



DURA-COAT CHEMICAL 200 HT-F

DESCRIPTION AND RECOMMENDED USES

Dura-Coat Chemical 200 HT-F is a brush-applied, 100% solids, fast-curing coating formulated with Novolac Epoxy resin and filled with ceramic microspheres for superior abrasion protection. It offers excellent chemical resistance in the presence of highly aggressive caustics and acids. It withstands temperatures up to 230 °C in immersion conditions. Application is easy using a brush, roller, or airless spray equipment.

- Can be applied up to 1 mm without sagging
- Suitable for any substrate such as steel, bronze, aluminum, and concrete
- Ideal for protection against corrosion and abrasion

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

- Centrifugal pumps
- Bins and silos
- Water boxes
- Flotation cells
- Metal structures
- Impeller
- Heat exchangers
- Tanks
- Screw conveyors
- Valves
- Fans
- Internal lining of pipes, joints, and circumferential welds

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	230°C	446°F
	Dry Service	280°C	536°F
Chemical Resistance	Water	Excellent	
	Alkalies	Excellent	
	Inorganic Acids	Excellent	
	Organic Acids	Excellent	
	Organic Solvents	Excellent	
Solids by Volume		100%	
Mixed Density		1.4	
Shore D Durometer Hardness	(ASTM D 2240)	83	
Pot Life		35 min / kg at 72°F	
Vertical SAG Resistance at 21°C (70°F) and 1 mm (40mils)		No sag	
Coverage for 15kg Kit	232sf @20mils	21.2m² @500 micrones	
Mix Ratio	2:1 by weight		Base: Activator
Color	Gray as standard. Blue, green and red optional. Others contact the manufacture		
Shelf Life (unopened containers)	3 years at 55-95°F (13-35°C)		

PACKAGES

	SIZE	REORDER #
OPCIONES	1kg	200HTF-01
	2kg	200HTF-02
	7.5kg	200HTF-7.5
	15kg	200HTF-15
	1125ml	200HTF-Cart



ABRASION



AGGRESSIVE
CHEMICALS



HIGH
TEMPERATURE



DURA-COAT CHEMICAL 200 HT-F

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 with the Base using a mixing paddle or a low-speed drill equipped with a mixing blade, scraping the sides and bottom of the container or mixing board. Mix at a weight ratio of 2 parts Base to 1 part Activator. Stir well until the material has a uniform color and is free of streaks.
DILUTION: Never dilute.

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	2 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 get stuck in the coating (epoxy-bonded bristles are best). Trim or tape to a length under 1".
Roller: use a high-quality roller with 1/8" nap.
Airless Spray Gun: 45:1 ratio or higher with TIP 529–535, pressure of 5000 psi or more. Temperature at 50°C (122°F).
Plural Component Airless: Graco Xp70 or equivalent, heated to 43°C (109 °F).
Robotic Application: Robotic application of the coating on internal circumferential welds using a rotary atomizer.

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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