

COATING DATA

DESCRIPTION:

A high build, surface-tolerant, semi-gloss epoxy coating formulated for excellent resistance to corrosive and abrasive environments. This product is available in a wide range of attractive colors and is formulated for excellent adhesion to clean steel, rusted steel, weathered galvanized steel, wood, concrete, and most existing cured coatings. This product meets the requirements of ANSI/AWWA D102-03 OCS-5 for first coat and intermediate coat and OCS-6 intermediate coat. Complies with U. S. EPA Ozone Transport Commission (OTC) for Volatile Organic Compounds for VOC Emission Standards for industrial maintenance coatings.

PERFORMANCE:

SYSTEM: One coat Induraguard at 6.0 mils Dry Film Thickness

TEST	METHOD/CONDITIONS	SUBSTRATE	RESULTS
ADHESION	ASTM D 3359 Method B	Hot Rolled Steel Rusty Steel Aged Alkyd Coating	5 Rating, No Failure 5 Rating, No Failure No Wrinkling or lifting, 5 Rating, No Failure
SOLVENT RESISTANT	Methyl Ethyl Ketone		75 Double Rubs. No Softening
IMPACT RESISTANT	ASTM D 2794	Hot Rolled Steel	Pass 90 in./lbs.
HARDNESS	ASTM D 336		4H
SALT SPRAY	ASTM B 117 (Scribed)		1,000 Hours, No effect < 1/16" Undercut @ Scribe

USE:

This product is especially designed to provide long-term protection to primed, unpainted or previously painted steel. It may be used to extend the life of structures previously painted with lead and chromate containing coatings and thus avoid the generation of toxic by-products that sandblasting would entail. This product is ideal for protecting and extending the life of metal buildings, fences, piping, process equipment, tanks, bridges and structural steel.

RECOATABILITY:

Induraguard may be used as a single coat, recoated with itself or topcoated with Induron Perma-Clean II Epoxy, Induron Armorguard Epoxy, Induron Indurethane, or Induron Aquanaut® finishes.

SURFACE PREPARATION:

Steel (Non-Immersion)—For best results, SSPC-SP 6 Commercial Blast and remove all surface contaminants. Prime with PE-70 Epoxy, RC-70 Epoxy, Perma-Clean II Primer, Indurazinc MC-67, or other recommended Induron primers. **Steel (Immersion)**—Use SSPC-SP 10 Near White Blast. **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. **Corroded Steel (Non-immersion)**—Remove loose rust scale and poorly adhered old paint using water blast and/or hand and power tools. Remove oil and grease per SSPC-SP 1 Solvent Cleaning. For severe industrial exposures, a brush off blast cleaning is recommended. **Old Paint**—Remove all peeling and poorly adhered paint using water blast and/or hand and power tools. Remove oil and grease per SSPC-SP 1 Solvent Cleaning. A test patch is recommended over existing coatings.

LIMITATIONS:

Not recommended for dry service temperatures exceeding 200°F, or immersion service at temperatures exceeding 120°F. Do not use when substrate temperature is below 45°F.

COVERAGE:

Theoretical—1,171 ft² per gallon at 1.0 mil dry.

DRY FILM THICKNESS:

3.0 to 7.0 mils per coat.

WET FILM THICKNESS:

4.1 to 9.6 mils.

APPLICATION DATA**BLEND RATIO:**

One part Induraguard Part A to one part by volume Induraguard Part B. Blend components thoroughly using power agitation. Allow components to stand 15 minutes prior to beginning application.

POT LIFE:

Three hours at 90°F.

APPLICATION:

Airless Spray—Use 0.015-0.017 tip; 30:1 Pump ratio at 80-100 psi operating air pressure. **Conventional Spray**—Follow equipment manufacturer's instructions for the application of epoxy coatings. **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:

For airless spray applications, use unthinned. If required, thin up to 10% with Induron K-1012 Industrial Thinner.

CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 45°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—18 hours at 80°F

TO RECOAT—48 hours or second day at 45°F to 55°F; 24 hours or overnight above 55°F. **Note:** Lower temperature, higher film build, and/or poor ventilation will retard dry time.

PHYSICAL DATA:**COLORS**

VOLUME SOLIDS: 75% ± 1%

SOLIDS BY WEIGHT: 85% ± 1%

WEIGHT PER GALLON: 11.3 ± 0.5 lbs/gallon (mixed)

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.0 lbs/gallon; < 240 grams/liter

Mixed thinned 10% - < 2.4 lbs/gallon; < 290 grams/liter

SAFETY DATA:

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