



ULTRACOTE 524 HS Primer & Finish

(Tank Lining/Floor Coatings)

(Paints & Coatings)

HEAVY DUTY, HIGH PERFORMANCE

GENERIC CLASS: High solids and high build epoxy catalyzed by a unique amine activator with a special grade chemical resistant pigment.

PRODUCT DESCRIPTION: Ultracote 524 HS Primer and Topcoat is a high solid amine cured epoxy tank lining and coating having excellent chemical, thermal shock and abrasion resistance. These class coatings are designed to provide a dry film thickness up to 6 mils per applied coat. It features outstanding adhesion and has excellent edge covering without sagging, pinholing or mud cracking. It is unusually inert and corrosion resistant to fresh and sea water, most salt solutions, agricultural chemicals and petroleum and petrochemical products as well as caustics and acids. These coatings conform to the requirements of Bureau of Ships Specification MIL-P-23236, Class I and II, Type I. It is suitable for direct food contact and potable water tank surfaces in appropriate colors and conform to American Water Work Association Specification D102-78 Inside Paint System No. 1.

TYPICAL USES: Ultracote 524 HS Primer and Topcoat may be considered as a protective coatings for steel, storage tanks, handling industrial, waste and brine waters and water solution containing salts, alkalis, acids and many other chemicals. It is intended for use in pickling tanks, oil storage production and with petroleum products such as sweet and sour crude oils, diesel, kerosene, gasoline, aviation fuels, lubrication materials, greases, motor oils, hydraulic fluids, skydrol and aliphatic hydrocarbon solvents. It is also intended for use in storage of agri-chemical products and use on fertilizer plants, pulp and paper mills, breweries, steel mills, mining and for tank lining of ocean-going carriers.

LIMITATIONS: Ultracote 524 HS Primer and Topcoat is not suitable for use in immersion service to strong mineral and organic acids.

CHEMICAL RESISTANCE EXPOSURE:

(With proper topcoat)

<u>Exposure</u>	<u>Immersion</u>	<u>Splash & Spillage</u>	<u>Fumes</u>
Acids	Very Good	Excellent	Excellent
Alkalis	Very Good	Excellent	Excellent
Solvents	Excellent	Excellent	Excellent
Fuels/oils			
lubricants	Excellent	Excellent	Excellent
Salts	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

NOTE: Although the chemical tests indicated show that Ultracote 524 HS Primer and Topcoat is unaffected by immersion service as listed, it is not meant to imply an express guarantee in actual service. The service is dependent upon application and actual operating conditions and it is generally recommended that users confirm adaptability of the product for a specific use by their own tests.

TEMPERATURE RESISTANCE: (Dry Basis)

Sustained	:	250°F (121°C)
Intermittent	:	300°F (148.8°C)

WEATHERING: Very Good (Chalks)

FLEXIBILITY: Fair

THERMAL SHOCK: Unaffected 5 cycles, -70°F to +200°F.

HARDNESS: Excellent. Konig Pendulum -95± seconds; Din Standard 53157 (Glass Standard 250 seconds).

ABRASION RESISTANCE: Excellent

SUBSTRATES: Apply over properly prepared steel, concrete, stainless steel, aluminum or others as recommended.

TOPCOAT: May be topcoated with Ultracote 524 HS Finish, catalyzed epoxies, phenolics, chlorinated rubbers and others as recommended.

COMPATIBILITY WITH OTHER COATINGS: May be applied over zinc rich epoxy, inorganic zinc and catalyzed epoxies, phenolics and others as recommended.

CALCULATED VOLUME SOLIDS:
Ultracote 524 HS Primer & Topcoat 88%±2%

RECOMMENDED DRY FILM THICKNESS PER COAT:

Primer : 4-5 mils (100-125 microns)
Topcoat : 5-6 mils (125-150 microns)

CALCULATED COVERAGE PER MIXED GALLON:

1,411.5 mil sq.ft. (34.65 sq.m./li. @ 25 microns)
352.8 sq.ft. @ 4 mils (8.66 sq.m./li. @ 100 microns)
282.3 sq.ft. @ 5 mils (6.93 sq.m./li. @ 125 microns)
235.3 sq.ft. @ 6 mils (5.8 sq.m./li. @ 150 microns)

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

SHELF LIFE: 12 months. Turn stock upside down every 4 months.

