



TECHNICAL BULLETIN

EB-6917

December 2008

HERESITE EB-6917 BAKED EPOXY COATING

(Low VOC's)

EB-6917 is available in 1 gallon & 5 gallon kits.

GENERIC TYPE: A two packaged high solids baked

RECOMMENDED USAGE HERESITE EB-6917 is specially formulated for immersion or industrial maintenance applications. It provides outstanding chemical resistance to a wide range of alkalis, salts, petroleum products, and other aqueous solutions.

The EB-6917 epoxy coatings are excellent for hot caustic service in concentrations to 73%. Please contact your representative for a recommendation regarding your specific operating conditions.

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	Good	Excellent
Alkalis	Excellent	Excellent
Solvents	Good	Excellent
Inorganic Salts	Excellent	Excellent
Water	Excellent	Excellent

ORDERING INFORMATION

SHIPPING WEIGHT:

EB-6917: Approx. 13 lbs. / gal.
S-330 Solvent Approx. 8 1/2 lbs. / gal.

FLASHPOINT: EB- 6917, 23°F (-5°C)
S-330 Solvent, 23°F (-5°C)

PRIMER:
Not Required

PACKAGING:

SHELF LIFE:

24 months at 70°F in unopened containers

POT LIFE:

24 hours at 70°F

PHYSICAL DATA:

Solids by Weight: Approximately 94%
Solids by Volume: Approximately 88%
Viscosity: 75 Krebs Units
Flexibility: Passes Zuhr conical Mandrel
1/2" bend

Temperature Limitation: Dry heat up to 325°F (163°C). Temperature excursions up to 400°F (204°C) can be tolerated for short durations.

Standard Color: Tan

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
Maintenance	6 - 8 Mils	1

SURFACE PREPARATION:

Remove all oil, grease, and other contaminants. All seams should be continuously welded, weld splatter removed and all edges radiused. (See Bulletin No. 113, "Fabrication Specifications.")

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.

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: 1500-1800 psi liquid pressure. Tip size from .015" to .019" Thinning requirements are less than 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 and allow the mixed material to age 30 minutes before using. Mixed material must be used within 24 hours.

Primer: Self priming on steel.

Thinner: The type and amount of thinner required is dependent upon temperature, ventilation, humidity, spray equipment used, and desired film thickness. Suggested thinning at 75°F (24°C) is 10 - 20%. HERESITE S-330 solvent is recommended for normal applications.

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.
NO INTERMEDIATE BAKING IS REQUIRED BETWEEN COATS
9. For second coat, repeat Steps 1 through 7
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.
11. Coating should be final cured according to following schedule.
175°F (75°C) - 12 hours
250°F (121°C) - 4 hours *

* Best Chemical Resistance at Higher Bake Temperature

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