



## Using DuraTough™ DL

**PLEASE READ THESE INSTRUCTIONS AND MATERIAL SAFETY DATA SHEET (MSDS) CAREFULLY PRIOR TO USE**

FLEXICLAD® DuraTough™ DL is a two component, 100% solids, fluid consistency elasto-ceramic polymer composite specifically formulated to surface and protect equipment subject to cavitation accelerated erosion/corrosion.

FLEXICLAD® DuraTough™ DL combines the superior strength, durability and adhesion of an epoxy with the exceptional flexibility, abrasion resistance and shock-absorbancy of an elastomeric urethane.

### SURFACE PREPARATION

FLEXICLAD® DuraTough™ DL should only be applied to clean, dry and well roughened surfaces.

1. Remove all loose material and surface contamination and clean with a suitable solvent which leaves no residue on the surface after evaporation such as acetone, MEK, isopropyl alcohol, etc.
2. Clean / roughen surface by abrasive blasting.
3. If necessary, apply moderate heat and/or allow the component(s) to 'leach' to remove ingrained contaminants.
4. Thoroughly roughen surfaces by abrasive blasting to achieve a 'white metal' degree of cleanliness and an anchor pattern of 3 mils.

Please note: In situations where adhesion is not desired, such as when making molds and patterns or to ease future disassembly, apply a suitable release agent (mold release compound, paste wax, etc.) to the appropriate surfaces.

### PRIMING THE SURFACE

FLEXICLAD® Primer is supplied in each kit of DuraTough™ DL (Green). After removing the divider, combine the Primer Base and Activator in the clear plastic packet, mixing until a uniform, streak-free color is obtained. Apply the Primer using a brush; be sure to 'stipple' the rough areas to insure complete coverage (wetting) of all exposed surfaces.

For detailed information regarding overcoating times, which vary depending on application temperatures, please refer to the appropriate section of the FLEXICLAD® DuraTough™ DL instructions.

### MIXING AND APPLICATION

For your convenience, the FLEXICLAD® DuraTough™ DL Base and Activator have been supplied in precisely measured quantities. Simply pour the entire contents of the Activator container into the Base container and, using a spatula, putty knife or other appropriate tool, mix thoroughly until the DuraTough™ DL reaches a uniform, streak-free color. Apply the mixed material to the prepared and Primed surface using a stiff-bristle brush or flexible applicator. As a guide, an even thickness of approximately 30-35 mils per coat should be obtained. A minimum two coat application is required. Overcoating

is ideally performed when the previously applied coat is just surface tacky; and, certainly within 6 hours at 77°F / 25°C of the previously applied DuraTough™.

### Technical Data

Volume capacity per 1/2 kg.	27 in <sup>3</sup> / 442 cc	
Mixed density	0.041 lbs per in <sup>3</sup> / 1.13 gm per cc	
Coverage rate per 1/2 kg. @ 30-35 mils	5 - 6 ft <sup>2</sup> / 0.5 m <sup>2</sup>	
Shelf life	Two years	
Volume solids	100%	
Mixing ratio	Base	Activator
By volume	5.7	1
By weight	6.5	1

### Cure Times

Ambient Temperature	Working Life	Initial Set	Maximum Overcoating	Full Cure
41°F 5°C	50 min	4 hrs	12 hrs	5 days
59°F 15°C	45 min	2 hrs	8 hrs	4 days
77°F 25°C	30 min	1 hrs	6 hrs	3 days
86°F 30°C	15 min	45 min	4 hrs	36 hrs

### Physical Properties

	Typical Values	Test Method
Hardness - Shore D	55	ASTM D-2240
Tensile Shear Adhesion		
Steel	1200 psi 84 kg/cm <sup>2</sup>	ASTM D-1002
Aluminum	1050 psi 74 kg/cm <sup>2</sup>	ASTM D-1002
Copper	1200 psi 84 kg/cm <sup>2</sup>	ASTM D-1002
Stainless steel	1100 psi 77 kg/cm <sup>2</sup>	ASTM D-1002
	-greater than 30 pli	ASTM D-1876
Peel Adhesion		
Comparative Cavitation Resistance		ASTM G-32
-Frequency: 20 KHZ; amplitude: 0.001 inches		
316 Stainless steel	60 microns	CMDL*
DuraTough™ DL	50 microns	CMDL*
Carbon Steel	240 microns	CMDL*

\*Cumulative Mean Depth of Loss

## Chemical Resistance

Acetic acid (10%) . . . . .	NR	Methanol . . . . .	NR
Ammonium hydroxide (10%) . . . . .	G	Mineral oil . . . . .	G
Ammonium hydroxide (30%) . . . . .	NR	Oxalic acid . . . . .	G
Butyl cellosolve . . . . .	NR	Phosphoric acid (10%) . . . . .	G
Ethanol . . . . .	NR	Phosphoric acid (50%) . . . . .	NR
Ethanol glycol . . . . .	G	Sodium hydroxide (10%) . . . . .	EX
Hexane . . . . .	G	Sodium hydroxide (50%) . . . . .	EX
Hydrochloric acid (10%) . . . . .	G	Sulfuric acid (10%) . . . . .	G
Isopropyl alcohol . . . . .	G	Toluene . . . . .	NR
MEK . . . . .	NR	Trichloroethylene . . . . .	NR

EX - Suitable for most applications including immersion.  
G - Suitable for intermittent contact, splashes, etc.  
NR - Not Recommended

### HEALTH & SAFETY

Every effort is made to insure that ENECON® products are as simple and safe to use as possible. Normal industry standards and practices for housekeeping, cleanliness and personal protection should be observed. For further information and guidance, please refer to the detailed MATERIAL SAFETY DATA SHEETS (MSDS) supplied with the material and also available on request.

### CLEANING EQUIPMENT

Clean tools, equipment and overspray, while wet, with warm soapy water. Dried residue can be cleaned with solvents such as mineral spirits or alcohol.

### TECHNICAL SUPPORT

The ENECON® engineering team is always available to provide technical support and assistance. For guidance on difficult application procedures or for answers to simple questions, call your local ENECON® Fluid Flow Systems Specialist or the ENECON® Engineering Center.

All information contained herein is based on long term testing in our laboratories as well as practical field experience and is believed to be reliable and accurate. No condition or warranty is given covering the results from use of our products in any particular case, whether the purpose is disclosed or not, and we cannot accept liability if the desired results are not obtained.

Copyright © 2010 by ENECON Corporation. All rights reserved. No part of this work may be reproduced or used in any form or by any means - graphic, electronic, or mechanical including photocopying, recording, taping or information storage and retrieval systems - without written permission of ENECON Corporation.

**ENECON**® Corporation  
The Fluid Flow  
Systems Specialists.

6 Platinum Court  
Medford, NY 11763-2251  
TEL: 516-349-0022 · FAX: 516-349-5522  
Toll Free: 888-4-ENECON  
Email: [info@enecon.com](mailto:info@enecon.com)

[www.enecon.com](http://www.enecon.com)