

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC77 SERIES EPOXY LINING INTERMEDIATE

DESCRIPTION & USES

HIGH CHEMICAL RESISTANCE

A two component, high solids, flake glass epoxy formulated for use as a intermediate coat between AC71 and AC72 for a higher chemical resistant 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 ----- Gray
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 ----- 15-18 mils
Dry Film Thickness ----- 10-12 mils
*See application procedure for AC77 spray
Theo. Coverage at Proper Thickness ----- 89-107 sq ft/gal
Induction Time ----- none required
Thinner ----- TH313
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

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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