	+++	+++	++++
Acid resistant up to 50% concentration	+++	+++	++++	++++	+++	+++	++++
Alkaline resistant up to 50% concentration	+++	+++	++++	++++	+++	+++	++++
Resistant to polar solvents	++++	++++	++++	++++	++++	++++	++++
Resistant to non-polar solvents	++++	++++	++++	++++	++++	++++	++++
Oil resistant	++++	++++	++++	++++	++++	++++	++++
UV light resistant	+++	+++	++++	++++	+++	+++	++++
Available in double cartridges	Yes Can be applied manually or with a spraying mixer without heating the cartridge (preheated only recommended)						
Available in bulky quantity	Yes Can only be used with a mixing and spraying machine		Yes Can only be used with a mixing and spraying machine		Yes Can be mixed by hand and applied manually or with an airless spraying gun		
Pot life at 23°C/73°F	1.5 min.		5 min.		40 min.		
Overcoating time for vertical surfaces	When used as corrosion protection on vertical surfaces, layers of max. 0.4 mm can be sprayed on top of each other per pass. The waiting time for overcoating corresponds to the pot life to prevent the sprayed coating from flowing down. Generally, the product can be applied continuously wet on wet or wet on dry to large areas, virtually without a maximum over-coating time.						
Touch dry at 23°C/73°F	~ 10-15 min.		~ 30-45 min.		~ 3-4 h		
Fully dry at 23°C/73°F	~ 4 h		~ 8 h		~ 24 h		
Full chemical resistance	~ 5 days		~ 5 days		~ 5 days		
Technical data sheet							

Epoxy adhesive Multi-EP as Primer or surface protection

Multi-EP is a high-performance adhesive for structural bonding of hard materials such as metal, glass and ceramics, and was specifically developed for use both as a primer and as a high-end anti-corrosion coating for aggressive conditions and temperatures up to +180°C / 356°F. The product is a 2-component epoxy system with a bio-based hardener for an exceptional level of safety: no toxic ingredients, solvent-free, VOC-free and CMR-free, REACH and RoHS compliant and food compliant. It's considered as non-dangerous for transport and storage. The shelf life under normal storage conditions is at least 2 years.

- Simplified surface preparation
  The product achieves good adhesion even when sandblasting or sanding is not possible as Multi-EP is a high-performance adhesive for structural bonding of steel and stainless steel.
- Bonding agent
  Multi-EP is the right primer for many adhesives in cold process, for vulcanization materials in hot process, for the hybrid vulcanizing material Multiface® material and for many coating materials.
- Corrosion protection with high resilience and performance
  Due to its chemical composition, Multi-EP provides an effective barrier against moisture and cracks, preventing moisture-laden air from getting under the coating. Multi-EP is resistant to UV light, acids and alkalis in medium concentrations as well as temperatures from -50°C / -58°F to over +180°C / 356°F.
- Easy to apply with virtually no limited overcoating time
  The product can be applied with a brush, a spatula, a roller or a pneumatic or airless spray gun.

	Multi-EP Liquid Fast version	**Multi-EP** Liquid Medium speed version	**Multi-EP** Putty material Medium speed version	**Multi-EP** Potting compound with fillers
Recommended applications	Metal primer Anticorrosion coating Bonding of metal, ceramics and non-elastic hard materials		Repair of coatings with low elasticity	Back-casting of machine parts with high impact and shocks; Repair of coatings (Highly compressive strength and curing with almost no shrinkage)
Available in double cartridges for small surfaces	Yes: can be applied manually or with a spraying mixer without heating the cartridge		Yes: can be mixed by hand and applied manually or with an airless spraying gun	
Available in bulky quantity	Yes, for a use with a mixing and spraying machine	Yes, can be mixed and applied manually or with an airless spray gun	Yes, must be mixed and applied manually	Yes, must be mixed and applied manually
Final hardness	85 ± 5 Shore (D)	85 ± 5 Shore (D)	85 ± 5 Shore (D)	95 ± 5 Shore (D)
Fillers included	No	No	Ceramic	Ceramic
Pot life at 23°C/73°F	15 min.	50 min.	50 min.	50 min.
Touch dry at 23°C/73°F	2 h	4 h	4 h	4 h
Hardening time at 23°C/73°F up to functional strength	4 h (+5°C / 41°F: 12 h)	8 h (+5°C / 41°F: 24 h)	8 h (+5°C / 41°F: 24 h)	8 h (+5°C / 41°F: 24 h)
Full hardening at 23°C/73°F	4 h (+5°C / 41°F: 10 h)	8 h (+5°C: 24 h)	8 h (+5°C: 24 h)	8 h (+5°C: 24 h)
Full hardening by heating at 80°C/176°F	< 1 h	< 1 h	< 1 h	< 1 h
Standard colors	Gras green / Light beige / Translucid Orange	Other colors (min. ordering quantity)	Black / Grey / Brown / Red / Yellow / Blue / White / Violet	

