

DURA-COAT CHEMICAL 200HT

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Chemical 200HT is a solvent free, high functionality Novolac Epoxy ceramic filled coating designed particularly as a protective coating for metals in highly aggressive chemical environments especially high wear abrasion. Excellent in a wide array of caustics and acids. Dura-Coat Chemical 200HT can be easily applied by brush or roller up to 40 mils without slump. It is able to withstand up to 230°C continuous operation and up to 280°C intermittently.

- It can be applied up to 40 mils without slump
- Suitable for any substrate, steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection

PACKAGES

	SIZE	REORDER #
OPCIONES	1kg	200HT-01
	2kg	200HT-02
	7.5kg	200HT-7.5
	15kg	200HT-15
	1125ml	200HT-Cart

FDA COMPLIANCE

This product complies with FDA regulations, for direct food contact specifically FDA 21 CFR 175.300 and FDA 21 CFR 175.105.

APPLICATION AREAS

- Pipelines
- Heat exchangers
- Tanks linings
- Impellers
- Screw conveyors
- Fans and housings
- Pump cases
- Internal coating of pipelines, joints and girth welds
- Water boxes
- Valves
- Metallic structures

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	230°C	446°F
	Dry Service	280°C	536°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Excellent	
	Organic Acids	Excellent	
	Organic Solvents	Excellent	
Flexural Strength	(ASTM D 790)	620kg/cm ² (60.7MPa)	8,800 psi
Pull-Off Adhesion	(ASTM D 4541)	330kg/cm ² (32.4MPa)	4,700 psi
Tensile Strength	(ASTM D 638)	211kg/cm ² (20.7MPa)	3,000 psi
Flexural Modulus	(ASTM D 790)	6.9 x 10 ⁴ kg/cm ²	9.9 x 10 ⁵ psi
Shore D Durometer Hardness	(ASTM D 2240)	80	
Taber Abrasion CS-10, 1000g, 1000 Cycles	(ASTM D 4060)	35mg	
Pot Life		35 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 1 mm (40mils)		No sag	
Coverage for 7.5kg Kit	115sf @20mils	10.7m ² @500 micron	
Mix Ratio	2:1 by weight		Base: Activator
Color	Gray as standard. Blue and red optional. Other colors contact the manufacture		
Shelf Life (unopened containers)	3 years at 55-95°F (13-35°C)		

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SURFACE PREPARATION

Proper surface preparation is critical to the long-term performance of this product. The exact requirements for surface preparation vary with the severity of the application, expected service life, and the initial substrate conditions. Minimum preparation is mechanical preparation St2/St3. Optimum preparation will provide a surface thoroughly cleaned of all contaminants and roughened to an angular profile between 75-125 µm (3-5 mil). This is normally achieved by initial cleaning and degreasing and then abrasive blasting to a cleanliness of Near White Metal (Sa.21/2), followed by removal of residual abrasive blast residues from the surface to be coated.

MIXING

Thoroughly mix Activator into Base with mixing stick or drill with low-speed mixing blade scraping sides and bottom of container or mixing board. Mix by weight 2-parts Base to 1-part Activator. Mix thoroughly to produce an even colored and streak-free material. **THINNING:** Never thin.

CURED TIME

	16°C (60°F)	25°C (77°F)	32°C (90°F)
TACK FREE	4 hours	2 hours	1 hour
LIGHT LOAD	12 hours	6 hours	3 hours
OVERCOAT END	16 hours	10 hours	5 hours
FULL LOAD	24 hours	12 hours	6 hours
FULL CHEMICAL	48 hours	24 hours	12 hours

APPLICATION

Brush: medium to stiff bristle of sufficient quality that bristles do not pull out and stick in coating (epoxy glued bristles are best). Trim or tape to <1" nap.
Roller: use good quality 1/8" nap.
Airless Spray: 45:1 or larger with TIP 529-535, pressure 5,000psi+. Temperature 50°C (122°F).
Plural Component Airless: Gracco Xp70 or equivalent, heated to 43°C (109°F).
Robotic Application: Robotic coating application on internal girth welds using rotatory atomizer.

APPLICATION TEMPERATURE

Keep between 55 to 95°F (17 to 35°C). Substrate: keep between 45 to 105°F (7 to 40°C). the difference in temperature of the substrate and the material should never exceed 10°F, 5°C. Substrate shall be a minimum of 5°F (3°C) above dew point. Do not apply if relative humidity exceeds 90%. If necessary, heat the metal prior to surface preparation using electric heater or heat lamp. Never use gas, oil, or kerosene heaters as they will leave a greasy residue on metal surface. For best results keep all material in warm area overnight (75°F+) for ease of mixing.

CLEAN UP

Tools must be immediately cleaned after usage by using industrial alkaline detergent.

SAFETY

Before using any products, review the appropriate Safety Data Sheet (SDS) or Safety Sheet for your area. Follow standard confined space entry and work procedures, if appropriate.

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