



ESTABLISHED 1935

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Technical Bulletin

CSE-6200 Epoxy Coating

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General Description: A two component cold set micaceous iron oxide filled epoxy coating cured with an accelerated amine adduct.

Intended Usage: HERESITE CSE-6200 material is an ambient cure (70°F) multipurpose extremely resistant epoxy coating designed for use in tank trailers, railcars, storage tanks, secondary containment or wherever highly corrosive chemical atmospheres are likely to be encountered.

FDA Status: *This material meets the requirements of 21 CFR 175.300 for direct food contact.*

Physical Data:

VOC: As Supplied

2.80 lbs. /gal. (336 gm/L)

Thinned 15% with S-406:

3.40 lbs. /gal. (407 gm/L)

Solids: 60.49 % by volume
76.03 % by weight

Coating Density: Part A: 11.83 lbs. /gal.
Part B: 8.93 lbs. /gal.
Mixed: 11.69 lbs. /gal.

Thinning Solvent Density: S-406: 7.35 lbs. /gal.

Approximate Shipping Weights:

CSE-6200: 16 lbs. per 1 gallon kit

64 lbs. per 5 gallon kit

S-406: 9.5 lbs. per 1 gallon

41 lbs. per 5 gallons

Colors: 6206 = gray matte finish, 6208 = ivory matte finish, 6204 = brown matte finish, other colors available on request

General Chemical Resistance: This coating has excellent resistance to alkaline material, water and solvents. The following is a brief listing of the chemical resistance

- Methyl Ethyl Ketone
- Gasoline
- Xylene
- 50 % Sodium Hydroxide
- Diacetone Alcohol

(For complete listing see a Heresite Chemical Resistance Guide or contact Heresite Protective Coatings).

Key Feature: When applied with adequate ventilation, CSE-6200 can be applied in two coats in one day with only a one hour recoat time. In most cases, depending on temperature of the commodity, this coating this coating can be placed into service 24 hours later,

Coverage: Theoretical coverage is 970 square feet per gallon per mil. This equates to 65 square feet per gallon at 12 mils dry film thickness with a 20 % loss factor.

Shelf Life:

2 years from the date of purchase at 70°F (21°C)

Pot Life: 1.5 hours @ 70°F (21°C)

Abrasion Resistance: 104 mg. weight loss per 1,000 cycles cs-17 wheel with 1,000 gram weight.

Flexibility: Passes ½ inch on a Mandrel Bend Test

Temperature Limits:

CSE-6200 accepts up to 250°F (121°C) depending on service environment.

Recommended Total DFT: 12 to 15 mils (300 - 375 microns). This can be accomplished in a two coat application at 75°F (24°C). A third coat may be necessary with cooler application temperatures. Approximately 10 wet mils will achieve 6 dry mils.

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

CAUTION: CONTAINS FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIR LINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRICAL EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.

Surface Preparation - Steel:

Immersion: A white metal blast in accordance with NACE #1 or SSPC-SP-5 Specifications.

Non-immersion: A commercial blast is acceptable in accordance with NACE #3 or SSPC-SP-6 Specifications.

Surface profile or anchor pattern should be 20-25% of the recommended dry film thickness.

Concrete: Remove protrusions by sanding or grinding. Concrete must be cured at 70°F (21°C) and 50% relative humidity for 28 days.

Immersion: Dry abrasive blast to open all voids. Blow or vacuum off residue

Non-Immersion: Surface must be acid etched or abrasive blasted to remove laitance.

Equipment

Agitated Spray Equipment is Preferred

1. All spray equipment shall be thoroughly cleaned and free of old paint film and other contaminants.
2. Use Conventional or Airless type spray guns.
3. Air supply shall be free of oils and water.
4. Airless spray equipment: 1800-2200 PSI liquid pressure. Tip size from .017" to .021 thinning is less than required for conventional spray.

Primer: Self priming on steel. On concrete, a prime coat of this material applied at a thinner viscosity is suggested.

Application Viscosity:

Recommended spraying viscosity of 35 seconds drain time on a #2 Zahn should be achieved at 15% thinning with S-406. Thinning amount will vary from batch to batch and spray equipment used.

Mixing: Stir Part A thoroughly, then stir Part B thoroughly. Add the contents of Part B into the container of Part A. Mix thoroughly then add thinner to achieve the desired spraying viscosity. Material should be sprayed immediately after mixing the two components and thinning. Mixed material must be used within 1.5 hours @ 70°F (21°C).

Mix Ratio: 20 Parts A to 1 Part B by volume.

Thinning: Suggested thinning is 15% with HERESITE S-406 solvent.

Application - NOTE: Due to the use of micaceous iron oxide, material should be kept agitated during application.

1. Do not apply if the temperature is less than 5°F (2°C) above the dew point.
2. Adjust the air pressure to approximately 80 pounds pot pressure. Adjust spray gun by first opening liquid valve and then adjust air valve to give approximately an 8-12 inch fan.
3. Holding gun perpendicular to the surface at a distance of 12 inches, apply a mist bonding pass.
4. Allow to flash off for several minutes, but not long enough to allow film to completely dry.
5. Apply 3 to 4 criss-cross multi passes maintaining a wet appearing film.
6. Repeat Step #5 until desired film thickness is obtained.
7. Clean equipment with HERESITE S-330 solvent or S-406 thinner.
8. Let first coat dry with ventilation for approximately one (1) hour at 70°F (21°C).
9. For second coat, repeat Steps 1 through 7.
10. Coating should be fully cured in 24 hours at 70°F (21°C), with adequate ventilation.