

**COATING DATA**

**DESCRIPTION:**

A two-component polyamide cured high build epoxy coating formulated for excellent resistance to corrosive and abrasive environments. This product is available in a wide range of attractive colors. It will cure to provide excellent barrier properties over a wide range of substrates and is free of lead and chromate. This product meets the requirements of the Food Safety and Inspection Service of the U. S. Department of Agriculture as chemically acceptable for use in areas where there may be a possibility of incidental food contact. This product also meets the requirements of ANSI/AWWA D102-06 OCS-5 for first coat and intermediate coat and OCS-6 intermediate coat.

**Armorguard Polyamide Semi-Gloss Epoxy**

- Dries to a semi-gloss finish.
- Available in a wide range of attractive colors.
- Excellent chemical resistance.
- Excellent resistance to aliphatic and aromatic hydrocarbons.
- Lead and chromate free.
- Complies with U. S. EPA National Volatile Organic Compound (VOC) Emission Standards for industrial maintenance coatings effective September 13, 1999.
- Very high performance. See Armorguard System Data Sheet.
- Performs well in many aggressive environments including the following substrates:  
Concrete subjected to high humidity or condensing moisture
  - Structural steel
  - Floors
  - Piping
  - Equipment and machinery
  - Storage tanks

**USE:**

As the intermediate or finish coat on properly primed steel surfaces. This product may be topcoated with Induron Indurethane Enamels. May be used over Induron Polyfill Epoxy Block Filler or directly on fully cured concrete surfaces.

**LIMITATIONS:**

Do not use for surface temperatures above 200°F (93°C). Not for potable water immersion.

**SURFACE PREPARATION:**

**Steel (Non-Immersion)**—For best results, SSPC-SP 6 Commercial Blast and remove all surface contaminants. Prime with Armorguard P 14 Primer, Perma-Clean II Primer, Z-Rep 56 Primer, or other recommended Induron primers. For steel that is power tool cleaned, or for rusted steel, prime with Induron Induramastic 85.

**Steel (Immersion)**—Use SSPC-SP 10 Near White Blast. Prime with Armorguard P 14 Primer.

**Aluminum**—Prime with Induron Vinyl Wash Primer.

**Galvanized Steel**—Prime with Induron Vinyl Wash Primer.

**Concrete Construction**—New concrete must cure at least 30 days prior to painting. Remove all surface contaminants. For best results, use SSPC-SP 7 Brush Off Blast to clean surface. Do not apply over oil or form release agents.

## COATING DATA (Cont)

**Concrete Floors**—New construction must cure at least 30 days prior to painting. Prepare surface with acid etch or abrasive blast. For best results, apply a first coat of Armorguard Polyamide High Gloss or Semi-Gloss Epoxy thinned up to 50% as a primer and follow with one or two full coats of the Armorguard Finish, High Gloss or Semi-Gloss.

### COVERAGE:

Theoretical—882 ft<sup>2</sup> per gallon at 1.0 mil dry film thickness.

### DRY FILM THICKNESS:

3.0 to 6.0 mils per coat.

### WET FILM THICKNESS:

5.5 to 11.0 mils.

## APPLICATION DATA

### BLEND RATIO:

One part Armorguard Base to one part Armorguard Polyamide Epoxy Blending Resin. Power agitate until components are thoroughly mixed. Allow mixed components to stand fifteen minutes prior to application.

### POT LIFE:

Six hours at 80°F, decreasing at higher temperature.

### APPLICATION:

**Airless Spray**—Use .015-.019 tip; 60 mesh filter; 30:1 pump ratio at 60-100 psi operating air pressure.

**Conventional Spray**—Follow instructions of equipment manufacturer for the application of epoxy paints.

**Roll**—Use lambswool cover. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

### THINNING:

If required, thin up to 10% with K-1066 Reducer. Clean equipment with K-1066 Reducer.

### CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dewpoint for a period of at least two hours after application to avoid condensation occurring on wet paint.

### DRY TIME:

TO HANDLE—7 hours at 80°F.

TO RECOAT—50°F or higher, overnight; 40°F-50°F, second day.

IMMERSION SERVICE—50°F or higher, seven days with proper ventilation; 40°F-50°F, 14 days with proper ventilation. Ventilation during application and after must be in accordance with AWWA D102-97 Section 4.7.3.

**Note:** High film thickness, low temperature and/or poor ventilation will retard dry time.

### PHYSICAL DATA:

VOLUME SOLIDS: 55% ± 1%

SOLIDS BY WEIGHT: 71% ± 1%

WEIGHT PER GALLON: 10.9 ± .2 lbs/gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 3.2 lbs/gallon; < 380 grams/liter

Mixed thinned 10% - < 3.5 lbs/gallon; < 420 grams/liter

**SAFETY DATA:** See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.