DURA-COAT

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ULTRA FAST 386

DESCRIPTION AND RECOMMENDED USES

Dura-Coat Ultra Fast 386 is a 100% solids, ULTRA-fast curing ceramic coating, solvent-free, designed primarily as a protective coating for metals in highly aggressive environments, particularly for high-wear abrasion and high impact resistance. It performs excellently in a wide range of caustics and acids. Dura-Coat Ultra Fast 386 can be easily applied with a plastic broom or putty knife up to 1000 mils without sagging.

- Can be applied up to 1000 mils without sagging
- Suitable for any substrate: steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection
- Designed for the reconstruction of worn parts

PACKAGES

OPTIONS	SIZE	REORDER #
	1kg	386-01
	2kg	386-02
	10kg	386-10
	20kg	386-20

APPLICATION AREAS

- Pipe elbows
- Screw conveyors
- Chutes and hoppers
- Propellers
- Fans
- Wear plates
- Pump bodies
- Containers
- 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		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 10 Kg Kit	8.6sf@240mils	0.8m²@6 mm	
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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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 the activator into the base using a mixing stick, scraping the sides and bottom of the container. Mix by weight 2 parts Base to 1 part Activator. Mix thoroughly to produce a uniform, streak-free material. Never add solvents.

CURED TIME

	16°C (60°F)	25°C (77°F)	32°C (90°F)
TACK FREE	25 min	20 min	15 min
LIGHT LOAD	30 min	25 min	20 min
OVERCOAT END	30 min	25 min	20 min
FULL LOAD	40 min	30 min	25 min

APPLICATION

Use a heavy-duty plastic scraper or putty knife to apply a minimum thickness of 6 mm. Work the material into the substrate profile to achieve maximum adhesion and eliminate any trapped air. Shape using a putty knife or plastic applicator. If molds or forms are used, ensure their surfaces are coated with a release agent to prevent material adhesion.

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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