

DURA-COAT SURFACE TOLERANT 610

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat 610 is a solvent free, ceramic filled coating designed particularly as a protective coating for metallic surface where only a mechanical preparation is available and for dump surfaces as well. Excellent in a wide array of caustics and acids. Dura-Coat 610 can be easily applied by brush or roller up to 25 mils without slump.

- It can be applied up to 25 mils without slump
- Suitable for any substrate, steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection

PACKAGES

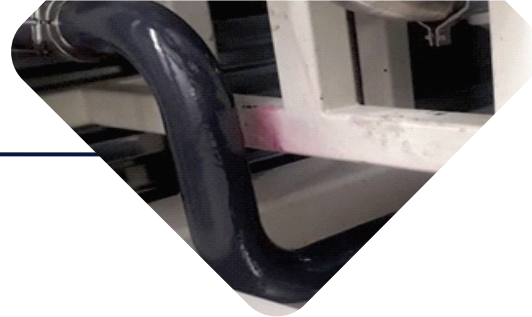
	SIZE	REORDER #
OPTIONS	1kg	610-01
	2kg	610-02
	7.5kg	610-7.5
	15kg	610-15

APPLICATION AREAS

- Bins and Silos
- Screw conveyors
- Water boxes
- Heat exchangers
- Fans and housings
- Valves
- Tanks linings
- Pump cases
- Metallic structures
- Impellers
- Many others

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	90°C	194°F
	Dry Service	150°C	320°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Good	
	Organic Acids	Good	
	Organic Solvents	Good	
Flexural Strength	(ASTM D 790)	560kg/cm ² (54.2MPa)	8,000 psi
Pull-Off Adhesion	(ASTM D 4541)	330kg/cm ² (32.4MPa)	4,700 psi
Tensile Strength	(ASTM D 638)	240kg/cm ² (23.4MPa)	3,400 psi
Shore D Durometer Hardness	(ASTM D 2240)	85	
Taber Abrasion CS-10, 1000g, 1000 Cycles	(ASTM D 4060)	52mg	
Pot Life		25 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 0.635 mm (25mils)		No sag	
Coverage for 7.5kg Kit	115sf @20mils	10.7m ² @500micron	
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)		



DURA-COAT SURFACE TOLERANT 610

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 or mechanical preparation. The preparation must be mechanical minimum St2 or St3.

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	6 hours	4 hours	3 hours
LIGHT LOAD	12 hours	8 hours	6 hours
OVERCOAT END	16 hours	10 hours	8 hours
FULL LOAD	24 hours	16 hours	12 hours
FULL CHEMICAL	48 hours	24 hours	18 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.

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.

Manufacturer, Dura-Coat Industrial Inc., makes no warranty either expressed or implied including warranties of merchantability or fitness for a particular purpose for this product. Under no circumstances will the manufacturer be liable for incidental, consequential, or other damages, breach of warranty, strict liability, or any other theory arising out of use of this product. The information and or recommendations contained herein are based on standard Product and are proprietary and furnished solely for the use of our customers. This information is provided in good faith and believed to be true and accurate as of the date/version of this document. As the manufacturer has no control over the use conditions or application process of the parties using this product, the manufacturer cannot accept responsibility for loss, injury or other damages resulting from the use of the Product or this or any other information provided by the manufacturer. Therefore, no guarantees of any kind, expressed or implied, are made by the manufacturer, Dura-Coat Industrial Inc., regarding this, or any, product manufactured by them or any contracted or licensed manufacturer. DURA-COAT® epoxy products do not provide structural integrity or improvement. They are only used to provide protection from corrosion, wear, abrasion and chemical attack on a given substrate and only to the extent provided for in the Data Sheets, Technical Data Sheets, Safety Data Sheets, and any other information as supplied in writing directly from manufacturers technical support.

4/25