



EPOXOLINE® ARO SERIES 425

PRODUCT PROFILE

GENERIC DESCRIPTION Polyamine Epoxy

COMMON USAGE A 100% volume solids Abrasion Resistant Overcoat (ARO) system for use on top of fusion bonded epoxy (FBE) for directional- and thrust-bore drilling application and other severe abrasive pipeline applications. ARO can also be used as a direct to metal (DTM) system to protect steel or ductile iron substrates for when HDD or abrasion is a concern. Contact Tnemec for more information.

COLORS 1249 Methane **Note:** Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

FINISH Semi-gloss

COATING SYSTEM

PRIMERS Self-priming

REPAIR/TOUCH-UP Series 425

SURFACE PREPARATION

STEEL SSPC-SP10/NACE 2 Near-White Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning with a minimum angular anchor profile of 3.0 mils.

FBE SSPC-SP7/NACE 4 Brush-Off Blast Cleaning or ISO Sa 1 Light Blast Cleaning with a minimum angular anchor profile of 1.0 mil.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 100% (mixed)

RECOMMENDED DFT 20.0 to 40.0 mils (508 to 1016 microns) in one coat with multiple passes.

CURING TIME

Temperature	To Handle	Max. Recoat
75°F (24°C)	2 hours	24 hours

VOLATILE ORGANIC COMPOUNDS 0.15 lbs/gallon (18 grams/litre)

HAPS 0.10 lbs/gal solids

THEORETICAL COVERAGE 1,604 mil sq ft/gal (39.4 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Three Part A (epoxy) to One Part B (amine)

MIXING RATIO By Volume: Three (Part A) to One (Part B)

PACKAGING

	Part A	Part B	Yield (mixed)
Large Kit †	3 - 5 gallon pails	1 - 5 gallon pail	20.0 gallons (75.7 L)
Small Kit	1 - gallon can (partial fill)	1 - quart can	1.0 gallon (3.79 L)

†Plural Component application only.

NET WEIGHT PER GALLON 12.80 ± 0.25 lbs (5.8 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)
Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C). It is suggested the material be stored at these temperatures at least 48 hours prior to use.

TEMPERATURE RESISTANCE Chemical resistance varies depending on chemical exposure and temperature. Refer to Tnemec's Chemical Resistance Guide for further information.

SHELF LIFE Part A: 12 months; Part B: 12 months at recommended storage temperature.

FLASH POINT - SETA Part A: >230°F (110°C) Part B: 148°F (64°C)

HEALTH & SAFETY 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	Dry Mills (Microns)	Wet Mills (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	30.0 (762)	30.0 (762)	53 (5.0)
Minimum	20.0 (508)	20.0 (508)	80 (7.5)
Maximum	40.0 (1016)	40.0 (1016)	40 (3.7)

Allow for overspray and surface irregularities. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

MIXING Power mix contents of each container, making sure no pigment remains on the bottom.
Pre-Heating: Heat each component to 110°F-120°F (43°C-49°C) prior to spraying.

THINNING **DO NOT THIN.** Thinning will adversely affect performance properties.

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PURGE TIME	Less than 60 seconds.
APPLICATION EQUIPMENT	HEATED PLURAL COMPONENT AIRLESS EQUIPMENT ONLY. Contact Tnemec Technical Service for recommended equipment modifications. Brush: Recommended for small areas, repairs and weld seams.
SURFACE TEMPERATURE	Minimum 60°F (16°C) Maximum 120°F (49°C) The surface should be dry and at least 5°F (3°C) above the dew point.
CLEANUP	Clean and purge lines immediately after use with No. 4 Thinner or MEK.

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