

DURA-COAT ABRASION 306HT

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Abrasion 306HT is a solvent free, high functionality Novolac Epoxy ceramic filled coating designed particularly as a protective coating for metals in highly aggressive environments, high temperature up to 280°C. It is especially high wear abrasion and strong impact resistant. Excellent in a wide array of caustics and acids. Dura-Coat Abrasion 306HT can be easily applied by plastic squeegee or putty knife up to 1000 mils without slump.

- It can be applied up to 1000 mils without slump
- Suitable for any substrate, steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection
- Designed for rebuilding worn parts

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

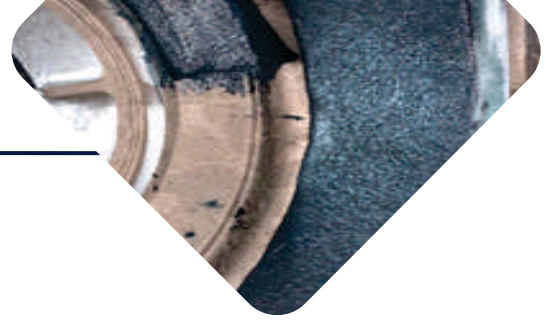
- Pipe elbows
- Screw conveyors
- Chutes and hoppers
- Propellers
- Fans and housings
- Wear plates
- Bins
- Pump cases
- Coal crushers
- Impellers
- Many others

PACKAGES

	SIZE	REORDER #
OPTIONS	1kg	306HT-01
	2kg	306HT-02
	10kg	306HT-10
	20kg	306HT-20

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	
Solids by Volume		100%	
Viscosity		Paste	
Mixed Density		2.0	
Shore D Durometer Hardness	(ASTM D 2240)	84	
Pot Life		25 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 12mm (1/2")		No sag	
Coverage for 10kg Kit	8.6sf@240mils	0.8m ² @6mm	
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. 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 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

Use heavy plastic squeegee or putty knife to apply a 6mm minimum thickness. Work material into profile of substrate to achieve maximum adhesive and to remove any entrapped air. Contour to correct form with putty knife or plastic applicator. If mold or form is used be sure to coat its surface with a release agent to prevent adhesion of the material.

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.

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.