DURA-COAT

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CHEMICAL 200F

DESCRIPTION AND RECOMMENDED USES

Fast-curing, brushable compound, 100% solids, Novolac epoxy with ceramic microsphere filler for abrasion protection. Excellent chemical resistance in the presence of caustics and concentrated acids. Can be easily applied by brush, roller, or airless spray.

- Can be applied up to 635 microns without sagging
- Excellent adhesion to steel, bronze, aluminum, and concrete
- Suitable for protection against corrosion and abrasion

PACKAGES

	SIZE	RED	GRAY
OPTIONS	1 kg	200F-R1	200F-GY1
	2 kg	200F-R2	200F-GY2

	SIZE	RED	GRAY
OPTIONS	7,5 kg	200F-R7.5	200F-GY7.5
	15 kg	200F-R15	200F-GY15

	SIZE	RED	GRAY
OPTIONS	1125 ML	200F-RCART	200F-GYCART

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

- Chimneys
- Piping
- Centrifugal pumps
- Heat exchangers
- Fans
- Valves
- Flotation cells
- Tanks
- Metal structures
- Scrubbers
- Many others

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service Dry Service	50°C 60°C	122°F 140°F
Flexural Strengh	(ASTM D 790)	327kg/cm² (32.1MPa)	4,650 psi
Pull-Off Adhesion	(ASTM D 4541)	289kg/cm² (28.3MPa)	4,100 psi
Tensile Strength	(ASTM D 638)	261kg/cm² (25.5MPa)	3,700 psi
Shore D Durometer Hardness	(ASTM D 2240)	85	
Taber Abrasion CS-10, 1000g, 1000 Cycles	(ASTM D 4060)	30mg	
Pot Life		35 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 12.7 mm (500 mils)		No sag	
Coverage for 7.5 kg Kit	115sf @20mils	10.7m² @500 microns	
Mix Ratio	2:1 by weight		Base: Activator
Color	Red and gray as standard. Other colors, contact the manufacturer.		
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 surface preparation requirements vary depending on application severity, expected service life, and the initial condition of the substrate. All sharp edges and welds must be ground to a 3 mm (120 mil) radius using an abrasive disc. Optimal preparation will provide a thoroughly clean surface, free of all contaminants, and roughened to an angular surface profile of 75–125 µm (3–5 mils). This is typically achieved through initial cleaning and degreasing, followed by abrasive blasting to White Metal (SSPC-SP10) or near-white metal, and subsequent removal of abrasive residues from the surface to be coated.

MIXING

Thoroughly mix the Activator into the Base using a mixing paddle, scraping the sides and bottom of the container. Mix by weight at a ratio of 2 parts Base to 1 part Activator. Mix completely until a uniform, streak-free material is obtained. Never add solvents.

CURED TIME

	16°C (60°F)	25°C (77°F)	32°C (90°F)
TACK FREE	3 hours	1,5 hours	1 hour
LIGHT LOAD	6 hours	3 hours	3 hours
OVERCOAT END	8 hours	5 hours	3 hours
FULL LOAD	10 hours	6 hours	4 hours
FULL CHEMICAL	12 hours	8 hours	6 hours

APPLICATION

Brush: medium to stiff bristles of sufficient quality so they do not shed or become embedded in the coating (epoxy-bonded bristles are preferred). Trim or tape to a length less than 1”.
Roller: use a high-quality roller with 1/8” nap.
Airless Spray: 45:1 ratio or higher, with tip size 529–535, 5,000 psi pressure or greater. Temperature: 50°C (122°F).
Plural Component Airless: Graco XP70 or equivalent, heated to 43°C (109°F).
Robotic Application: robotic coating application on internal circumferential welds using a rotary atomizer.

APPLICATION TEMPERATURE

Maintain the temperature between 55 and 95°F (17 to 35°C). The substrate must be maintained between 45 and 105°F (7 to 40°C). The temperature difference between the substrate and the material must never exceed 10°F (5°C). The substrate must be at least 5°F (3°C) above the 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 an oily residue on the metal surface. For best results, keep all material in a warm area overnight (≥ 75°F) to facilitate 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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