



Pruett-Schaffer
Coatings for a Green World
412-771-2000

www.pruett-schaffer.com

PRODUCT NUMBER **PRODUCT NAME**
11-SERIES **HEAT, CHEMICAL, & ABRASION RESISTANT EPOXY COATINGS**

GENERAL DESCRIPTION

Pruett-Schaffer's 11-Series coatings are low gloss, solvent based, two component amine-cured epoxy phenol novolacs. For best results, apply by air assisted or airless spray. Other methods will take more coats to achieve desired film thickness. Epoxy-Phenolic coatings serve as high performance linings or maintenance coatings for use over a wide variety of substrates that are subjected to extremely hostile environments.

RECOMMENDED USES

11-Series epoxies are premium, heavy duty, corrosion preventative, industrial maintenance coatings, and should only be applied by professionals. They are recommended for use on substrates exposed to chemical splash or mist, heat or steam, solvents, acid or alkali, water, salt, oils, and fuels. These coatings have excellent adhesion, exterior durability (but chalk), and abrasion resistance (if heat cured). The in-service temperature limit is 400 °F, wet or dry. They are very high in solids, allowing a thicker film build in one pass without sagging; and perform well over hard to protect sharp edges and complex geometric shapes.

SURFACE PREPARATION

For severe service, metal substrates should be degreased and blasted to SSPC-SP-10 white metal blast, 1.5 ± 0.5 mil profile. An SSPC-SP-6 commercial blast may be used where conditions are less aggressive.

MIXING INSTRUCTIONS

Thoroughly mix 4 parts by volume A component with $\frac{3}{4}$ part 11-B Hardener. Box while mixing at slow speed to avoid entraining air into the paint. Use at once, there is no induction time. Do not reuse previously used mixing containers; partially cured material will greatly accelerate the cure of the freshly mixed paint resulting in dramatically reduced pot life. Clean mixing blade after each use.

THINNING

Under normal conditions no thinning is necessary. If desired, thin with xylol. Add a little at a time with constant gentle agitation to a maximum of 5% by volume.

APPLICATION EQUIPMENT

Airless or air-assisted airless is the preferred method of application & will result in the best appearing finish. Use .015-.017 inch spray tip size. The recommended dry film build per coat is 5 $\frac{1}{2}$ to 8 mils when sprayed, which will yield a 4 to 6 mil dry film in one pass. Recoat if desired for higher film builds and better protection. They may be applied by brush or roller with 1/4 " nap or less.

CURING TIMES & TEMPERATURES

Air dries set-to-touch in 3 hours and tack free in 4 to 5 hours at 70 °F. Recoating must be done after 5 hours air dry and before 24 hours air dry time or reduced adhesion may result. Ultimate hardness and chemical resistance develops if heat cured for 1 hour at 350 °F.

CLEANUP

Clean equipment with xylol or toluol before the film cures.

ENVIRONMENTAL

These products meet current air pollution regulations regarding hydrocarbon and ozone reactive emissions. They are VOC compliant for most industries, are zinc and chromate free, and comply with current federal regulations regarding the use of lead in paint.

PHYSICAL PARAMETERS

VOC, ASTM D-3960:

1.87 lb./gal mixed system typical

WEIGHT PER GALLON, ASTM D-1475:

12.14 lbs. mixed system typical

NONVOLATILE, mixed system:

By weight: 84%

By volume: 74%

THEORETICAL COVERAGE:

1190 ft²/gallon/mil, dry film

GLOSS, 60°, ASTM D-523:

10 air dried, 2 after heat curing

POT LIFE, mixed in 5 gal lots:

More than 8 hrs @ 72 °F

MIX RATIO:

4 gal "A" component to $\frac{3}{4}$ gal "B" component

FLASH POINT, TAG CC: 81 °F

THIS INFORMATION RESULTS FROM TESTS CONDUCTED IN A LABORATORY UNDER LABORATORY CONDITIONS. DIFFERENT RESULTS MAY BE OBTAINED IN COMMERCIAL USE OF THIS PRODUCT UNDER FACTORY OR FIELD CONDITIONS. PRUETT-SCHAFFER MAKES NO WARRANTY CONCERNING THE SUITABILITY OF THIS PRODUCT FOR THE END USE CONTEMPLATED BY THE BUYER, EXCEPT THAT THE PRODUCT SHALL BE IN COMPLIANCE WITH THE TECHNICAL SPECIFICATIONS PRESENTED HEREIN.

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