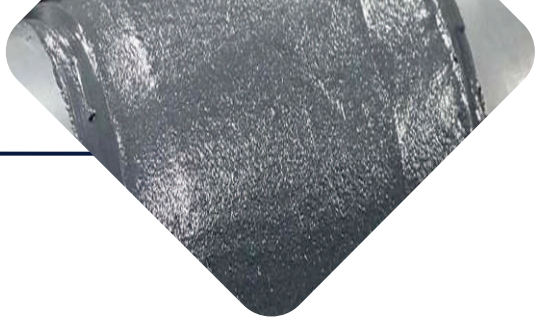
DURA-COAT



DURA-COAT REBUILD 101

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Rebuid 101 is a two component ambient-temperature curing epoxy putty. It is designed particularly as a rebuilding material for metals in dry and immersion service Dura-Coat Rebuild 101 is convenient-to-use, non-sagging with good chemical resistance and high mechanical strength.

- In compliance with FDA CFR 173.300
- 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

OPTIONS	SIZE	REORDER #
	1kg	101-01
	2kg	101-02
	10kg	101-10
	18kg	101-18

FDA COMPLIANCE

This product complies with FDA regulations, for direct food contact specifically FDA 21 CFR 175.300 and FDA 21 CFR 175.105.

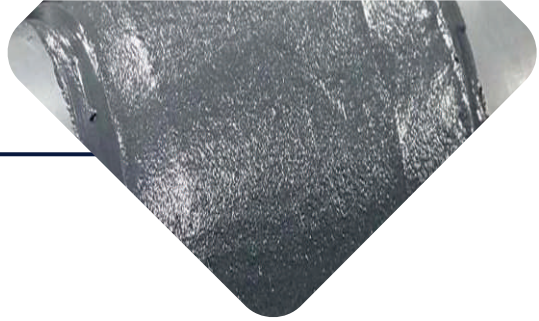
APPLICATION AREAS

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

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	90°C	194°F
	Dry Service	160°C	320°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Good	
	Organic Acids	Good	
	Organic Solvents	Good	
Solids by Volume		100%	
Viscosity		Paste	
Mixed Density		1.8	
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	60sf@40mils	5.6m²@1mm	
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®



DURA-COAT REBUILD 101

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	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 . 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, coats 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 14 hours of application at 77°F (25°C), (add 1-1/2 hours for each 10° below 77°F , subtract 1 hour for each 10° above 77°F). 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 an 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.

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