

# 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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