

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC73 SERIES EPOXY LINING

DESCRIPTION & USES

A two component, 99% volume solids, amine cured epoxy formulated for use as a flexible, direct – to – metal (DTM) protective lining for railcars. Used for dry bulk service in hopper cars carrying polyethylene, polypropylene, polystyrene plastic pellets, and food commodities (salt, sugar, flour, etc.).

Special Qualifications: 21 CFR175.300(Direct Food Contact)

SURFACE PREPARATION

BLAST: NACE #2/ SSPC-SP 10
Near White Metal Blast

PROFILE: Avg. depth 2.5 – 3.0 mils

APPLICATION SUMMARY*

EQUIPMENT: Airless 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:

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

PHYSICAL DATA

Finish ----- High Gloss
Colors -----Blue, Gray
Mixing Ratio ----- 3:1 by volume
Volume Solids ----- 99% (mixed)
VOC -----0.1 lbs/gal (9 g/l) mixed
Flash Point ----- > 200 F
Recommended Wet Film Thickness ---- 5 - 7 mils
Dry Film Thickness ----- 5 – 7 mils
Theo. Coverage at 6 mils DFT ----- 267 sq ft/gal
Thinner ----- if required, TH315
Clean up solvent TH315
Pot Life (8 gal. mix @ 77 F) 30 min to 45 min
Pot Life (8gal. mix @ 77 F thinned 10 %) 2 hrs
Shelf Life ----- 1 year

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

Set to touch -----5 hrs

Tack Free -----7 hrs

Dry Hard -----12 hrs

Recoat ----- 9 hrs

****Note: special air dry or force dry schedules are listed in the application procedure.**

SAFETY INFORMATION

Consult MSDS before use

SHIPPING DATA

Proper Shipping Name ----- Paint Liquid
Hazard Class----- Combustible Liquid
UN No. -----UN1263

***NOTE:** see detailed application instructions

DISCLAIMER

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REVISED 07/01/09