



# DURA-PLATE® 2807 HS

HOT SPRAY EPOXY COATING,  
100% VOLUME SOLIDS

Revised 07/2023 Issue 1

## PRODUCT DESCRIPTION

A 2-pack epoxy coating for corrosion protection of steel in the food and beverage industry with high physical strength, good abrasion and impact resistance.

Solvent free according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

- Suited for a wide range of foodstuffs, chemicals, cleaning agents and disinfectants
- Very good adhesion to steel, stainless steel and aluminium
- Economical one-coat application
- Reliable application owing to the ability to check for pores in the coating
- No extensive treatment necessary before first filling

## RECOMMENDED USE

Can be used as a corrosion protection coating for steel. Mainly used as internal lining of tanks, silos, containers, pipes and equipment for applications in the food and beverage industries.

## PRODUCT TECHNICAL DATA

**Volume Solids:** 100 ± 2% (ISO 3233-3)

**Weight Solids:** 100 ± 2%

**VOC:** 0 g/l determined practically in accordance with Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).  
146 g/l calculated from formulation to satisfy EC Solvent Emissions Directive.  
98 g/kg calculated from formulation to satisfy EC Solvent Emissions Directive (UK).

**Colours:** Blue (component A: white / component B: blue)  
Red brown (component A: red brown / component B: ochre)  
Beige (component A: white / component B: ochre)

**Flash Point:** Base: >101°C, Hardener: >101°C.

**Cleaner/Thinner:** Cleaner HS (for cleaning).  
Clean spills, tools and spatters immediately with Cleaner HS.  
Do not thin Dura-Plate® 2807 HS.

**Pack Size:** A two component material supplied in separate containers to be applied with special airless hot-spray equipment:  
Dura-Plate® 2807 HS: 25 kg (15.7 litre) base  
Dura-Plate® 2800: 25 kg (20.3 litre) hardener  
Volume will vary with colours and density.

**Mixing Ratio:** 100 parts base to 50 parts hardener by weight.  
1.5 parts base to 1 parts hardener by volume.

**Density:** 1.5 kg/l (may vary with colours).

**Shelf Life:** 2 years from date of manufacture, stored in originally sealed containers in a cool and dry environment.

### Recommended Application Methods:

2-Pack Airless Hot-Spray

### Typical Thickness:

	Recommended Spreading Rate Per Coat	
	Typical	Maximum Sag
Dry	500 µm	1000 µm
Wet	500 µm	1000 µm
Theoretical Consumption*	0.750 kg/m <sup>2</sup> 0.500 l/m <sup>2</sup>	
Theoretical Coverage*	1.33 m <sup>2</sup> /kg 2.00 m <sup>2</sup> /l	

\* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment.

Film thickness will vary depending on actual use and specification.

### Pot Life:

+ 20°C	+ 60°C
30 min	5 min

Pot life is dependent on temperature and volume.



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## AVERAGE DRYING TIMES

### For 400 - 1000 µm Dry Film Thickness:

	+ 20°C
Dry to touch	6 hours
Foot Traffic	12 hours

Maximum recoat time is 4 hours at 20°C. Prior to further applications all contamination must be removed. In the case of extended recoating times the surface must be sweep-blasted.

Final cure: Full mechanical and chemical resistance after 7 days at + 20°C.

Containers or pipes can be sealed immediately after the coating has been applied. The coating hardens without the need for ventilation.

These figures are given as a guide only.

## APPROVALS & ENDORSEMENTS

- Inert and harmless in accordance with German food legislation.
- Physiologically harmless (expert report by Eurofins Institute Nehring).

## SURFACE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination such as oil, grease, dirt and corrosion products to achieve satisfactory adhesion.

Removal of welding spatter, grinding of welding seams and welding seam overlaps in accordance with DIN EN 14879-1.

**Steel surfaces** shall be blast-cleaned to Sa 2½ according to ISO 8501-1 (ISO 12944-4).

Average surface profile Rz ≥ 50 µm.

**Stainless steel and aluminium** shall be sweep blasted according to ISO 12944-4 with a non-ferrous blasting abrasive.

## MIXING

Application exclusively with 2-pack hot-spray airless equipment. Stir both components separately prior to application. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothing.

## APPLICATION CONDITIONS

Substrate temperature shall be above + 10°C and at least 3°C above the dew point.

Material temperature shall be above + 65°C.

Relative air humidity shall be below 80%.

## APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for satisfactory application characteristics. Always purge spray equipment before use with listed cleaner.

### 2-Pack Airless Hot-Spray

Unit: Efficient hot-spray airless equipment

Tip Size: 0.53 – 0.58 mm (0.021 – 0.023 inch)

Fan Angle: 40° - 60°

Operating Pressure: min. 180 bar (2600 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent satisfactory atomisation.

As conditions will vary from job to job, it is the applicators responsibility to ensure that the equipment in use has been set up to give the best results.

If in doubt consult Sherwin-Williams customer service.

### Repair

- Apply as supplied
- Suitable only for the repair of small areas

Clean and prepare damaged areas by sanding or sweep blasting of areas to be coated and ensure thorough removal of dust. As soon as possible the cold mixed material should be applied by trowel.

### Porosity test

With a suitable high-voltage tester, e.g. Fischer-POROSCOPE® HV20 with flat electrode (rubber tongue). Test voltage 10 Volt per 1 µm coating thickness.



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## RECOMMENDED SYSTEMS

### Steel, stainless steel and aluminium

1 x Dura-Plate® 2807 HS (min. 400 µm up to max. 1000 µm)

## ADDITIONAL NOTES

Drying times, curing times and pot life should be considered as a guide only.

### Chemical resistance:

Resistant to various cargo. Consult Sherwin-Williams.

### Temperature resistance:

Dry heat up to approx. + 100°C

In case of higher temperatures consult Sherwin-Williams customer service.

### Mechanical resistance:

Buchholz hardness according to ISO 2815: ~ 100

### Abrasion resistance:

In accordance with ASTM D 4060 (Taber Abraser): 250 mg/100 U (load: 500 g; disc S 33)

Numerical values quoted for physical data may vary slightly from batch to batch.

## HEALTH & SAFETY

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

## WARRANTY

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