

# RAILCAR COATINGS *of* AMERICA

## THE RIGHT CHEMISTRY

### AC74 SERIES EPOXY LINING

#### DESCRIPTION & USES

A two component, 85% volume solids, modified epoxy formulated as a direct to metal (DTM) protective lining with excellent chemical resistance. For dry bulk service. For hopper cars carrying plastic pellets, minerals, and dry food commodities

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

#### SURFACE PREPARATION

**BLAST:** NACE #2/ SSPC-SP 10

Near White Metal Blast

**PROFILE:** Avg. depth 2.5 – 3.0 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 airbrush 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 at 85 - 90 degrees F**

**For 12 hours minimum. Perform electrical holiday test for discontinuities. If force curing, all touchup must be made before force cure**

#### Forced Dry Schedule:

**Ramp rate @ 1 deg. F/min 150 deg F**

**Soak temperature @ 6 hours**

**\*NOTE: See detailed application instructions on separate sheet before application**

#### PHYSICAL DATA

**Finish** ----- *Semi - gloss*

**Colors** ----- *White, Blue, Gray, Red*  
(other colors available)

**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** ---- *7 - 10 mils*

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

*(May be applied in 2-coats)*

**Theo. Coverage at Proper Thickness** ----- *227 sq ft/gal*

**Induction Time** ----- *none required*

**Thinner** ----- *TH315*

**Pot Life (1b mix @ 77 F)** ----- *2 hrs*

**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 backside of this page if applicable**

#### SAFETY INFORMATION

##### Combustible change below

**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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