



Coal-Tar N
Coal Tar Epoxy
100N7728B Base
100X7729A Activator

PRODUCT DESCRIPTION

Coal-Tar N is a two-component polyamide-epoxy. It can be applied in one-coat application of 18 mils with no loss of adhesion. It displays excellent weathering and resistance to salt and fresh water degradation for steel and concrete.

Coal-Tar N is recommended for use on a large variety of steel or concrete structures.

Immersion

Marine Equipment
Salt & Fresh Water

Non-Immersion

Chemical Plants
Cogeneration Plants
Power Plants
Refineries
Structural Steel
Underground Storage Tanks

Linings In:

Alkalies
Bilge Tanks
Fresh Water
On Shore Pipelines

Salt Solutions
Salt Water
Sour Crude
Tankage

Intermittent Immersion:

Dams and Locks
Offshore Structures

Pilings
Sewage Treatment

PERFORMANCE PROPERTIES

System Tested:

Substrate: Steel
Surface Preparation: SSPC-SP6
1 ct. Coal Tar-N Black@ 18 mils dft

Adhesion:

Method: ASTM D4541
Result: Passes 600 lbs/sq in

Pencil Hardness:

Method: ASTM D3363
Result: 4H

Flexibility:

Method: ASTM D522
Result: Passes 180° bend 1" Mandrel

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TECHNICAL INFORMATION

Generic Types: Polyamide Cured – Coal Tar Epoxy.
Two-component product.

Gloss: Semi-Gloss

Use: Protective / Decorative

Color: Black

Recommended Film Thickness: 16.0 – 18.0 Mils Dry
21.0 – 24.0 Mils Wet

Spread Rate: 66 – 75 sq ft/gal @ the recommended dft

Dry Time: @ 77°F (25°C) & 50% Relative Humidity

To Touch: 3 – 4 hours

Tack Free: 16 – 20 hours

Recoat: If product is to be recoated, you must recoat within 26 hours for good adhesion. After this time, surface should be abraded.

Flash Point: 80°F (20°C)

Brookfield Viscosity: 20 – 40 Poise with #7 Spindle
@ 100 rpm

VOC: 1.88 (204 g/l) ± 1% (activated)

#HAPS / Gal Solids: 2.51 (activated)

Solids By Volume: 74.01 ± 2% (activated)

Solids By Weight: 78.89 ± 2% (activated)

Weight Per Gallon: 8.92 ± .15 lbs/gal (activated)

Pot Life: Four hours @ 77°F (25°C)

Shelf Life: One year unopened from date of manufacture, each component.

Recommended Primer: Product is self-priming, but can be used over Enviro-Zinc Epoxy Primer for maximum protection of steel. Self-priming over concrete.

Clean Up: 560X3504 (Xylene)

PERFORMANCE PROPERTIES

(continued from page one)

Dry Heat Resistance:

Method: ASTM D2485

Result: Passes 250°F

Salt Spray Resistance:

Method: ASTM B117

Result: Passes 1000 hours – no rust, no blistering

Abrasion Resistance:

Method: ASTM D4060 1 kg load

Result: 1000 cycles, 60 mg los

APPLICATION INFORMATION

SURFACE PREPARATION:

Surface of substrate should be dry, clean, and in sound, paint-worthy condition. The surface must be free of dirt, grease, oil, salts, loose rust, loose mill scale, and any other foreign materials or contaminants. For non-severe exposure, SSPC-SP3, Power Tool Cleaning may be all that is required. SSPC-SP6, Commercial Blast Cleaning is required for more demanding conditions or severe chemical exposure.

Steel and Iron:

The minimum surface preparation for steel and iron is SSPC-SP2/SP3, Hand Tool or Power Tool Cleaning. Prior to this procedure, the surface should be solvent cleaned per SSPC-SP1. For more severe exposures, begin with SSPC-SP1, followed by SSPC-SP6, Commercial Blast Cleaning. Bare metal should be primed as soon after surface preparation as possible, or before flash rusting occurs.

APPLICATION CONDITIONS:

Temperature:

Temperature should not exceed 120°F or go below 40°F during application. This applies to air, surface of substrate and the primer itself. The temperature should be at least 5° F above the dew point.

MIXING & THINNING INSTRUCTIONS:

Mix one part base component with one part activator component using mechanical agitation. Stir well and allow catalyzed mixture to blend 15 – 30 minutes before use.

Note: The addition of thinner reduces viscosity, which, in turn, affects spread rate and application characteristics. If thinner is used, make sure it is well incorporated into the paint prior to application.

This product is available in 10-gallon kits. Each kit consists of the following: five gallons 100N7728B base component and five gallons 100X7729A activator component.

Prices may be obtained from your Sumter Coatings Sales Representative, or by calling Sumter Coatings Customer Service at 1-888-471-3400.

APPLICATION EQUIPMENT:

The following are general recommendations. Pressure and tip size may be varied due to temperature changes and for proper spray characteristics.

Thinning: Thin up to 5% by volume with 560X3504 (Xylene)

See Mixing and Thinning Instructions for further information.

Airless Spray:

Pump Ratio: 30:1

Hose: 1/4" or 3/8"

Tip Size: .015 – .019

Pressure: 2400 – 2600 psi

Filter: 60 Mesh

Air-assisted Airless

Pump Ratio: 30:1

Fluid Pressure: 800 – 1200 psi

Air Pressure: 10 – 20 psi

Fluid Hose: 5/16" – 1/2"

Tip Size: .017 – .019

Conventional Spray:

Gun: Graco AirPro or equal

Fluid Nozzle: 1.4 mm

Air Cap: 289773

Atomization Pressure: 40 – 50 psi

Fluid Pressure: 15 – 20 psi

HINTS FOR BETTER PERFORMANCE:

A clean substrate is necessary for optimal performance, as direct contact of coating and steel surface is required for rust inhibition and good adhesion.

All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application in order to help prevent premature failure in these areas.

Over-thinning of the coating material can result in an insufficient film-build, poor adhesion and overall poor appearance.

During the spray application, use a 50% overlap with each pass of the gun. This will help ensure complete and thorough coverage, avoiding low build areas, which may corrode prematurely due to insufficient primer.

January 2010
(replaces all previous editions)

The technical data furnished are true and accurate to the best of our knowledge at the date of issuance. It is subject to change without prior notice. It is suggested the user verify with Sumter Coatings, Inc. prior to specifying or ordering. Test results are believed to be reliable, however, no guarantee of accuracy is given or implied. We guarantee all products to conform to Sumter Coatings, Inc.'s quality control standards. Liability, if any, is limited to replacement of product. No other warranty or guarantee of any kind, expressed or implied, is made by Sumter Coatings, Inc., including fitness for a particular purpose.