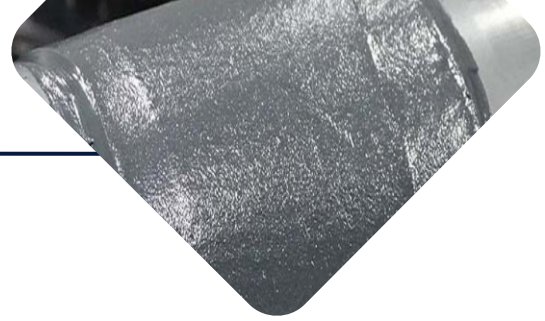




DURA-COAT REBUILD CHEMICAL FAST 251

DESCRIPTION AND RECOMMENDED USES

100% solids, Dura-Coat Rebuild Chemical Fast 251 is a solvent free, high functionality Novolac Epoxy coating and with fast-curing agent. It is designed particularly as a rebuilding material for metals in highly aggressive chemical and temperature immersion service. Dura-Coat Rebuild Chemical Fast 251 is convenient-to-use, non-sagging with excellent high-temperature resistant and high mechanical strength. It is able to withstand up to 230°C continuous operation and up to 280°C intermittently.

- It can be applied up to 500 mils without slump
- Ideally suited for restoration cladding material for corrosion
- Suitable for abrasion protection
- Suitable for immersion and non-immersion service

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	251-01
	2kg	251-02
	10kg	251-10
	18kg	251-18

APPLICATION AREAS

- Shafts
- Chemical storage tanks
- Scrubbers
- Heat exchangers
- Fans and housings
- Mix zones
- Electric power plant
- Pump cases
- Ducts
- Hot oil pipeline break
- Impellers

TECHNICAL DATA

Maximum Temperature (dependent on service)	Wet Service	230°C	446°F
	Dry Service	280°C	536°F
Chemical Resistance	Water	Excellent	
	Alkalis	Excellent	
	Inorganic Acids	Excellent	
	Organic Acids	Excellent	
	Organic Solvents	Excellent	
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 mm (1/2")		No sag	
Coverage for 10kg Kit	60sf@40mils	5.6m²@1mm	
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)		



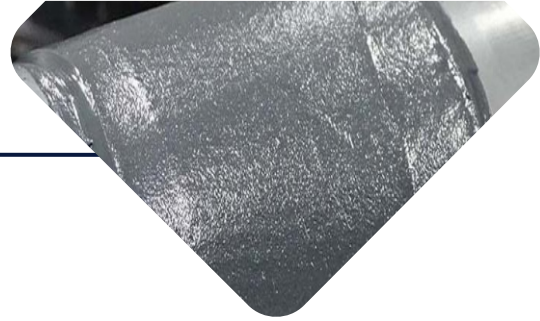
ABRASION



AGGRESSIVE
CHEMICALS



HIGH
TEMPERATURE



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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 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	45 mins.	30 mins.	20 mins.
LIGHT LOAD	1 hour	45 mins.	30 mins.
OVERCOAT END	1 hour	45 mins.	30 mins.
FULL LOAD	1.5 hours	1 hour	45 mins.
FULL CHEMICAL	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.

Manufacturer, Dura-Coat Industrial Inc., makes no warranty either expressed or implied including warranties of merchantability or fitness for a particular purpose for this product. Under no circumstances will the manufacturer be liable for incidental, consequential, or other damages, breach of warranty, strict liability, or any other theory arising out of use of this product. The information and/or recommendations contained herein are based on standard Product and are proprietary and furnished solely for the use of our customers. This information is provided in good faith and believed to be true and accurate as of the date/version of this document. As the manufacturer has no control over the use conditions or application process of the parties using this product, the manufacturer cannot accept responsibility for loss, injury or other damages resulting from the use of the Product or this or any other information provided by the manufacturer. Therefore, no guarantees of any kind, expressed or implied, are made by the manufacturer, Dura-Coat Industrial Inc., regarding this, or any, product manufactured by them or any contracted or licensed manufacturer. DURA-COAT® epoxy products do not provide structural integrity or improvement. They are only used to provide protection from corrosion, wear, abrasion and chemical attack on a given substrate and only to the extent provided for in the Data Sheets, Technical Data Sheets, Safety Data Sheets, and any other information as supplied in writing directly from manufacturers technical support.

