

DURA-COAT IMPACT FAST 358

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Impact Fast 358 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 and strong impact resistance. Excellent in a wide array of caustics and acids. Dura-Coat Impact Fast 358 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 slipping.
- Suitable for any substrate, steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection
- Designed for rebuilding worn parts

APPLICATION AREAS

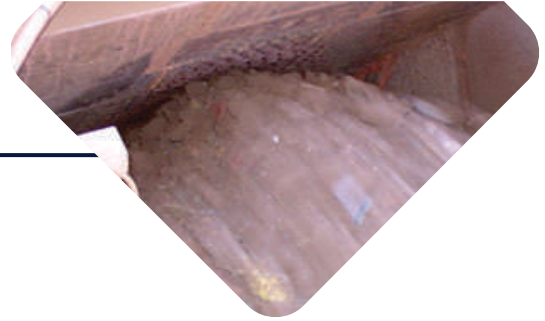
- Pipe elbows
- Screw conveyors
- Chutes and hoppers
- Propellers
- Fans and housings
- Wear plates
- Pump cases
- Bins
- Coal crushers
- Impellers
- Many others

PACKAGES

| | SIZE | REORDER # |
|---------|------|-----------|
| OPTIONS | 1kg | 358-01 |
| | 2kg | 358-02 |
| | 10kg | 358-10 |
| | 20kg | 358-20 |

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 12.7 mm (500mils) | | No sag | |
| Coverage for 10kg Kit | 9sf@240mils | 0.83m2@6mm | |
| Mix Ratio | 2:1 by weight | Base: Activator | |
| Color | Blue as standard. Grey 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. 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) |
|----------------------|-------------|-------------|-------------|
| TACK FREE | 45 mins. | 30 mins. | 20 mins. |
| LIGHT LOAD | 1 hour | 45 mins. | 30 mins. |
| OVERCOAT END | 1 hour | 45 mins. | 30 mins. |
| FULL LOAD | 1.5 hours | 1 hour | 45 mins. |
| FULL CHEMICAL | 4 hours | 3 hours | 2 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.

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