

## Epoxy

<b>PRODUCT DESCRIPTION</b>	Devgrip 238 is a two component, abrasion resistant epoxy coating.			
<b>INTENDED USES</b>	Devgrip 238 is designed to protect surfaces subject to unusual abrasive and wear conditions common to many heavy-duty industrial service operations and is ideal for use on pipe lines, drill pipe storage areas and any other surfaces subject to abrasive wear.			
<b>PRACTICAL INFORMATION FOR DEVGRIP 238</b>	<b>Colour</b>	Haze Grey, Oxide Red, Black		
	<b>Gloss Level</b>	Semi-gloss		
	<b>Volume Solids</b>	77% ± 2%		
	<b>Typical Thickness</b>	250 microns (10 mils) dry equivalent to 325 microns (13 mils) wet		
	<b>Theoretical Coverage</b>	3.10 m <sup>2</sup> /litre at 250 microns d.f.t and stated volume solids 124 sq.ft/US gallon at 10 mils d.f.t and stated volume solids		
	<b>Practical Coverage</b>	Allow appropriate loss factors		
	<b>Method of Application</b>	Airless Spray		
	<b>Drying Time</b>	Overcoating Interval with recommended topcoats		
	<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	
				<i>Minimum</i> <i>Maximum</i>
	5°C (41°F)	*	26 hours	18 hours      30 days
	15°C (59°F)	*	13 hours	9 hours      30 days
	25°C (77°F)	*	6 hours	3 hours      30 days
	* not applicable			
<b>REGULATORY DATA</b>	<b>Flash Point (Typical)</b>	Part A 33°C (91°F); Part B 27°C (81°F); Mixed 27°C (81°F)		
	<b>Product Weight</b>	1.52 kg/l (12.7 lb/gal)		
	<b>VOC</b>	1.71 lb/gal (206 g/l) EPA Method 24		
	See Product Characteristics section for further details			

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### SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease, form release agents, curing compounds, laitance, other foreign matter and be structurally sound. Remove all loose paint, mortar spatter, mill scale, and rust.

#### New Surfaces:

Abrasive blast to near-white metal surface cleanliness in accordance with SSPC-SP10 or ISO8501-1:2007 Sa2.5. Blast profile on steel should be at least 2 mils (50 microns) in depth and be of a sharp, jagged nature as opposed to a “peen” pattern (typically obtained in shot blasting).

Remove all dust, debris and blasting medium.

#### Previously Painted Surfaces

Devgrip 238 is not suitable for application to existing coatings.

### APPLICATION

<b>Mixing</b>	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.	
	(1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.	
	At temperatures below 21°C (70°F) it is recommended that Devgrip 238 is allowed a 15 minute induction period after mixing, prior to commencing application.	
<b>Mix Ratio</b>	4 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	5°C (41°F) 6 hours	15°C (59°F) 25°C (77°F) 5 hours 4 hours
<b>Airless Spray</b>	Recommended	See Product Characteristics section for further details
<b>Thinner</b>	T-10 Thinner	Up to 5% thinner may be added to aid application at lower temperatures.
<b>Cleaner</b>	T-10 Thinner	
<b>Work Stoppages</b>	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.	
<b>Clean Up</b>	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:

- Tough epoxy binder and special hard reinforcing minerals outwear glass flake polyesters
- Resists heavy direct impacts without delamination or separation
- Resistant to seawater immersion
- Resists many chemicals and solvents
- Suitable for areas subject to mechanical damage
- Applies with standard airless or air spray equipment
- Excellent low temperature cure

Shop primers are not suitable to properly anchor Devgrip 238 for heavy-duty service. For lesser services, Devran 201H or Catha-Coat 302H primers can be used.

In common with all epoxies Devgrip 238 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

#### Airless Spray Application

Devgrrip 238 can be applied by heavy-duty airless spray equipment using a 45:1 minimum air assisted airless, equipped with Tungsten carbide tips and teflon coated pistons and seals. Devgrip 238 is abrasive to tips and seals. Expect more frequent than normal replacement. Take all screens out of the pump. Put the pump directly over the pail with no right angles on the suction feed. Make sure that the suction feed pipe or hose is not less than 1" in diameter. Most pumps are reduced down to 3/8" or less on the bottom. 3/8" ID fluid hoses are recommended for work under 50 feet. Over 50 feet use a 1/2" ID fluid hose. Fluid hose should be directly connected to the silver gun equipped with a .025" to .031" tip size.

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.

### SYSTEMS COMPATIBILITY

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The following primers are recommended for Devgrip 238:

Cathacoat 302H  
Cathacoat 302HA  
Cathacoat 302HB  
Cathacoat 304L  
Cathacoat 304V  
Cathacoat 313  
Cathacoat 315  
Cathacoat 315HA  
Cathacoat 315HB  
Devran 201H

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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](http://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	0.8 US gal	1 US gal	0.2 US gal	1 US quart
	5 US gal	4 US gal	6 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	1 US gal	11.5 lb		2.9 lb	
	5 US gal	55.1 lb		13.9 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](http://www.international-marine.com) or [www.international-pc.com](http://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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