

# DURA-COAT

## ABRASION FAST 351

### DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Abrasion Fast 351 is a solvent free, FAST CURING ceramic filled coating designed particularly as a protective coating for metals in highly aggressive environments especially high wear abrasion. Excellent in a wide array of caustics and acids. Dura-Coat Abrasion Fast 351 can be easily applied by plastic squeegee or putty knife up to 500 mils without slump.

- It can be applied up to 500 mils without slump
- Suitable for any substrate, steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection
- Designed for rebuilding worn parts

### PACKAGES

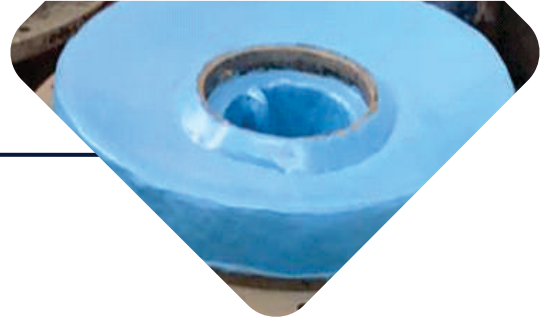
	SIZE	REORDER #
OPTIONS	1kg	351-01
	2kg	351-02
	10kg	351-10
	20kg	351-20

### APPLICATION AREAS

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

### TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	70°C	158°F
	Dry Service	93°C	200°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Good	
	Organic Acids	Good	
	Organic Solvents	Good	
Solids by Volume		100%	
Viscosity		Paste	
Mixed Density		2.0	
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 12.7mm (500mils)		No sag	
Coverage for 10kg Kit	25sf@80mils	2.3m <sup>2</sup> @2mm	
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 ABRASION FAST 351

## 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)
<b>TACK FREE</b>	45 mins.	30 mins.	20 mins.
<b>LIGHT LOAD</b>	1 hour	45 mins.	30 mins.
<b>OVERCOAT END</b>	1 hour	45 mins.	30 mins.
<b>FULL LOAD</b>	1.5 hours	1 hour	45 mins.
<b>FULL CHEMICAL</b>	4 hours	3 hours	2 hours

## APPLICATION

Use heavy plastic squeegee or putty knife to apply a 1mm 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.

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