

# DURA-COAT REBUILD FAST 151

## DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Rebuild Fast 151 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 Rebuild Fast 151 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 rebuilding worn parts

## FDA COMPLIANCE

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

## PACKAGES

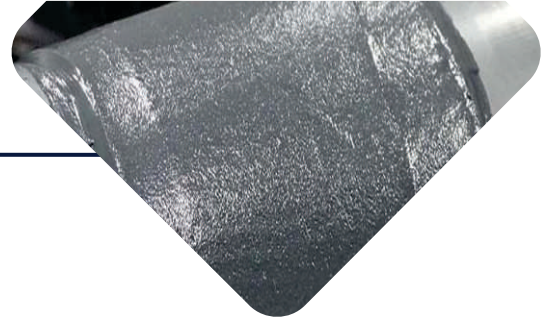
	SIZE	REORDER #
OPTIONS	1kg	151-01
	2kg	151-02
	10kg	151-10
	18kg	151-18

## 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@320mils	5.6m <sup>2</sup> @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)		



# DURA-COAT REBUILD FAST 151

## 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

Mezcle completamente el Activador con la Base usando un palo de mezcla o un taladro con una pala mezcladora de baja velocidad, raspando los lados y el fondo del recipiente o la tabla de mezcla. Mezcle en una proporción de 2 partes de Base por 1 parte de Activador en peso. Mezcle bien para obtener un material de color uniforme y sin vetas. **DILUCIÓN:** Nunca diluya.

## 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. 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 77°F, 25°C (add 1-1/2 hour for each 10°F below 77°, 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 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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