COLORS: Yellow, Buff, White and Orange

FINISH: Primer : Flat
Topcoat : Semi-gloss and gloss

COMPONENT: Two

FLASH POINT: (Pensky-Martens Closed Cup)

Ultracote 524 HS Primer and Topcoat
Part A & B 73°F (23°C)
Ultracote Thinner #33 103°F (39°C)
Ultracote Thinner #15 77°F (25°C)

SURFACE PREPARATION: No more surface preparation than can be coated in the same working day should be performed. Round off all sharp edges and rough welds. All burrs, weld spatter, loose concrete, masonry and wood should be completely removed.

SURFACE PREPARATION: (Cont.) Concrete and masonry should cure at least thirty (30) days. Oil, grease and heavy deposits of surface contaminants should be removed. All surfaces must be clean, dry and free of any dirt, dust, chalk, grease, oils, salts, curing compounds, release agents and other deleterious materials before application is performed.

CARBON STEEL: It is recommended for immersion or severe exposure that metal surfaces be prepared in accordance to SSPC-SP-10 (Near White Blast Cleaning) as minimum. For atmospheric or chemical fumes and splash and spillage exposures, metals surfaces may be prepared in accordance with SSPC-SP-6 (Commercial Blast Cleaning). Prepared metal surfaces should have an anchor profile of not less than 2 mils (50 microns).

ALLOY STEELS AND NON-FERROUS METALS: Chemically clean surfaces in accordance with SSPC-SP-1 (Solvent Cleaning). Abrasive "brush" blast to provide a lightly profiled and etched surface.

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.

CONCRETE: All concrete surfaces require whip blasting for immersion service. Fully cured concrete must be blasted to a hard, firm, clean and neutral surface before coating.

MIXING: Mix separately, then combine and stir very thoroughly before use and occasionally during application making sure no pigments remain in the bottom of the can.

MIXING RATIO:

Part A : 4 parts by volume
Part B : 1 part by volume

After mixing together parts A and B, allow the mix to stand 20 minutes to have complete chemical activation. Adverse effect will occur if not strictly followed. Remix before application.

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

THINNER: Thin up to 20% by volume with Ultracote Thinner #33 or #15. Do not over thin!

POT LIFE: 4-5 hours @ 75°F (24°C) and less at higher temperature.

APPLICATION TEMPERATURES:

Material : 55-90°F (13-32°C)
Surfaces : 50-110°F (10-43°C)
Ambient : 50-100°F (10-38°C)
Humidity : 0-85%

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

SPRAY TECHNIQUE: All spray equipment should be thoroughly cleaned and the hose in particular, should be free of old paint, film and other contaminants. Use a 50% overlap with each pass of the gun.

SUGGESTED APPLICATION EQUIPMENT:

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 No. 18 gun (External Mix), 67 fluid nozzle, 65 fluid needle, 67 PB air cap, heavy duty fluid spring and Teflon fluid packing, 1/2" ID or larger high solvent resistant fluid line and 3/8" ID or larger air supply line. Operating air source capable of providing minimum 20 cfm @ 80 psi to each nozzle and 60 psi to the pot is required.

AIRLESS SPRAY: Standard equipment such as Graco or equal using 30:1 or higher pump ratio. Graco 206-718 gun having a fluid tip of .019" or larger orifice size with Reverse-A-clean tip, 3/8" ID or larger high pressure and solvent resistant fluid line, 1/2" ID or larger air supply line.

Operating air source capable of providing 80 to 100 psi inbound pressure at pump.

BRUSH/ROLLER: Natural bristle brush or short nap mohair with phenolic core.

DRYING TIME:

To Touch : 2 hrs. @ 90°F (32°C)
To Recoat : 6-10 hrs. @ 90°F (32°C)
To Handle : 6 hrs. @ 90°F (32°C)
Final Cure : 8 days prior to chemical exposure

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

STORAGE CONDITION:

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

PACKAGING:

Gallon (3.785 liters)
Pail (4 & 5 Gallons)

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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