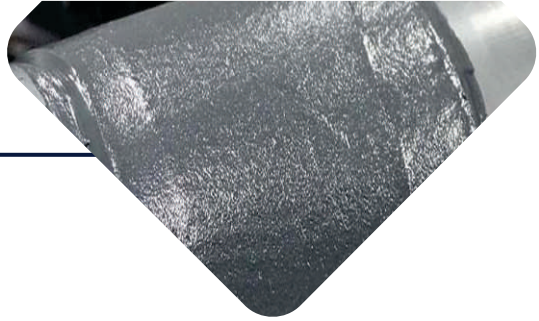
DURA-COAT



DURA-COAT
FAST CURING PUTTY 161

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Fast Curing Putty 161 is a two component ambient-temperature FAST CURING epoxy putty. It is designed particularly as a rebuilding material for metals in dry and immersion service Dura-Coat Fast Curing Putty 161 is convenient-to-use, non-sagging with good chemical resistance and high mechanical strength.

- 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 filling gaps and worn areas

PACKAGES

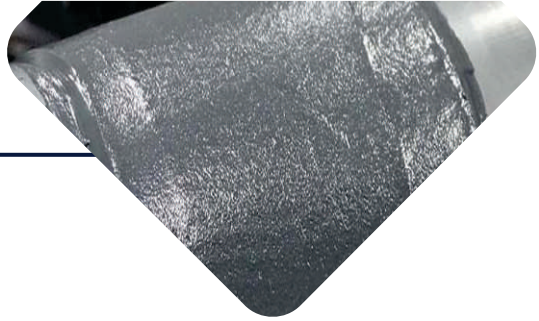
OPTIONS	SIZE	REORDER #
	1kg	161-01
	2kg	161-02
	10kg	161-10
	18kg	161-18

APPLICATION AREAS

- Shafts
- Screw conveyors
- Chutes and hoppers
- Pipes
- Fans and housings
- Wear plates
- Pump cases
- Bins
- Coal crushers
- Impellers
- Many others

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service Dry Service	70°C 93°C	158°F 200°F
Chemical Resistance	Water Alkalis Inorganic Acids Organic Acids Organic Solvents	Excellent Excellent Good Good Good	
Solids by Volume		100%	
Viscosity		Paste	
Mixed Density		1.8	
Shore D Durometer Hardness	(ASTM D 2240)	85	
Pot Life		5 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 12.7 mm (500mils)		No sag	
Coverage for 10kg kit	54sf @40mils	5.6m²@1mm	
Coverage		Varies with thickness applied	
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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FAST CURING PUTTY 161

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)
WORKING TIME	6 mins.	5 mins.	4 mins.
FUNCTIONAL CURE	15 mins.	12 mins.	10 mins.
FULL CHEMICAL	1 hour	30 mins.	25 mins.

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 77ºF, 25ºC (add 1-1/2 hour for each 10ºF below 77º, subtract 1 hour for each 10º above 77ºF). 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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