VOLATILE ORGANIC COMPOUNDS

TECHNICAL DATA

Temperature | To Handle/To Recoat | Max Recoat
90°F (32°C)  | 4 hours | 21 days
75°F (24°C)  | 12 hours | 21 days
65°F (18°C)  | 16 hours | 21 days
55°F (11°C)  | 24 hours | 21 days
45°F (7°C)   | 48 hours | 21 days
35°F (2°C)   | 72 hours | 21 days

Unthinned: 1.46 lbs/gal (175 grams/litre)
Thinned 5% (No. 2 Thinner): 1.73 lbs/gal (208 grams/litre)

HAPS

Theoretical Coverage

1267 ml sq ft/gal (31.1 m²/L at 25 microns). See APPLICATION for coverage rates.

Two: Part A and Part B

By volume: Two (Part A) epoxy to one (Part B) amine.

mixing ratio

1.60 lbs/gal solids
Thinned 5% (No. 2 Thinner): 2.05 lbs/gal solids

Net Weight per Gallon
12.56 ± 0.25 lbs (5.7 ± 0.11 kg) (mixed)

A high-build, surface tolerant epoxy mastic that can be applied over light corrosion and marginally prepared steel, in low-temperatures and over dew point conditions. Series 138 stands up to the harsh atmospheric environments found in industrial facilities. Its unique phenalkamide epoxy technology resists color shift, making it an ideal finish coat for severe conditions.

COLORS

GALVANIZED STEEL & NON-TEMPERATURE RESISTANCE

PRIMERS

The following maximum recoat times apply: Series 66, 115, 138; twenty one (21) days, Series 1094, 1095, 1096; thirty (30) days. If this time limit is exceeded, Series 138 must be uniformly scarified prior to topcoating.

SHELF LIFE

Part A: 82°F (28°C)  Part B: 96°F (36°C)

This product contains chemical ingredients which are considered hazardous. Read container label warning and Safety Data Sheet for important health and safety information prior to the use of this product.

Keep out of the reach of children.
APPLICATION

**COVERAGE RATES**

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Dry Mils (microns)</th>
<th>Wet Mils (microns)</th>
<th>Sq Ft/Gal (m²/gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>4.0 (100)</td>
<td>5.0 (125)</td>
<td>309 (28.7)</td>
</tr>
<tr>
<td>Maximum</td>
<td>10.0 (255)</td>
<td>13.0 (330)</td>
<td>124 (11.5)</td>
</tr>
</tbody>
</table>

**MIXING**

Power mix contents of each container, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. **Note:** Both components must be above 50°F (10°C) prior to mixing. For application to surfaces between 35°F to 60°F (2°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, blended components should be above 60°F (16°C).

**THINNING**

Thin up to 5% or 1/4 pint (190 mL) per gallon with No. 2 Thinner.

**POT LIFE**

1 hour at 75°F (24°C)

**SUBSTRATE CONDITIONING**

Do not apply over puddles, ponding, or standing water. All standing and heavy accumulations of water must be removed before application. In the case of sweating pipes, accumulated water must be removed. Brush, roll, or spray/backroll to displace water and create a monolithic film in direct contact with substrate.

**APPLICATION EQUIPMENT**

Airless Spray

<table>
<thead>
<tr>
<th>Pump Size</th>
<th>Tip Orifice</th>
<th>Atomizing Pressure</th>
<th>Mat'l Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>45:1 or greater</td>
<td>0.017” to 0.021” (430 to 555 microns)</td>
<td>3,500 to 4,500 psi (241 to 310 bar)</td>
<td>1/4” to 1/2” (6.4 to 12.7 mm)</td>
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</table>

**Surface Temperatures**

Minimum 35°F (2°C)  Maximum 135°F (57°C)

**CLEANUP**

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

**Brush:** Recommended for small areas only. Use high quality synthetic or nylon bristle brushes.

**Roller:** Use high quality 3/8” to 1/2” synthetic woven nap roller covers.

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