

Epoxy

PRODUCT DESCRIPTION

A high performance, versatile, two component, chemically cured tile-like epoxy coating with excellent chemical, corrosion, moisture, stain, and abrasion resistance.

INTENDED USES

For use on interior or exterior properly prepared and primed metal or masonry surfaces in corrosive and chemical environments, or as a high performance architectural coating (HIPAC). Also used on concrete floors and interior primed drywall, plaster and wood surfaces. Ideal for structural steel, piping, tanks, and equipment as well as the hard usage areas of food processing plants, dairies, schools, hospitals, restaurants, corridors, public housing and public buildings.

White meets FDA requirements (21CFR 175.300) for direct food contact.

PRACTICAL INFORMATION FOR TRU-GLAZE 4508H

Colour	White, Clear and safety colours			
Gloss Level	Gloss			
Volume Solids	59% ± 2%			
Typical Thickness	75-150 microns (3-6 mils) dry equivalent to 127-254 microns (5.1-10.2 mils) wet			
Theoretical Coverage	5.90 m ² /litre at 100 microns d.f.t and stated volume solids 237 sq.ft/US gallon at 4 mils d.f.t and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Airless Spray, Roller, Air Spray, Brush			
Drying Time	Overcoating Interval with recommended topcoats			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	*	24 hours	16 hours	30 days

REGULATORY DATA

Flash Point (Typical)	Part A 22°C (72°F); Part B 22°C (72°F); Mixed 22°C (72°F)		
Product Weight	1.27 kg/l (10.6 lb/gal)		
VOC	2.66 lb/gal (319 g/l)	EPA Method 24	

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, curing compounds, loose and flaking paint and other foreign substances.

New Surfaces:

Concrete, Plaster and Masonry

Cure at least 30 days before painting. pH must be 10.0 or lower. Remove laitance and roughen unusually slick poured or pre-cast concrete by acid etching or abrasive sweeping. Follow acid manufacturer's application and safety instructions. Rinse thoroughly with water and allow to dry. Remove loose aggregate. Prime with this product. Fill concrete block with Tru-Glaze-WB 4015 waterborne epoxy blockfiller.

Steel:

Tru-Glaze 4508H should be applied to a substrate which has been correctly prepared and primed using Devran 223 epoxy or Devran 203 waterborne epoxy primers. See primer datasheet for further information.

Galvanized Metal and Aluminium:

Tru-Glaze 4508H should be applied to a substrate which has been correctly prepared and primed using Tru-Glaze WB 4030 or Devran 203 waterborne epoxy primers. See primer datasheet for further information.

Previously Painted Surfaces:

Poorly adhering old coatings should be removed. Wash to remove contaminants. Rinse thoroughly with water and allow to dry. Dull glossy areas by light sanding. Remove all debris. Prime bare areas with primer specified under New Surfaces.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.	
	<ol style="list-style-type: none"> (1) Agitate Base (Part A) with a power agitator. (2) Agitate Curing Agent (Part B) with a power agitator. (3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. 	
	Allow the mixed material to stand 45 minutes at temperatures below 21°C (70°F) before use. Above 21°C (70°F) allow 30 minutes induction time.	
Mix Ratio	1 part(s) : 1 part(s) by volume	
Working Pot Life	25°C (77°F) 6 hours	
Airless Spray	Recommended	Use a 0.38mm (15 thou) tip size and adjust pressure as needed.
Brush	Suitable	See Product Characteristics section for further details
Roller	Suitable	See Product Characteristics section for further details
Thinner	T-10 Thinner	
Cleaner	T-10 Thinner	
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with T-10 Thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.	
Clean Up	Clean all equipment immediately after use with T-10 Thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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PRODUCT CHARACTERISTICS

Advantages:

- Chemical and stain resistant
- Resists splash and spillage of acids, alkalis, salts, solvents, oils, grease, foodstuffs and detergents
- Surface and atmospheric moisture tolerant during application
- Long lasting tile-like finish
- Outstanding hardness and toughness
- Abrasion resistant
- Easily washed and cleaned
- Performance alternate for Federal Specifications TT-C-535B (TYPE I&II) and TT-C-550C (Class A)

In common with all epoxies Tru-Glaze 4508H will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Tru-Glaze 4508H may yellow during application and cure if exposed to the combustion by-products of improperly vented fossil fuel burning heaters.

Tinting: Tint the appropriate base (Part A) with AkzoNobel Dramatone or industrial colourants. Mix thoroughly before curing agent (Part B) is added. For deeper colours use with industrial colourants only.

For best opacity, tint primers toward finish coat colour. Certain shades of yellow, orange, pink and red may require multiple coats.

Usually, one coat of Tru-Glaze 4508H is sufficient but for rough or porous surfaces, two coats may be required to obtain the smoothness desired. Care should be taken that proper and uniform film thicknesses are obtained. Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding.

Use clean medium nap synthetic roller (new rollers must be free of loose fibres).

Surfaces coated with this product may become slippery when wet. For additional slip resistance in areas of pedestrian traffic, add one pound per gallon of coarse pumice or other texturing material. Dries to light foot traffic on concrete floors in 24 hours at 25°C (77°F).

Thinning should not exceed 5% and must conform to state and local VOC regulations.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

The following primers are recommended for Tru-Glaze 4508H:

Devran 203 Devran 201H
Tru-Glaze-WB 4015

The following topcoats are recommended:

Devthane 349QC Devthane 359
Devthane 359H Devthane 378
Devthane 378H Devthane 379
Devthane 379H Devthane 389

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	1 US gal	1 US gal	1 US gal	1 US gal	1 US gal
	5 US gal	5 US gal	5 US gal	5 US gal	5 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	1 US gal	13.2 lb		10 lb	
	5 US gal	56.6 lb		50.1 lb	
STORAGE	Shelf Life	24 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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