



# DURA-COAT INDUSTRIAL 620

## DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Industrial 620 is a solvent free, designed particularly as a protective coating for metals in industrial environments. Excellent in a wide array of environments. Dura-Coat Industrial 620 can be easily applied by brush, roller and spray 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 weathering protection

## PACKAGES

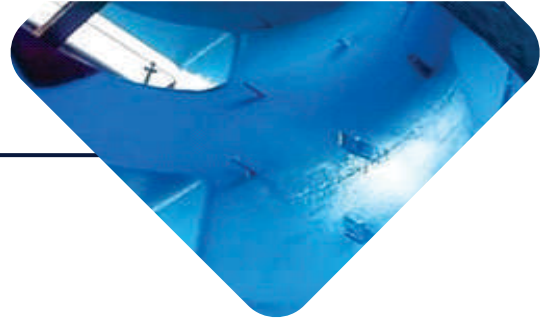
	REORDER #	GREY	GREEN	RED	ORANGE	BLUE	YELLOW
OPTIONS	5 L	620-GY5	620-GR5	620-R5	620-O5	620-B5	620-Y5
	10 L	620-GY10	620-GR10	620-R10	620-O10	620-B10	620-Y10

## APPLICATION AREAS

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

## TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	50°C	122°F
	Dry Service	60°C	140°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Good	
	Organic Acids	Good	
	Organic Solvents	Good	
Solids by Volume		100%	
Mixed Density		1.25	
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 0.635 mm (25mils)		No sag	
Coverage for 10 L Kit	215sf @20mils	20m <sup>2</sup> @500 micron	
Mix Ratio	2:1 by weight	Base: Activator	
Color	Grey, green, red, orange, blue and yellow		
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)
<b>TACK FREE</b>	4 hours	2 hours	1 hour
<b>LIGHT LOAD</b>	12 hours	6 hours	3 hours
<b>OVERCOAT END</b>	16 hours	10 hours	5 hours
<b>FULL LOAD</b>	24 hours	12 hours	6 hours
<b>FULL CHEMICAL</b>	48 hours	24 hours	12 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.

## 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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