



ULTRACOTE 317 FINISH

(Epoxy Enamel Topcoat)

(Paints & Coatings)

HEAVY DUTY, HIGH PERFORMANCE

GENERIC CLASS: Two pack epoxy enamel cured with polyamide.

PRODUCT DESCRIPTION: An economical, heavy duty high performance maintenance coating. Suitable for surfaces where high gloss, chemical abrasion resistant finish is required. It cures to a hard tough film with excellent subfilm corrosion resistance.

TYPICAL USES: Ultracote 317 Finish is an excellent coating for new construction, maintenance for protection of structural steel, concrete, equipment, tank exteriors in chemical and food plant, breweries, paper mills, fertilizer plants and other industries with corrosive conditions. Excellent protection for equipment subjected to impact abrasion, detergents, water, steam and oils. It is also recommended for marine exposure such as offshore structure, vessels and barges.

LIMITATIONS: Not recommended for immersion service to strong solvents and concentrated acids.

CHEMICAL RESISTANCE GUIDE:

<u>Exposure</u>	<u>Splash & Spillage</u>		<u>Fumes</u>
	<u>Spillage</u>	<u>Splash & Spillage</u>	
Acids	Good	Very Good	Very Good
Alkalies	Good	Excellent	Excellent
Solvents	Very Good	Excellent	Excellent
Salt	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

TEMPERATURE RESISTANCE: (Dry Basis)

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

FLEXIBILITY: Very Good

WEATHERING: Excellent (Chalks)

ABRASION RESISTANCE: Excellent

DURABILITY: Excellent, but chalks on exposure to ultraviolet rays. Chalking does not affect durability and chemical resistance.

SUBSTRATES: May be applied over properly primed metals, cementitious surface or others as recommended.

TOPCOAT REQUIRED: Normally none. May be topcoated by itself.

COMPATIBILITY WITH OTHER GENERICS: Ultracote 317 Finish may be applied over catalyzed epoxies, phenolics or others as recommended.

CALCULATED VOLUME SOLIDS:

Ultracote 317 Finish 48%±2%

RECOMMENDED DRY FILM THICKNESS PER COAT: 2 - 3 mils (50 - 75 microns)

CALCULATED COVERAGE PER MIXED GALLON:

768 mil sq. ft. (19.3 sq. m./ li. @ 25 microns)
 384 sq. ft. @ 2 mils (9.4 sq. m./ li. @ 50 microns)
 256 sq. ft. @ 3 mils (6.43 sq. m./ li. @ 75 microns)

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

SHELF LIFE: 12 months. Turned stock upside down every 3-4 months.

COLORS: White, Green, Blue and colors.

FINISH: Semi-gloss and gloss

COMPONENT: Two

FLASH POINT: (Pensky-Martens Closed Cup)

Ultracote 317 Finish 90°F (32°C)
Ultracote Thinner #15 104°F (40°C)

SURFACE PREPARATION: Remove any oil or grease from surface to be coated with clean rags soaked in toluol or xylol.

STEEL: Apply over clean, dry recommended primers.

CONCRETE: Do not coat concrete treated with hardening agents unless tests indicate satisfactory adhesion. Apply only when concrete has properly cured and dried. Acid etched or swept blasted are preferred method of application.

WELDING: Welding should precede coating. In the event welding or flame cutting is performed on metal already coated with this product, do so in accordance with the latest instructions in USA Standard Z49:1 "Safety in Welding and Cutting". All welded, burned or otherwise damage areas should be cleaned to base metal, prepared and recoated as specified.

MIXING: Stir very thoroughly to a uniform consistency and occasionally during application. Allow mix to stand for 20 minutes to attain complete activation of chemicals and remix before use.

MIXING RATIO:

Ultracote 317 Finish Part A 3 part by volume
Ultracote 317 Finish Part B 1 part by volume

NOTE: Components are not interchangeable. e. q. component A of one color may not be used with component B of another color and vise versa.

THINNER: Thin up to 10% by volume with Ultracote Thinner #15. Do not use other kinds of thinner!

POT LIFE: 4-6 hours at 75°F (24°C) and less at higher temperatures.

APPLICATION TEMPERATURES:

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

NOTE: Do not apply when the surface temperature is less than 5°F (2°C) above the dew point.

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

SUGGESTED APPLICATION EQUIPMENT:

AIRLESS SPRAY: Standard equipment such as Graco or equal using a 30:1 or higher pump ratio. Graco 205-591 gun having a fluid tip of .013"-.015" with Reverse-A-Clean tip, 3/8" minimum I.D. or larger high pressure and solvent resistant fluid line, 1/2" I.D. or larger air supply line. Operating source capable of providing 80 to 100 psi. inbound pressure at the pump. Use teflon packings. Hold gun approximately 18-20 inches from the surface and perpendicular to the surface.

CONVENTIONAL SPRAY: Standard equipment such as Binks or equal using a pressure material pot with mechanical agitator, equipped with dual regulators and air gages. Oil and moisture separators are necessary. Binks #18 gun or #62 gun, 63B fluid tip, 63PB air cap, heavy duty fluid spring and teflon fluid packing, 1/2" I.D. or larger high solvent resistant fluid line and 3/8" I.d. or larger air supply line. Operating air source capable of providing a minimum 20 CFM at 80 psi to each nozzle and 60 psi to the pot is required. Hold gun approximately 12-14 inches from the surface and perpendicular to the surface.

BRUSH OR ROLLER: Use a medium, natural bristle brush, with full strokes. Avoid rebrushing. Use short nap mohair roller with phenolic core.

DRYING TIME:

To Touch : 90 mins @ 90°F (32°C)
60 mins. @ 75°F (24°C)
To Handle : 3 hrs. @ 90°F (32°C)
6 hrs. @ 75 °F (24°C)
To Recoat : 3-4 hrs. @ 90°F (32°C)
4-6 hrs. @ 75 °F (24°C)
Final Cure : 3 days

CLEAN-UP: Use Ultracote Thinner #2 or xylol.

STORAGE CONDITION:

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

PACKAGING: Gallon Kit (3.785 liter)
Pail (4 and 5 Gallons)

NOTE: Consult Ultracote Technical Representative for earlier recoating time.

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.

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