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## COATING DATA

### DESCRIPTION:

A two-component, high solids, chemical and corrosion resistant epoxy coating formulated to provide excellent protection to a variety of substrates in corrosive environments. This product uses a special modified polyamidoamine curing agent which imparts the best properties of both amines and polyamides. Perma-Clean 3 is part of a system which includes Perma-Clean 3 Primer and Perma-Clean 3 High Gloss Epoxy Finish. Use these together to provide maximum corrosion protection. Topcoat with Induron 6600 Indurethane Plus or Permastic Polyurethane finishes for exterior exposure. 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 Outside System No. 5 for first and intermediate coat.

Perma-Clean 3 High Gloss Epoxy
<ul style="list-style-type: none"><li>• High build epoxy coating which can be applied to provide up to 6 dry mils per coat.</li><li>• Complies with South Coast Air Quality Management District (SCAQMD) for Volatile Organic Compounds for VOC Emission Standards for industrial maintenance coatings</li><li>• Performs well in many aggressive corrosive environments including the following:<ul style="list-style-type: none"><li>➢ Concrete floors. Swimming pools and natatoriums.</li><li>➢ Immersion in neutral, alkaline, and salt solutions.</li><li>➢ Immersion in water.</li><li>➢ Immersion in concentrated caustic solutions.</li><li>➢ Acid fume, splash, and spillage.</li><li>➢ Immersion in aliphatic petroleum hydrocarbon solvents.</li></ul></li></ul>

### USE:

To protect carbon steel, non-ferrous metals, concrete, masonry, wood or drywall substrates from chemical and corrosion attack. Use in corrosive environments that include abrasion, moisture, corrosive fumes, chemical contact, and immersion. Ideal for use in chemical processing, power, offshore, petrochemical, food, beverage, pharmaceutical, pulp and paper mills, water/wastewater plants and others.

### LIMITATIONS:

Do not use for immersion service above 120°F (49°C) or dry heat above 200°F (93°C). Not recommended for immersion in concentrated solutions of mineral acids or organic acids. Not for potable water.

### SURFACE PREPARATION:

**Steel (Immersion in water)** - SSPC-SP 10/NACE 2 Near-White Blast Cleaning. (**Chemical immersion**) - SSPC-SP 5/NACE 1 White Metal Blast Cleaning

**Steel (Non-Immersion)**—SSPC-SP 6/NACE 3 Commercial Blast Cleaning.

**Ductile Iron**—Remove all surface contaminants by abrasive blasting per NAPF 500-03-04. Do not coat surfaces previously coated with asphalt.

**Concrete**—New concrete must cure for at least 28 days. Verify dryness by testing for moisture per “ASTM D4263 Plastic Sheet Method”. Apply to clean, dry and sound concrete substrates that are free of all curing compounds, oils, greases or any other contaminants. All concrete surfaces shall be made free of voids, cracks and other imperfections using Induron EFS 707 Epoxy Surfacer or Induron Mortarchem. Prepare the surface per ICRI 310.2 to achieve surface profile to meet a CSP 3-4.

**Recoating**—Multicoat systems may require this product to be recoated. This product does not require scarifying the surface prior to being recoated with itself and many other Induron epoxies. Before recoating, remove all chalk and any other surface contaminants.

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

Compatible primers include Perma-Clean 3 Primer, Indurazinc MC-67, Indurazinc MC ONE 67, Induramastic 85, and others. Topcoat with Induron 6600 Indurethane Plus or Permastic Polyurethane finishes for exterior exposure. **Note:** For steel that is Power Tool Cleaned, or rusted steel, prime with Induramastic 85 or E-Bond 100.

**COVERAGE:** Theoretical—962 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:** 6.0 to 10.0 mils.

## APPLICATION DATA

### BLEND RATIO:

One part Perma-Clean 3 Epoxy Activator to four parts Perma-Clean 3 Epoxy Base. Power agitate until components are thoroughly mixed. Allow mixed components to stand fifteen minutes prior to application.

### POT LIFE:

4 hours @90F, 8 hours @70F, 12 hours @50F.

### APPLICATION:

**Airless Spray**—Use .017-.019 tip; 60 mesh filter; 30:1 pump ratio at 80-100 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-1017 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 - 5 hours @90F, 10 hours @70F, 18 hours @50F.

TO RECOAT - 50°F or higher, over-night; 40°F to 50°F, second day.

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

**Note:** E-60 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure. See E-60 Technical Data Sheet for more information.

### PHYSICAL DATA:

VOLUME SOLIDS: 56% ± 1%

WEIGHT PER GALLON: 13.5 ± .2 lbs per gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 0.8 lbs/gallon; < 100 grams/liter

Mixed thinned 10% - < 0.8 lbs/gallon; < 100 grams/liter

HAPS:

Mixed unthinned – 0.34 lbs/gallon solids

Mixed thinned 10% - 0.34 lbs/gallon solids

### SAFETY DATA:

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