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Coal Tar Epoxy

PRODUCT DESCRIPTION

Coal-Tar N is a bituminous, two-component polyamide-epoxy. It can be applied in one-coat application of 18 mils with no loss of adhesion. It displays excellent weathering and resistance to salt and fresh water degradation for steel and concrete.

Coal-Tar N is recommended for use on a large variety of steel or concrete structures. **Coal-Tar-N** meets the performance requirements of SSPC Paint no. 16, MPI # 35, and SSPC Paint No. 33 (replaced SSPC Paint No. 12).

Immersion	*Non-Immersion*
Marine Equipment	Chemical Plants
Salt & Fresh Water	Cogeneration Plants
	Power Plants
	Refineries
	Structural Steel
	Underground Storage Tanks
Linings In:	
Alkalies	Salt Solutions
Bilge Tanks	Salt Water
Fresh Water	Sour Crude
On Shore Pipelines	Tankage
Intermittent Immersion:	
Dams and Locks	Pilings
Offshore Structures	Sewage Treatment

PERFORMANCE PROPERTIES

System Tested:
Substrate: Steel
Surface Preparation: SSPC-SP6
1 ct. Coal Tar-N Black@ 18 mils dft

Adhesion:
Method: ASTM D4541
Result: Passes 600 lbs/sq in

Pencil Hardness:
Method: ASTM D3363
Result: 4H

Flexibility:
Method: ASTM D522
Result: Passes 180° bend 1" Mandrel

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TECHNICAL INFORMATION

Generic Types: Polyamide Cured – Coal Tar Epoxy. Two-component product.

Gloss: Semi-Gloss

Use: Protective / Decorative

Color: Black

Recommended Film Thickness: 16.0 – 18.0 mils dry
21.0 – 24.0 mils wet
Apply in two coats @ 8 – 9 mils dry.
10.8 – 12.1 mils wet.

Spread Rate: 66 – 75 sq ft/gal @ the recommended dft

Dry Time: @ 77°F (25°C) & 50% Relative Humidity

To Touch: 3 – 4 hours
Tack Free: 16 – 20 hours
Recoat: If product is to be recoated, you must recoat within 26 hours for good adhesion. After this time, surface should be abraded.

Storage Temperature: 20°F (-7°C) Minimum
110°F (43°C) Maximum

Flash Point: 80°F (20°C)

Brookfield Viscosity: 20 – 40 Poise with #7 Spindle @ 100 rpm

VOC: 1.88 (204 g/l) ± 1% (activated)

#HAPS / Gal Solids: 2.51 (activated)

Solids By Volume: 74.01 ± 2% (activated)

Solids By Weight: 78.89 ± 2% (activated)

Weight Per Gallon: 8.92 ± .15 lbs/gal (activated)

Pot Life: Four hours @ 77°F (25°C)

Shelf Life: One year unopened from date of manufacture, each component.

Recommended Primer: Product is self-priming, but can be used over Enviro-Zinc Epoxy Primer for maximum protection of steel. Self-priming over concrete.

Clean Up: 560X3504 (Xylene)

PERFORMANCE PROPERTIES
(continued from page one)

Dry Heat Resistance:
Method: ASTM D2485
Result: Passes 250°F

Salt Spray Resistance:
Method: ASTM B117
Result: Passes 1000 hours – no rust, no blistering

Abrasion Resistance:
Method: ASTM D4060 1 kg load
Result: 1000 cycles, 60 mg los

APPLICATION INFORMATION

SURFACE PREPARATION:
Surface of substrate should be dry, clean, and in sound, paint-worthy condition. The surface must be free of dirt, grease, oil, salts, loose rust, loose mill scale, and any other foreign materials or contaminants. For non-severe exposure, SSPC-SP3, Power Tool Cleaning may be all that is required. SSPC-SP6, Commercial Blast Cleaning is required for more demanding conditions or severe chemical exposure.

Steel and Iron:
The minimum surface preparation for steel and iron is SSPC-SP2/SP3, Hand Tool or Power Tool Cleaning. Prior to this procedure, the surface should be solvent cleaned per SSPC-SP1. For more severe exposures, begin with SSPC-SP1, followed by SSPC-SP6, Commercial Blast Cleaning. Bare metal should be primed as soon after surface preparation as possible, or before flash rusting occurs.

APPLICATION CONDITIONS:
Surface Temperature:
50°F (10°C) Minimum 110°F (43°C) Maximum
Surface should be dry and a minimum of 5°F (3°C) above the dew point.

Paint Temperature:
50°F (10°C) Minimum 90°F (32°C) Maximum

Relative Humidity:
Dry times may be adversely affected as the relative humidity increases. Caution should be taken when painting in very humid conditions.

MIXING & THINNING INSTRUCTIONS:
Mix one part base component with one part activator component using mechanical agitation. Stir well and allow catalyzed mixture to blend 15 – 30 minutes before use.

Note: The addition of thinner reduces viscosity, which, in turn, affects spread rate and application characteristics. If thinner is used, make sure it is well incorporated into the paint prior to application.

This product is available in 10-gallon kits. Each kit consists of the following: five gallons base component and five gallons activator component.

APPLICATION EQUIPMENT:

The following are general recommendations. Pressure and tip size may be varied due to temperature changes and for proper spray characteristics.

Thinning: Thin up to 5% by volume with
560X3504 (Xylene)

See Mixing and Thinning Instructions for further information.

Airless Spray:
Pump Ratio: 30:1
Hose: 1/4" or 3/8"
Tip Size: .015 – .019
Pressure: 2400 – 2600 psi
Filter: 60 Mesh

Air-assisted Airless
Pump Ratio: 30:1
Fluid Pressure: 800 – 1200 psi
Air Pressure: 10 – 20 psi
Fluid Hose: 5/16" – 1/2"
Tip Size: .017 – .019

Conventional Spray:
Gun: Graco AirPro or equal
Fluid Nozzle: 1.4 mm
Air Cap: 289773
Atomization Pressure: 40 – 50 psi
Fluid Pressure: 15 – 20 psi

HINTS FOR BETTER PERFORMANCE:
A clean substrate is necessary for optimal performance, as direct contact of coating and steel surface is required for rust inhibition and good adhesion.

All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application in order to help prevent premature failure in these areas.

Over-thinning of the coating material can result in an insufficient film-build, poor adhesion and overall poor appearance.

During the spray application, use a 50% overlap with each pass of the gun. This will help ensure complete and thorough coverage, avoiding low build areas, which may corrode prematurely due to insufficient primer.

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