

# RAILCAR COATINGS of AMERICA

## THE RIGHT CHEMISTRY

### AC72 SERIES EPOXY LINING FINISH

#### DESCRIPTION & USES

#### HIGH CHEMICAL RESISTANCE

A two component, high solids, modified epoxy formulated for use in conjunction with AC71 primer as a protective lining with excellent resistance to acetic and hydrochloric acids. Used for dry bulk service in hopper cars carrying EVA, PTA, Adipic acid and other commodities, which may contain residual process acid.

Special Qualifications: 21 CFR175.300(b)(3)(viii)(a)

#### SURFACE PREPARATION:

Free of dust, dirt, oils, moisture and other contaminates.

#### APPLICATION SUMMARY\*

**EQUIPMENT:** 45:1 ratio pump with 0.019 to 0.025 inch diameter orifice for airless spray gun tip at a 2800 psi minimum fluid pressure at tip to obtain proper atomization. An artist airbrush can be used for touchup of WFT marks and other small repairs

#### REQUIRED CONDITIONS:

Noncontaminated profile  
Dry, dust-free metal surface primed with AC71  
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:

Circulate warm air @ 90 - 100 deg. F for 12 hours minimum. Perform electrical holiday test for discontinuities. All tests and touchups must be made before a force cure

#### Forced Dry Schedule:

- Ramp rate 1 degree F / min
- 150 F soak temperature @ 6 hours

\*Note: see detailed application instructions on separate sheet before application.

#### PHYSICAL DATA

Finish ----- High Gloss  
Colors ----- Blue, White  
Mixing Ratio ----- 1:1 by volume  
Volume Solids ----- 67% + (mixed)  
VOC ----- 2.35 lbs/gal (282 g/l) mixed  
Flash Point ----- 68 F  
Recommended Wet Film Thickness ----- 12-15 mils  
Dry Film Thickness ----- 8-10 mils  
Dry Film Thickness (Roof Area) ----- 13-16 mils\*\*  
Theo. Coverage at Proper Thickness ----- 108 - 134 sq ft/gal  
Induction Time ----- none required  
Thinner ----- TH770 finish coat  
Pot Life (1b mix @ 77 F) ----- 4 hrs  
Shelf Life ----- 1 year  
Dry Times (at 77 F)  
Set to touch ----- 2 hrs  
Tack Free ----- 6 hrs  
Dry Hard ----- 12 hrs  
Recoat ----- Overnight

#### \*\*Note:

Conditions such as moisture content and temperature of the product LOAD along with conditions of the hopper car such as venting or non-venting can effect the suitability of the system. When such conditions are encountered consult with your R.C.A. representative.

#### 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

#### DISCLAIMER

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