



ESTABLISHED 1935

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TECHNICAL BULLETIN

HERESITE EB-6817 December 2008

GENERAL DESCRIPTION: Two component, high solids baked epoxy formulated to resist high alkaline chemicals and higher temperatures.

INTENDED USAGE: EB-6817 coating is a low bake epoxy coating primarily designed for use in tank trucks, railcars, storage tanks, ISO tanks, or where highly alkaline chemicals are present such as 73% caustic soda at 250°F.

PHYSICAL DATA:

Temperature Resistance:

Dry Heat: 325°F (163°C) with short term resistance to temperature excursions to 400°F (204°C).

VOC: as supplied

0.63 lbs. /gal. (75.5 gm/L)

Thinned 15% with S-330

1.42 lbs. /gal. (170.2 gm/L)

Solids

90.61% by volume

94.45% by weight

Coating Density

Part A: 12.53 lbs. /gal.

Part B: 8.33 lbs. /gal.

Mixed: 11.36 lbs. /gal.

Thinning Solvent: S-330

Approximate Shipping Weights:

EB-6817: 13 lbs. per 1 gal. kit; 66 lbs. per 5 gal. kit

S-330: 8 ½ lbs. per 1 gal. 38 lbs. per 5 gal.

Standard Color: Tan

GENERAL CHEMICAL RESISTANCE:

This coating has excellent resistance to 73% caustic solutions at temperatures to 250°F (121°C) without the use of MDA.

<u>Exposure</u>	<u>Immersion</u>	<u>Splash & Spillage</u>
Acids	Fair	Good
Alkalies	Excellent	Excellent
Solvents	Good	Excellent
Inorganic Salts	Excellent	Excellent
Water	Excellent	Excellent

Please consult the Chemical Resistance Guide, Sales Representative, or the Manufacturer for your specific requirements.

Coverage: Theoretical coverage is 1,453 square feet per gallon per mil. (At 13 mils DFT average coverage would be 89 square feet per gallon. This includes a 20% loss factor.) The recommended total dry film thickness is as follows:

<u>Environment</u>	<u>Dry Film Thickness</u>	<u>No. of Coats</u>
Immersion	12 - 15 Mils	2
Highly Corrosive Fumes	12 - 15 Mils	2
Mild Corrosive Fumes	7 - 10 Mils	2

Abrasion Resistance: 50 mg weight loss per 1000 cycles cs-17 wheel with 1,000 gram weight.

Flexibility: Passes 1/2 inch on a Mandrel Bend Test

Shelf Life:

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

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: Not Applicable

Equipment:

1. All spray equipment shall be thoroughly cleaned and free of old paint film and other contaminants.
2. Use standard type spray guns.
3. Air supply shall be free of oils and water.
4. Airless spray equipment: 2400-2800 psi liquid pressure. Tip size from .017" to .021" thinning requirements are less than required for conventional spray.

Mixing: Stir Part A thoroughly, then stir Part B thoroughly. Add the contents of Part B to the container of Part A. Mix thoroughly then add thinner to achieve the desired spraying viscosity. Allow the mixed material to age 30 minutes before using. Mixed material must be used within 6 hours.

Pot Life: 6 Hours @ 70°F.

Mix Ratio: Kits are shipped in correct proportion, if smaller quantity is required, ratio is:
100 parts A to 12 parts B by weight
100 parts A to 38.6 parts B volume

Application Viscosity: When thinned at 15% with Heresite S-330 solvent, a spraying viscosity of 35 seconds drain time on a Zahn #2 cup can be achieved. The amount of thinner required may vary slightly batch to batch.

APPLICATION:

1. Do not apply if the temperature is less than 5°F (2°C) above the dew point.
2. Adjust air pressure to approximately 80 pounds at the gun and provide 15 - 20 pounds pot pressure. Adjust spray gun by first opening liquid valve and then adjust air valve to give approximately 8-12 inch fan.
3. Hold the 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 immediately with HERESITE S-330 solvent.
8. Let first coat dry with ventilation for approximately 10-16 hours at 70°F (21°C), but not longer than 72 hours.

INTERMEDIATE BAKING IS NOT REQUIRED BETWEEN COATS

9. For second coat, repeat Steps 1 through 7

Final Cure Schedule

10. Air dry final coat with ventilation for approximately one hour prior to introducing heat. After the air dry period has elapsed, the temperature should be raised approximately 40°F (22°C) in increments of 30 minutes until the desired metal temperature is reached.
175°F (75°C) - 12 hours
250°F (121°C) - 4 hours *

* Best Chemical Resistance at Higher Bake Temperature

EB-6817

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