

DURA-COAT METAL REBUILD 261

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Metal Rebuild 261 is a solvent free, high functionality Novolac Epoxy coating and with FAST CURING agent. It is designed particularly as a rebuilding material for metals in highly aggressive chemical and temperature immersion service Dura-Coat Metal Rebuild 261 is convenient-to-use, non-sagging, with addition of machinable steel, with excellent high temperature resistant and high mechanical strength. It is able to withstand up to 230°C continuous operation and up to 280°C intermittently.

- It can be applied up to 500 mils without slump
- Ideally suited for restoration cladding material for corrosion
- Machinable
- Suitable for immersion and non-immersion service

PACKAGES

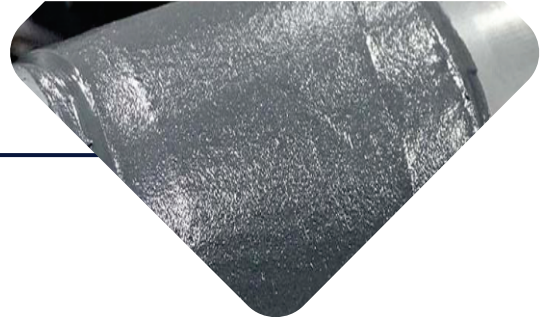
	SIZE	REORDER #
OPTIONS	1kg	261-01
	2kg	261-02
	10kg	261-10
	20kg	261-20

APPLICATION AREAS

- Shafts
- Chemical storage tanks
- Scrubbers
- Heat exchangers
- Fans and housings
- Mix zones
- Pipelines
- Pump cases
- Ducts
- Hot oil pipeline break
- Impellers

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)	279kg/cm ² (27.4MPa)	3,970 psi
Compressive Strength	(ASTM D 695)	1,060kg/cm ² (104MPa)	15,000 psi
Flexural Modulus	(ASTM D 790)	6.9 x 10 ⁴ kg/cm ²	9.9 x 10 ⁵ psi
E-Modulus		9.98 x 10 ⁴ kg/cm ² (9,800MPa)	1.42 x 10 ⁶ psi
Shore D Durometer Hardness	(ASTM D 2240)	85	
Pot Life		25 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 12 mm (1/2")		No sag	
Coverage for 10kg Kit	54sf @40mils	5m ² @1mm	
Mix Ratio	1:1 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. All sharp edges and welds shall be ground smooth or to a 3 mm (120 mil) radius before abrasive blasting. 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 White Metal (SSPC-SP10) or Near White Metal, 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 1-part Base to 1-part Activator. Mix thoroughly to produce an even colored and streak-free material. THINNING: Never thin. Pot life is 30 min @20°C.

CURED TIME

	16°C (60°F)	25°C (77°F)	32°C (90°F)
TACK FREE	1 hour	45 mins.	30 mins.
LIGHT LOAD	4 hours	3 hours	2 hours
OVERCOAT END	4 hours	3 hours	2 hours
FULL LOAD	8 hours	6 hours	4 hours
FULL CHEMICAL	16 hours	12 hours	10 hours

APPLICATION

Use heavy plastic squeegee or putty knife. Work material into profile of substrate to achieve maximum adhesion and to remove any entrapped air. Contour to correct form with putty knife or plastic applicator. If mold or form is used, coat its surface with a release agent to prevent adhesion of the material. Machining is possible using carbide tipped tools. Grinding is possible if done within 4 hours of application at 77°F, 25°C (add 1-1/2 hour for each 10°F below 77°, subtract 1 hour for each 10° above 77°F). Large holes and cracks can be bridged with glass or metal cloth.

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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