

SELECTION & SPECIFICATION DATA

Type	Epoxy Paste/Caulk
Description	DMVEVSBSeFW9dSVW[eSfi aZJa_ ba` Wf#` " , ea fVefcbi WZYdSVWbaj k eVBS` fS` V LaSf[YZ DMVEVSBSeF9dSVWZSeVjUWVWfUWZ_ [US^dVefS` UW fa Si [VWdS` YWaxbVWchUZV_ [US^dXgWch adS` [U [adS` [USUjVeS` V S]S[eZDMVEVSBSeF9dSVWZSeS ^a` Y dVLaSfi [Vai i Z[LZ S^ai e[f fa TWfabZJaSfW gb fa #&VSkd VbWVW[Y a` fV_ bVdSfgdVZDMVEVSB^ BSeF9dSVWAd_eSf[YZfTa` V fa_ S` k egdSUW [UgV[Y La` UdVWVefS[^VeeFVW_ VVS^XTVW^See S` Vi aaVz
Features	<ul style="list-style-type: none"> • #` " , ea fVd HA5 8dWV • 9dVsf XadhWf[US^dVbS[de • @a eZd`]SYWVjbs` eja` adV[efad[a` • EVSe VSe] i [fZ cg[U] dVgd fa eVh[UW • 4a` VeUZV_ [US^k S` V_ WZS` [US^k fa fZW egTefcSfW
Uses	<ul style="list-style-type: none"> • 5aa f` Y Fai Vb • DMV[[eZ 6S_ SYWV EgdSUW • >Vb] DVbS[d • FS`] >[f` Ye • : [YZ efdVYfZ efdjUfgdS^SVZVchWAd_ VVS^ Ta` V[Y
Color	Light gray
Finish	Matte
Primer	Self-priming
Solids Content	100% by volume

SUBSTRATES & SURFACE PREPARATION

All	Substrate must be clean, dry and free of contaminants.
Steel	<p>Immersion: SSPC-SP 10/NACE 2 Near White Metal Blast with angular profile of 2.5 – 3.5 mils.</p> <p>Non-immersion: SSPC-SP 6/NACE 2 Commercial Blast with angular profile of 1.5 – 3.0 mils, SSPC-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.</p>
Weld Repair	Use a flame to sweat out oil from deeply impregnated surfaces. Stabilize cracks by drilling the extremities. Long cracks should be drilled, tapped and bolted every few inches. Vee-out all cracks using a file. Degrease using clean rags.

MIXING & THINNING

Mixing Do not mix partial kits. To mix small kits, transfer the entire contents of resin and hardener onto the plastic mix board. Mix thoroughly together until color of material is uniform and free of any streaks. To mix large kits, combine resin and hardener and mix with a mechanical mixer.

Thinning	Do not thin.
Pot Life	45 minutes in 8 fl oz mass at 77°F (25°C)
	Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.
Cleanup	MEK or Acetone

APPLICATION GUIDANCE

Conditions	Surface should be at least 50°F (10°C) and relative humidity not to exceed 90%. Maximum substrate temperature should be kept to 140°F (60°C). Contact ErgonArmor for conditions where the substrate temperature exceeds 140°F (60°C).
Application	Apply directly onto the prepared surface with the spreader or mixing knife provided. Press down firmly to remove entrapped air, fill all cracks, and ensure maximum contact with the surface. Use reinforcement cloth over holes and cracks. Fully machinable using conventional tools once cured.
Brush & Roller	Brush or roller can be used to smooth uncured surface with solvent if desired.

CURE SCHEDULE & RECOAT WINDOW

TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN-TO-SERVICE (HYDROCARBON IMMERSION)
50°F (10°C)	12 hours	14 days	7 days
77°F (25°C)	3 hours	14 days	24 hours
140°F (60°C)	1 hour	7 days	4 hours

Return-to-service will vary with chemical exposure. Consult with ResTech Technical Service for guidance.

Tack free at 77°F (25°C) ASTM D1640	3.5 hours for 25 – 30 mil DFT
Dry hard at 77°F (25°C) ASTM D1640	8 hours for 25 – 30 mil DFT

SAFETY

Safety	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.
Ventilation	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

ESTIMATING & HANDLING

Theoretical Coverage

12.8 square feet per gallon at 125 mils. Allow for loss in mixing and application.

Storage & Shelf Life

Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 24 months when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions. Do not store below 40°F (4°C) or above 110°F (43°C). If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with ResTech.

TYPICAL PHYSICAL PROPERTIES

PROPERTY	VALUE
Dry adhesion ASTM D4541 Blasted steel 1 coat	>2,850 psi (20 MPa)
Flash point	Greater than 250°F (121°C)
Specific gravity	Part A: 1.36 Part B: 0.82
VOC	0 lb/gal (0 g/L)
Density	Part A: 11.3 lbs/gal (1.35 kg/L) Part B: 6.8 lbs/gal (0.81 kg/L)

SERVICE TEMPERATURE

SERVICE	TEMPERATURE
Dry	250°F (121°C)
Splash/spill	200°F (93°C)
Immersion	150°F (65°C)

Temperature limitations will vary with chemical exposure. Consult ResTech Technical Service for guidance.