

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC21 SERIES DTM EPOXY FINISH

DESCRIPTION & USES

A two component, 75% volume solids, modified amine cured epoxy formulated for corrosion resistance as a direct to metal (DTM) exterior coating for railcars.

SURFACE PREPARATION

BLAST: NACE #2/ SSPC-SP 6

Commercial

PROFILE: Avg. depth 2.0 – 2.5 mils

APPLICATION SUMMARY*

EQUIPMENT: 45:1 ratio pump with 0.017 to 0.019 inch diameter orifice for airless spray gun tip at a 2800 psi minimum fluid pressure at tip to obtain proper atomization. An artist air brush can be used for touchup of WFT marks and other small repairs

REQUIRED CONDITIONS:

Noncontaminated profile

Dry, dust-free metal surface

Metal temperature above 60 F

Metal temperature 5 degrees above dew point

Ambient temperature above 50 F

Humidity less than 90%

Material temperature between 70 and 90 F

SAFETY: Consult MSDS for proper handling, cleanup, disposal and use of personal protective equipment before use.

Air Dry Schedule

Recoat within 10 days @ 77 F

Forced Dry Schedule

PHYSICAL DATA

Finish ----- High Gloss

Colors ----- Black, White, Brown, Gray

Mixing Ratio ----- 1:1 by volume

Volume Solids ----- 75% (mixed)

VOC ----- 1.8 lbs/gal (216 g/l) mixed

Flash Point ----- 60 F

Recommended Wet Film Thickness ---- 8-11 mils

Dry Film Thickness -----6-8 mils

Theo. Coverage at Proper Thickness --150 –201 sq ft/gal

Induction Time -----none required

Thinner -----TH 315 or TH313

Pot Life (1b mix @ 77 F) ----- 3 hrs

Shelf Life ----- 1 year

****Dry Times (at 77 F)**

Set to touch -----3 hrs

Tack Free -----6 hrs

Dry Hard -----10 hrs

Recoat ----- 12 hrs

****note: special air dry or force dry schedules are listed on the back side of this page if applicable**

SAFETY INFORMATION

WARNING! FLAMMABLE, HARMFUL IF INHALED, CAUSES IRRITATION

Keep away from sparks or flames. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after applications unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

Consult MSDS before use

SHIPPING DATA

Proper Shipping Name ----- Paint Liquid

Hazard Class----- Combustible Liquid

UN No. -----UN1263

***NOTE:** see detailed application instructions on separate sheet before application

DISCLAIMER

The facts stated and the recommendations and suggestions herein are based upon experiments and supplier information believed to be reliable. No guarantee is made of their accuracy, however, and American Coatings ASSUMES NO LIABILITY FOR PRODUCT FAILURE OTHER THAN TO SUPPLY REPLACEMENT MATERIAL FOR PRODUCTS SHOWN TO BE DEFECTIVE WHEN DELIVERED OR TO REFUND THE PURCHASE PRICE. Except as stated, THERE ARE NO WARRANTIES, EITHER EXPRESSED OR IMPLIED, OF MERCHANTABILITY, FITNESS OR OTHERWISE. AMERICAN COATINGS SHALL NOT BE LIABLE FOR SPECIAL, INCIDENTAL AND CONSEQUENTIAL DAMAGES. No statement contained herein shall be construed as an inducement to infringe existing patents or as an endorsement of specific manufacturers.

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PERFORMANCE DATA

SUBSTRATE: STEEL
SURFACE PREPARATION: SSPC-SP6

ABRASION RESISTANCE

TEST: ASTM D4060, CS17 WHEEL, 1000 CYCLES, 1 KG LOAD
RESULTS: 200 MG LOSS

ADHESION

TEST: ASTM D4521
RESULTS: 1050 PSI

DIRECT IMPACT RESISTANCE

TEST:ASTM G14
RESULTS: 20 IN LBS

DRY HEAT RESISTANCE

TEST: ASTM D2485
RESULTS: 200 DEG., YELLOWING

FLEXIBILITY

TEST: ASTM D522, 180 DEG. BEND, 1" MANDREL
RESULTS: PASSES

PENCIL HARDNESS

TEST: ASTM 53363
RESULTS:EXCELLENT; NO BLISTERING, CRACKING OR DELAMINATION 1/16" RUST
CREEPAGE AT SCRIBE

SOLVENT RESISTANCE

TEST: ASTM D-5402
RESULTS: 300+, 7-DAY CURE