

Technical Data Sheet

DESCRIPTION AND RECOMMENDED USES: 100% solids, **Dura-Coat Metal-Flex 480** is a high elongation, elastomeric, hybrid-epoxy. It is ideally suited for cavitation and abrasion, and it is completely compatible with epoxy coatings. The elastomeric aspect delivers a tough, flexible resilience while the epoxy aspect provides improved water and chemical resistance and shelf stability. Metal-Flex 480 epoxy reactivity eliminates the moisture sensitivity and toxicity associated with traditional urethanes. Metal-Flex 480 is easily applied up to 25 mils without slump.

- It can be applied up to 25 mils without slump
- Suitable for cavitation, corrosion and abrasion protection
- Suitable for any substrate, steel, aluminum, concrete, bronze
- Suitable for immersion and non-immersion service.



Application Areas:

- ✓ Bins and Silos
- ✓ Heat exchangers
- ✓ Pump cases
- ✓ Impellers
- ✓ Screw conveyors
- ✓ Fans and housings
- ✓ Tank linings
- ✓ Metallic structures
- ✓ Waterboxes
- ✓ Valves
- Many others

TECHNICAL DATA

Maximum Temperature (Dependent on service)	Wet Service Dry Service	82°C 93°C	180°F 200°F
Chemical Resistance	Water Alkalis Inorganic Acids Organic Acids Organic Solvents	Excellent Good Fair Fair Poor	
Elongation		70%	
Specific Gravity		1.4	
Viscosity		Light Paste	
Pot life		55 MIN / KG at 72°F	
Vertical SAG Resistance at 21C (70F) and 0.6mm (25mils)		No sag	
Coverage for 10Kg kit	154sf @20mils	14.3m2 @500 micron	
Mix Ratio	1:1 by Weight		Base: Activator
Color	Grey, Blue, Red		
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 1-parts Base to 1-part Activator. Mix thoroughly to produce an even colored and streak-free material.

THINNING: Never thin.

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.

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	6 hrs.	4 hrs.	3 hr.
Light Load	12 hrs.	10 hrs.	8 hrs.
Overcoat End	14 hrs.	12 hrs.	10 hrs.
Full Load	48 hrs.	36 hrs.	18 hrs.
Full Chemical	96 hrs.	72 hrs.	36 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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