



# ULTRACOTE 250 AC

(Marine Epoxy Primer & Anti-Corrosive)

## (Paints & Coatings)

## HEAVY DUTY, HIGH PERFORMANCE

**GENERIC TYPE:** Polyamide epoxy with special anti-corrosive pigments.

**PRODUCT DESCRIPTION:** Ultracote 250 AC is a high build and heavy duty coating for use above and below waterline of ships and vessels. It has excellent resistance to sea water and corrosive ions permeation and cathodic protection. It is tough, hard and high abrasion resistance. High resistance to oils and mild chemicals. It performs excellent adhesion to steel surface and various organic and inorganic zinc primers. Very good adhesion property with various kinds of anti-fouling.

**TYPICAL USES:** Ultracote 250 AC is recommended for use as anti-corrosive coating for ship bottom, boottop, topside, deck, etc. It is recommended for coating on various marine structures, offshore structures, oil rig platforms and various structures subject to corrosive environment.

**LIMITATIONS:** Not recommended for immersion service on oxidizing acids.

### CHEMICAL RESISTANCE GUIDE:

Exposure	Immersion Service	Splash & Spillage	Fumes
Acids	NR	Very Good	Excellent
Alkalies	Good	Very Good	Excellent
Solvents	Very Good	Very Good	Very Good
Salts/ Sea Water	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

### TEMPERATURE RESISTANCE: (Dry Basis)

Sustained	:	200°F (93°C)
Intermittent	:	250°F (121°C)

**WEATHERING:** Excellent

**ABRASION RESISTANCE:** Excellent

**SUBSTRATES:** Ultracote 250 AC may be applied over properly prepared steel and concrete, or others as recommended.

**TOPCOAT REQUIRED:** Ultracote 250 AC may be topcoated with catalyzed epoxies, vinyls and chlorinated rubber anti-fouling, phenolics and others as recommended.

**COMPATIBILITY WITH OTHER COATINGS:** Ultracote 250 AC may be used over inorganic and organic zinc primers, catalyzed epoxies, phenolics or others as recommended. recommendation.

### CALCULATED VOLUME SOLIDS:

Ultracote 250 AC                      50% ± 2%

### RECOMMENDED DRY FILM THICKNESS PER COAT:

2 - 3 mils (50 - 75 microns)

### CALCULATED COVERAGE PER MIXED GALLON:

802 mil sq. ft. (20 sq. m./li. @ 25 microns)  
401 sq. ft. @ 2 mils (9.8 sq. m./li. @ 50 microns)  
267 sq. ft. @ 3 mils (6.7 sq. m./li. @ 75 microns)

**NOTE:** Assume loss factor when estimating job requirements at prevailing condition.

**SHELF LIFE:** 12 months minimum.

**FINISH:** Flat and semi-gloss

**FINISH:** Flat

**COMPONENT:** Two

**FLASH POINT:** (Pensky Martens Closed Cup)

Ultracote 250 AC Part A            46°F (8°C)

Ultracote 250 AC Part B            60°F (16°C)

**SURFACE PREPARATION:** Remove any oil or grease from surface to be coated with clean rags soaked in ultracote thinner #2 or tuluol in accordance with SSPC-SP-1.

**STEEL SURFACE:** Dry abrasive blast to a commercial grade finish in accordance with SSPC-SP-6 to a degree of cleanliness in accordance with NACE #3 to obtain a 1-2 mil (25-50 microns) blast profile. Acceptable power tool clean per SSPC-SP-3 for touch up only.

**CONCRETE:** Do not coat concrete treated with hardening solutions unless test patches indicate satisfactory adhesion. Do not apply coating unless concrete has cured at least 28 days @ 70°F (21°C) and 50% RH or equivalent time. Apply to properly prepared concrete that was acid etched or swept blasted.

**MIXING:** Stir individually Part A and Part B be combining in the following proportions:

	<u>1 Gal. Kit</u>	<u>4 Gals. Kit</u>
Ultracote 250 AC - Part A	3 quarts	3 gals.
Ultracote 250 AC - Part B	1 quart	1 gal.

**THINNER:** Use Ultracote Thinner #17 up to 10% by volume. Do not over thin or use other thinner. It may adversely affect coating performance unless test indicates satisfactory result. Consult Ultracote Technical Representative before use.

**POT LIFE:** 6 hours @ 70°F (24°C) and less at higher temperature. Pot life ends when coating losses body and begin to sag.

**APPLICATION TEMPERATURES:**

Materials	:	55-90°F (13-32°C)
Surfaces	:	50-135°F (10-57°C)
Ambient	:	50-110°F (10-43°C)
Humidity	:	0-90%

Do not apply when the surface temperature is less than 5°F (2°C) above the dew point. Special thinning and application techniques may be required above or below normal condition.

**SPRAY:** Use adequate air volume for correct operation. Use 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

**NOTE:** The following equipment has been found suitable, however, equivalent equipment may be substituted.

**CONVENTIONAL SPRAY:** Use a 3/8" I.D. material hose. Hold gun 8-10 inches from the surface and at right angle to the surface.

<u>Mfr. &amp; Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	66	66PB
DeVilbiss P-MBC or JGA	E	704
Approx. .070" I.D.		

**AIRLESS SPRAY:** Use 3/8" I.D. Material hose. Hold gun 12-14 inches from the surface and at right angle to the surface.

<u>Mfr. &amp; Gun</u>	<u>Pump</u>
DeVilbiss JGA-507	QFA-514
Graco 205-591	President 30:1 or Bulldog 30:1
Binks Model 500	Mercury 5C

**NOTE:** Use teflon packings for pumps. Use a .015 tip with 2,000 psi.

**BRUSH OR ROLLER:** For small areas or touch up only, use medium, natural bristle brush with full strokes. Avoid rebrushing. Use short nap mohair roller with phenolic.

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**DRYING TIME:**

Dry to Touch	:	1-2 hrs. @ 75°F (24°F)
		1hr. 90°F (43°F)
Dry to Recoat	:	3-4 hrs. @ 90°F (32°F)
		5-6 hrs. @ 95°F (24°F)
Dry to Handle	:	5-6 hrs.
Curing Time	:	5 days

**CLEAN UP:** Use Ultracote Thinner # 2

**PACKAGING:** Gallon (3.785 liters)  
Pail (4 & 5 gallons)

**STORAGE CONDITION:**

Temperature : 40-110°F (4-43°F)  
Humidity : 0-100%

**SAFETY INFORMATION:** This product (and any recommended thinners) contains solvents and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. Keep away from sparks, heat and open flame and use necessary safety equipment such as air mask, non-sparking tools and ladders, etc. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Keep out of reach of children.

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Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Ultracote Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.

**ULTRACOTE PAINTS & COATINGS CORPORATION**

**Main Office:** No. 114 Eagle St. corner F. Legaspi St., Brgy. Ugong, Pasig City, Philippines  
Tel. Nos. +63 2 671-3409 / 671-9261; Telefax Nos. +63 2 671-3410 / 671-3414  
**Cebu Office:** Rm. 307 N & N Cortes Arcade, AC Cortes Avenue, Mandaue City, Philippines  
Tel. No. +63 32 344-0268; Telefax No. +63 32 344-1638  
E-mail: [contact@ultracote.net](mailto:contact@ultracote.net) | Website: <http://www.ultracote.net>