

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC 86 SERIES LINING

DESCRIPTION & USES

A two component, high solids, modified epoxy formulated for use as a protective lining with excellent resistance to molten sulfur. Formulated for high chemical resistance, heat distribution and heat dissipation. (NACE TG067)

SURFACE PREPARATION

BLAST: NACE #2/ SSPC-SP 10

Near White Metal Blast

PROFILE: Avg. depth 2.5-3.0 mils

APPLICATION SUMMARY*

EQUIPMENT: Plural component or airless 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

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 @ 85 to 90 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
- 200 F soak temperature @ 2 hours

***NOTE:** see detailed application instructions on separate sheet before application

PHYSICAL DATA

Finish ----- High Gloss

Colors ----- Off White, Blue, Gray

Mixing Ratio ----- 4:1 by volume

Volume Solids ----- 84% (mixed)

VOC ----- 1.28 lbs/gal (150 g/l) mixed

Flash Point ----- 63 F

Recommended Wet Film Thickness ---- 10-14 mils

Dry Film Thickness ----- 8-12 mils

(May be applied in 1 or 2 coats)

Theo. Coverage at Proper Thickness --112 – 168 sq ft/gal

Induction Time ----- none required

Thinner ----- TH315, TH313, TH780

Clean up solvent TH315, TH313, TH780

Pot Life (1b mix @ 77 F) 60 min

(5 g mix @ 77 F) 30 min

Shelf Life ----- 6 months

**Dry Times (at 77 F)

Set to touch ----- 4 hrs

Tack Free ----- 6 hrs

Dry Hard ----- 10 hrs

Recoat ----- overnight

**Note: special air dry or force dry schedules are listed on the backside of this page if applicable

SAFETY INFORMATION

Consult MSDS before use

SHIPPING DATA

Proper Shipping Name ----- Paint Liquid

Hazard Class ----- Combustible Liquid

UN No. ----- UN1263

DISCLAIMER

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