

Heresite EP-6300 Series

Our 50 years of coating history speaks for itself.

In 1964, Heresite was the first company to apply coatings to aluminum-finned, copper-tubed heat exchangers. The Heresite coating became then, and still remains a standard in the industrial coatings industry. We provide the highest quality protective coatings for air conditioning and refrigeration systems that operate in moderate to severely corrosive environments, including both coastal and/or industrial applications.

A high performance epoxy phenolic coating.

EP-6300 series is a high performance coating capable of providing protection in severe and chemically corrosive environments. It is formulated explicitly for sustained immersion for tank linings, heat transfer equipment, spiral heat exchangers, fans, blowers, filter plates, tank cars, tank trailers, duct work, exhaust hoods, and other industrial equipment.

Product Description

Baking cross-linked epoxy phenolic

Recommended Uses

Heresite EP-6300 series is a high performance coating capable of providing protection in severe and chemically corrosive environments. It is formulated especially for sustained immersion for tank linings, heat transfer equipment, spiral heat exchangers, fans blowers, filter plates, tank cars, tank trailers, duct work, etc.

Chemical Resistance

EP-6300 series is chemically resistant to a wide range of acids, solvents, and inorganic salts. Please review chemical resistance guide for further information.

Packaging Information

EP-6300 series is available in one gallon, five gallon and 54 gallon drum quantities.

Thinners and Cleanup

Recommended use of Heresite S-330

Storage Conditions

Coating should not be stored longer than 12 months. Coating should be stored in a clean, dry environment at 50-75°F. Keep out of direct sunlight. Avoid excessive heat and keep from freezing.



Physical Properties

Solids by weight: Approximately 52% clear, 62% pigmented
Solids by volume: Approximately 42% clear, 44% pigmented
Pot life: NA 1 component
Induction Time: NA
Mixing Ratio by Volume: NA
Color: EP-6300 Clear, EP-6379 Maroon

VOC Content

Clear: 4.18 lbs/gal (501 g/L) as supplied
Maroon: 3.84 lbs/gal (460 g/L) as supplied

Film Thickness

For immersion service, a 3-4 coat system is required to achieve 5 – 7 mils (125 – 175 microns).

Coverage

Theoretical coverage is approximately 675 square feet per gallon per dry mil. Coverage rates are estimates and make no allowance for material loss. Actual rates will vary dependent on application method, surfaces, etc.

Surface Preparation

All surfaces must be clean, sound, and free of any oils, dirt, grease, wax and any other contamination that may interfere with coating adhesion. For best results all bare surfaces must be properly prepared prior to application of this product.

It is recommended a commercial blast is acceptable in accordance with NACE #1 or SSPC-SP-5 specifications. Surface profile or anchor pattern shall be 20-25% of the recommended dry film thickness.

Thinning

Reduce EP-6300 series with S-330 solvent to 25 to 30 seconds on Zahn Cup #2. This requires approximately 20-30% dilution by volume.

The amount of thinner required is dependent upon temperature, ventilation, humidity, application type and desired film thickness.

Spray Application

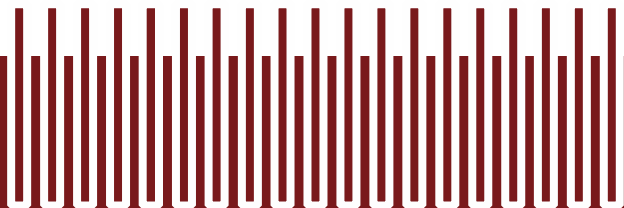
1. Consult SDS prior to use.
2. Do not apply if temperature is less than 5°F above dew point, or if temperature is below 45°F.
3. Use standard production type spray equipment (conventional, HVLP, airless, etc.). A few starting recommendations can be found below:

<u>Guns</u>	<u>Fluid</u>	<u>Air</u>
DeVilbiss JGA-510	E	46MP
Binks #2100	67-SS	46-21MD-2 or 3
Binks #95	66-SS	66-SD

Graco Air Pro HVLP

Airless spray equipment, 1500-1800 psi liquid pressure. Tip size from 0.013" to 0.018".

4. Spray viscosity will be dependent on type of equipment being used. It has been seen that spraying at dip viscosity is very effective.
5. Spray equipment: always flush spray equipment with solvent to clean prior to applying coating.



6. Air supply must be uncontaminated. Adjust air pressure to approximately 80 pounds at the gun and provide 15-20 pounds at pressure pot. Adjust spray gun by first opening liquid valve and then adjust air valve to give approximately an 8"-12" fan, holding gun perpendicular to the surface at a distance of 12".
7. Apply a mist bonding pass.
8. Allow to flash off for approximately a minute, but not long enough to allow film to completely dry.
9. Apply 3-4 crisscross multi-passes maintaining a wet appearing film approximately 3-4 wet mils. This will achieve a dry film thickness of approximately 1.5-2.0 mils.
10. Air dry a minimum of 60 minutes with ventilation prior to introducing heat.
11. Typically, a three to four coat process is required to achieve 5.0 to 7.0 mil DFT. An intermediate bake is required between each coat, allowing to cool to room temperature before next coat is applied – see baking schedule.

Bake Schedule

Intermediate Bake:

1. 93-121°C (metal temperature) held for 10-20 minutes

Final Bake:

1. Raise the temperature approximately 22°C in increments of 30 minutes until 205°C (metal temperature) has been reached. Hold 205°C for 1 hour.
2. To determine correct bake, saturate a cloth with S-330, rub coating lightly. Coating should wipe off between coats, but should not after final bake (cure).

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 WORKERS MUST WEAR FRESH AIR LINE RESPIRATORS. 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, WORKMERS SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.**

To the best of our knowledge the technical data contained herein are true and accurate at the date of issuance and are subject to change without prior notice. No guarantee of accuracy is given or implied. We guarantee our products to conform to strict quality control. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, is limited to replacement of products. Prices are subject to change without prior notice. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY THE SELLER, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.