

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC22 SERIES EPOXY PRIMER / FINISH

DESCRIPTION & USES

A direct to metal (DTM), chemical resistant Epoxy Primer / Finish for the exterior of railcars.

SURFACE PREPARATION

BLAST: NACE #2/ SSPC-SP 6

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
Full cure 7 days @ 77 F

Forced Dry Schedule

PHYSICAL DATA

Finish ----- Semi-Gloss
Colors ----- Buff, Brown
Mixing Ratio ----- 1:1 by volume
Volume Solids ----- 85% (mixed)
VOC ----- 1.2 lbs/gal (140 g/l) mixed
Flash Point ----- 100 F
Recommended Wet Film Thickness ---- 5-8 mils
Dry Film Thickness -----4-6 mils
Theo. Coverage at Proper Thickness --170 –341 sq ft/gal
Induction Time -----none required
Thinner -----TH 314
Pot Life (1b mix @ 77 F) ----- 2 hours
Shelf Life ----- 1 year
****Dry Times (at 77 F)**
Set to touch -----2 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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AC22 SERIES
DTM EPOXY PRIMER/FINISH

PERFORMANCE DATA

SUBSTRATE: STEEL
SURFACE PREPARATION: SSPC-SP6

ABRASION RESISTANCE

TEST: ASTM D4060, CS17 WHEEL, 1000 CYCLES, 1 KG LOAD
RESULTS: 60 MG LOSS

ADHESION

TEST: ASTM D4521
RESULTS: 950 PSI

DIRECT IMPACT RESISTANCE

TEST: ASTM G14
RESULTS: 10 IN. LBS

DRY HEAT RESISTANCE

TEST: ASTM D2485
RESULTS: 200 DE., YELLOWING

FLEXIBILITY

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

PENCIL HARNESS

TEST: ASTM D3363
RESULTS: H

SALT FOG RESISTANCE

TEST: ASTM B117, 750 HRS
RESULTS: EXCELLENT; NO BLISTERING, CRACKING OR DELAMINATION, 1/16" RUST
CREEPAGE AT SCRIBE

SOLVENT RESISTANCE

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

EXTERIOR DURABILITY

TEST: 1 YEAR, 45 DEG. SOUTH
RESULTS: EXCELLENT, WITH CHALKING