

Revolutionary products . . .

. . . for rebuilding, resurfacing and protecting all types of fluid flow machinery, equipment and structures.

FLEXICLAD®

DuraTough™ DP

**FLEXICLAD®
DuraTough™ DP**

Cavitation Resistant
Requires No Heat
Excellent Adhesion
100% Solids
Exceptional Flexibility

Rebuilds equipment damaged by cavitation.

Superior strength, durability and adhesion with flexibility, abrasion resistance and elongation.

FLEXICLAD® DuraTough™ DP is a two component, 100% solids elasto-ceramic polymer composite specifically formulated to rebuild equipment prone to cavitation attack and subsequent damage.

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

FLEXICLAD® DuraTough™ DP is ideal for rebuilding cavitated areas as well as creating or rebuilding flexible seals, gaskets, seats, etc, on machinery and equipment such as heat exchangers, pumps, valves and piping systems.

- **Cavitated areas**
- **Flexible seals**
- **Gaskets**
- **Seats**
- **Heat exchanger joints**
- **Pumps**
- **Valves**
- **Piping systems**



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DuraTough™ DP**

www.enecon.com

ENECON® Corporation
The Fluid Flow
Systems Specialists.

1-888-4-ENECON

Tel: 516 349 0022 · Fax: 516 349 5522
email: enecon@enecon.com

700 Hicksville Road · ENECON Center · Suite 110 · Bethpage, NY 11714-3496

Technical Data

Volume capacity per 1/2 kg.	25.7 in ³ / 438 cc	
Mixed density	0.041 lbs per in ³ / 1.14 gm per cc	
Coverage rate per 1/2 kg. @ 0.25 in / 6 mm	100 in ² / 0.06 m ²	
Shelf life	Two years	
Volume solids	100%	
Mixing ratio	Base	Activator
By volume	4	1
By weight	4	1

Cure Times

Ambient Temperature	Working Life	Initial Set	Maximum Overcoating	Full Cure
41°F 5°C	150 min	6 hrs	12 hrs	5 days
59°F 15°C	120 min	3 hrs	8 hrs	4 days
77°F 25°C	60 min	2 hrs	6 hrs	3 days
86°F 30°C	45 min	90 min	4 hrs	36 hrs

Physical Properties

Physical Properties	Typical Values	Test Method
Hardness -Shore D	50	ASTM D-2240
Tensile Shear Adhesion		
Steel	1000 psi 70 kg/cm ²	ASTM D-1002
Aluminum	950 psi 67 kg/cm ²	ASTM D-1002
Copper	900 psi 63 kg/cm ²	ASTM D-1002
Stainless steel	850 psi 60 kg/cm ²	ASTM D-1002
Peel Adhesion	-greater than 40 pli	ASTM D-1876
Comparative Cavitation Resistance		
-Frequently: 20 KHZ; amplitude: 0.001 inches		ASTM G-32
316 Stainless steel	60 microns	CMDE*
DuraTough™ DP	100 microns	CMDE*
Carbon Steel	240 microns	CMDE*

*Cumulative Mean Depth of Erosion

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

Your Local ENECON® Fluid Flow Systems Specialist

Using DuraTough™ DP

Surface Preparation - FLEXICLAD® DuraTough™ DP should only be applied to clean, dry and well roughened surfaces.

1. Removes 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.

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™ DP. 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™ DP Instruction Sheet.

Mixing & Application - Stir the Activator thoroughly to completely liquify it before mixing the two components together. For your convenience, the FLEXICLAD® DuraTough™ DP Base and Activator have been supplied in precisely measured quantities. However, should smaller quantities be desired, measure out 4 parts Base to 1 part Activator by volume (4:1, v/v) on a clean mixing surface and, using a spatula, putty knife or other appropriate tool, mix thoroughly until the DuraTough™ DP reaches a uniform, streak-free color. Apply the mixed material to the prepared and Primed area using a flexible applicator, putty knife, etc., pressing down well to force out any entrapped air and insure intimate contact with the surface.

Health and 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. Please refer to the detailed MATERIAL SAFETY DATA SHEETS (MSDS) supplied with the material (also available on request) for more information.

Cleaning Equipment - Wipe excess material from tools immediately. Use acetone, MEK, isopropyl alcohol or similar solvent as needed.

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.

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