

Technical Data Sheet

DESCRIPTION AND RECOMMENDED USES: 100% solids, **Dura-Coat Rebuild 101** is a two component ambient-temperature curing epoxy putty. It is designed particularly as a rebuilding material for metals in dry and immersion service **Dura-Coat Rebuild 101** is convenient-to-use, non-sagging with good chemical resistance and high mechanical strength.

- In compliance with FDA CFR 173.300
- It can be applied up to 500 mils without slump
- Suitable for any substrate, steel, bronze, aluminum, concrete
- Suitable for corrosion and abrasion protection
- Designed for rebuilding worn parts



Application Areas:

- ✓ Shafts
- ✓ Propellers
- ✓ Pump cases
- ✓ Impellers
- ✓ Screw conveyors
- ✓ Fans and housings
- ✓ Bins
- ✓ Coal crushers
- ✓ Chutes and hoppers
- ✓ Wear plates
- ✓ Many others

TECHNICAL DATA

Maximum Temperature (Dependent on service)	Wet Service Dry Service	90°C 160°C	194°F 320°F
Chemical Resistance	Water Alkalis Inorganic Acids Organic Acids Organic Solvents	Excellent Excellent Good Good Good	
Flexural Strength	(ASTM D 790)	560 kg/cm ² (54.2 MPa)	8,000 psi
Pull-Off Adhesion	(ASTM D 4541)	330 kg/cm ² (32.4 MPa)	4,700 psi
Tensile Strength	(ASTM D 638)	240 kg/cm ² (23.4 MPa)	3,400 psi
Shore D Durometer Hardness	(ASTM D 2240)	85	
Taber Abrasion CS-10, 1000g, 1000 Cycles	(ASTM D 4060)	35mg	
Pot life		25 MIN / KG at 72°F	
Vertical SAG Resistance at 21C (70F) and 12.7mm (500mils)		No sag	
Coverage for 10Kg kit	54sf @40mils	5m ² @1mm	
Mix Ratio	2:1 by Weight		Base: Activator
Color	Grey as standard. Blue and Red optional. Other colors contact the manufacture		
Shelf life (unopened containers)	3 Years at 55-95°F (13-35°C)		

Application Sheet

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. 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 White Metal (SSPC-SP10) or Near White Metal, 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.

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 14 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.

Curing Schedule

	16°C (60°F)	25°C (77°F)	32°C (90°F)
Tack Free	4 hrs.	2 hrs.	1 hr.
Light Load	12 hrs.	6 hrs.	3 hrs.
Overcoat End	16 hrs.	10 hrs.	5 hrs.
Full Load	24 hrs.	12 hrs.	6 hrs.
Full Chemical	48 hrs.	24 hrs.	12 hrs.

Clean Up

Use commercial solvents (Acetone, Xylene, Alcohol, Methyl Ethyl Ketone) to clean tools immediately after use. Once cured, the material would have to be abraded off.

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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