



DURA-COAT SURFACE TOLERANT 610

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat 610 is a solvent free, ceramic filled coating designed particularly as a protective coating for metallic surface where only a mechanical preparation is available and for damp surfaces as well. Excellent in a wide array of caustics and acids. Dura-Coat 610 can be easily applied by brush or roller 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 abrasion protection

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	610-01
	2kg	610-02
	7.5kg	610-7.5
	15kg	610-15

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	90°C	194°F
	Dry Service	150°C	320°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Good	
	Organic Acids	Good	
	Organic Solvents	Good	
Solids by Volume		100%	
Mixed Density		1.4	
Shore D Durometer Hardness	(ASTM D 2240)	80	
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 7.5kg Kit	115sf@20mils	10.7m ² @500micron	
Mix Ratio	2:1 by weight	Base: Activator	
Color	Gray as standard. Blue and red optional. 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 requirements for surface preparation vary with the severity of the application, expected service life, and the initial substrate conditions. All sharp edges and welds shall be ground smooth or to a 3 mm (120 mil) radius before abrasive blasting or mechanical preparation. The preparation must be mechanical minimum St2 or St3.

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	6 hours	4 hours	3 hours
LIGHT LOAD	12 hours	8 hours	6 hours
OVERCOAT END	16 hours	10 hours	8 hours
FULL LOAD	24 hours	16 hours	12 hours
FULL CHEMICAL	48 hours	24 hours	18 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.

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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