Cartridges	Cartridge 50 g	Cartridge 400 g	Cartridge 1.200 g	**Bulky quantity**	Caulking guns, spraying mixers and application devices
1 cartridge 2 static mixer 2:1				 5 kg or 10 kg	
Data sheet and instruction					

Acrylic adhesive Multi-PEPP for the bonding of Polyethylene

Multi-PEPP is a high-performance adhesive for the structural bonding of polyethylene and polypropylene as well as plastics on each other or for viscoelastic bonding to hard materials such as metal, glass and ceramics. The product ensures an exceptionally high level of safety: without toxic ingredients, solvent-free, VOC-free and CMR-free, REACH and RoHS compliant and food compliant, safe for transport and storage.
The shelf life is 6 months at +5 to +25°C / 41-77°F in dark condition.

- Simplified surface preparation: the special adhesive properties enable optimal adhesion even without special preparation of the contact surfaces.
- Easy to apply with a brush, a spatula but also with a caulking gun with a spray mixer.

Main applications	Bonding of wear protection plates made of polyethylene (LDPE, HDPE, UHMWPE) or polypropylene		
Possible applications	Can be used as a primer for PE and PP sheets Bonding of rubber, PU, POM, metals		
Final hardness	60 ± 5 Shore (D)		
Open time at 23°C/73°F	3 min.		
Fixture time at 23°C/73°F	30 min. with PE or PP (at +5°C / 41°F: 30 min.) 1 h with galvanized steel (at +5°C / 41°F: 2 h)		
Curing time at 23°C until functional strength as adhesive	~ 24 h		
Dry surface as primer at 23°C	Approx. 1 week		
Cartridges	50 g	250 g	500 g
1 cartridge 2 mixers 10:1			
Data sheet and instruction			

Cleaning Agent Ester Bio

Ester Bio is a new generation chemical cleaner with broad spectrum action, solvent and VOC-free and was developed as a replacement for traditional cleaners for the elastomer industry. The product is considered to be safe for people, the environment, transport and storage and does not require any labeling. The shelf life is 5 years at 5-25°C / 41-77°F and dark condition.

- High performance: the molecular structure, the wetting properties and the very long evaporation time result in an upscaled ability to dissolve polar and non-polar molecules as well as heavy contaminants.
- Cost-efficient: the very long evaporation and exposure times lead to a particularly high level of effectiveness and very low consumption, especially when cleaning large areas or when used in an immersion bath.

Material	Ester-based system made from plant ingredients, manufactured for an exceptionally high level of safety.
Main characteristics	Made from renewable raw materials, without alcohol, silicone, oil and surfactants. Solvent-free and VOC-free. Non-flammable, 5 years shelf life. Applicable from +5°C / 41°F to +80°C / 176°F (boiling point > 200°C / 392°F; flash point > 120°C / 258°F). No toxic ingredients, no CMR components, RoHS compliant, not dangerous goods in terms of transport and storage, 100% biodegradable.
Application	After few minutes exposure time, treat the surface with cleaning paper or cleaning cloths and dry without residue.
Bottle made HDPE with 100 ml Spray bottle made HDPE with 500 ml Canister made of HDPE with 5 l or 10 l Hobbock with 200 l	
Data sheet and instruction	

Vulcanizing material, adhesives and cleaner

Protection coating

Vulcanizing presses for rubber belts

Heating presses for thermoplastic belts

Tools for belt maintenance

Belts for round balers

Further technical information, data sheets and instructions under www.hejatex.com

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http://www.beltecsolutions.com

ISO 9001
EINGETRAGENE FIRMA