

PRODUCT DESCRIPTION

Type Two component polyamide coal tar epoxy

100N7728B Coal Tar Epoxy is a high solids, high film build, low VOC 2K coal tar epoxy that is suitable for a variety of applications. It offers the user a flexible coating yielding excellent results in challenging environments. It offers a simple 1 to 1 mix ratio.

- Uses**
- Marine applications
 - A liner for clarifiers
 - Offshore rigs
 - Petroleum storage tanks
 - Dam gates
 - Penstocks
 - Non potable water tank and pipe coating
 - Underground applications

- Features**
- Immersion capable for fresh and salt water
 - Lining for alkalis, bilge tanks, non-potable water, onshore pipelines
 - Chemical Resistant
 - Intermittent immersion applications for dams, offshore platforms, pilings, sewage treatment

SUBSTRATE & SURFACE PREPARATION

Steel & Iron Substrate must be clean, dry and free of contaminants. Remove oil and grease thoroughly with suitable cleaners or solvent cleaned per SSPC-SP 1. For less than severe applications, prepare with SSPC-SP3, Power Tool Cleaning. Abrasive blast to SSPC-SP 6 for severe environments. Immersion service requires surface preparation of SSPC-SP10 / NACE 2 with a 2.5 – 4.0 mil profile.

For Immersion Service: Perform Holiday test in accordance with ASTM D162.

Galvanizing, Aluminum, Concrete Brush blast with 2 mil profile. Recommended dry film thickness is 4.0 mils.

For Immersion Service: Perform Holiday test in accordance with ASTM D4787 for concrete.

Primer Product is self-priming but can be used over Enviro-Zinc Organic Zinc Rich Epoxy (100S9785-KIT) or Enviro-Zinc Inorganic Zinc (100S9715) for immersion applications. It is self priming over concrete.

MIXING & THINNING

Ratio 2 – components. Combine base and activator components at a 1 to 1 ratio with curing agent **100X7729A Activator**. Ensure both components are above 50°F before mixing and using.

Mixing Mix the base component thoroughly before use by boxing or with slow mechanical agitation to avoid adding air resulting in bubbles. To 1 parts base add 1 part activator 100X7729A by volume. Stir well to ensure complete mixing and allow catalyzed mixture to blend 15-30 minutes before use.

Thinning Thinning is not normally needed. If needed reduce up to 5% with **560X1557 VOC Exempt Reducer** as required to maintain VOC levels. **560X0015 Epoxy Thinner Medium** or **560X3504 Xylene** can be used where VOC is not a concern for a medium reducer.

Pot Life 4 hours sprayable @ 77°F.

Cleanup Use Wash Solvent (**560X0952**).

APPLICATION GUIDANCE

Application Conditions Application of these product systems requires recommended temperature / humidity conditions and film thickness ranges. The material, booth and or site, and substrate temperature should be no lower than 40°F before, during, and after application. Do not apply paint materials to surfaces less than 5°F above dew point, or to surfaces warmer than 120°F. Ambient temperature should be minimum 50°F to maximum 105°F. Paint temperature of 60°F to 80°F will provide best performance.

Spray This product is high solids can be applied by using multiple types of spray equipment including airless, air-assisted airless, and conventional and HVLP spray.

- Note**
1. Conventional Spray pressure pot should have dual regulators, 3/8" (0.95 cm) ID minimum material hose, 0.07" (0.18 cm) ID fluid tip and corresponding air cap.
 2. Airless Spray (suggested).
 - a) Material hose 3/8" ID – 1/2" ID
 - b) Tip size: 0.025-0.017"
 - c) Pressure: 3,000 psi
 - d) Filter: none, remove

Brush & Roller Brush small areas only with a natural bristle and no reduction. Use a 3/8" – 1/2" roller with solvent resistant core with no reduction.

CURE TIME & RECOAT WINDOW

Substrate Temperature	To Touch	Tack Free	To Recoat	Full Cure
75°F (24°C)	3 – 4 hours	16 - 20 hours	Recoat within 26 hours for good adhesion	7 days

Sweat in time of 15 minutes is recommended before application.

Drying times are dependent upon film thickness, temperature and humidity.

PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
Coal Tar Epoxy Base	100N7728B	5-gallon pails, full filled.
Coal Tar Epoxy Activator	100X7729A	5-gallon pails, full filled.

Theoretical Coverage 118 ft² / catalyzed gallon @ 10.0 mils dry film thickness, unreduced and 100% transfer efficiency.

Storage & Shelf Life Maintain products in original packaging and sealed until ready for use. Estimated shelf life is one year when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions.

Safety Mixes and applications of this product present several hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

Ventilation Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
Colors	Black
Gloss	Semi-gloss
Pot Life	24 hours. <i>Best results are achieved when using within 2 hours of mixing. Do not use catalyzed material that has exceeded its pot life.</i>
Volume Solids	74%
Recommended DFT	16.0 – 18.0 mils DFT
Flash Point	Base: 80°F
VOC #HAPS / GAL SOLIDS	1.88 lbs. / gal. (204 g/L) mixed 2.51 (activated)
Weight / gallon	8.92 lb./gal. activated
Temperature Resistance	275°F
Shelf Life	1 year unopened and unactivated

HELPFUL HINTS

All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application 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.

Coating must be fully cured before placing into immersion applications.

For high build applications apply first coat at up to 10 mils WFT and let flash for 45 minutes and then apply 2nd coat of up to 10 mils WFT.

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