

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC 87 SERIES LINING PRIMER

DESCRIPTION & USES

A two component, high solids, modified epoxy formulated for use as a primer under the AC 88 Series. A multi-service, protective lining primer with excellent chemical resistance. A lining primer for corrosive immersion environments, where commodities may contain acids, alkalis, solvents and salts. Formulated for resistance to kaolin clay slurry, titanium dioxide slurry, and caustic soda

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 0.017 to 0.021 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. Topcoat with AC 88 Series.

Forced Dry Schedule: (AC87 / AC88) System

- 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 ----- Low Gloss

Colors ----- Salmon

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

Volume Solids ----- 75% (mixed)

VOC -----1.9 lbs/gal (228 g/l) mixed

Flash Point -----63 F

Recommended Wet Film Thickness ---- 7 - 8 mils

Dry Film Thickness -----5-6 mils

Theo. Coverage at Proper Thickness -201-241 sq ft/gal

Induction Time ----- 15 minutes

Thinner ----- TH313

Clean up solvent TH315 or TH313

Pot Life (1 lb mix @ 77 F) 4 hrs

(5 gallon mix @ 77 F) 1 1/2 hrs

Shelf Life ----- 1 year

**Dry Times (at 77 F)

Set to touch -----1 hrs

Tack Free -----6 hrs

Dry Hard -----10 hrs

Recoat -----12 hrs or overnight

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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