

TECHNICAL DATA SHEET

ALOCIT 28.15 EPOXY COATING FINISH

STANDARD GRADE (All temps above water - underwater below 17°C/63°F)

- Outstanding adhesion, on oily surfaces & underwater
- Environmentally friendly - solvent free and no heavy metals
- Proven protection against corrosion, including A.L.W.C.
- An inexpensive solution to problem coating needs
- Abrasion resistant

USAGE

As a hygienic, easily cleaned finish for concrete, steel, ironwork providing a hard wearing attractive surface. For preservation of steel structures, industrial floors, cellars, bund areas, laundries, sheet pilings, locks and channels, docks, harbours, oil rigs, oil tanks, ships hulls and bilges, bridges, conduits, caverns, industrial plants for wet or oily surfaces, railway and subway tunnels, underpasses, swimming pools etc. Can also be used as self-priming coat on minimal surface prep.

- A protective coating resistant to many alkalis, some acids, oils, sewage, mechanical wear and chemical attack
- A coating that can be applied on dry, wet, or even on underwater surfaces
- A high build (200 - 400 microns/8-16 mil) per coat

TECHNICAL DETAILS

Product Description	Two component/epoxy resin based/pigmented/solvent free
Volume Solids	100%
Mixing Ratio (by weight)	5 parts resin - 1 part hardener
Specific Gravity	Mixed - 1.55; Base only - 1-75 (+ or - 10% depending on colour)
Dilution	Do not dilute
Brush/Tool Cleaner	Immediately after use. Acetone
Theoretical Coverage Rate*	@ 400µ/16 mil (Maximum WFT) = 1.35m ² /mixed Kg @ 300µ/12 mil (Optimum WFT) = 1.8m ² /mixed Kg @ 200µ/8 mil (Minimum WFT) = 2.7m ² /mixed Kg @ 25µ/1 mil = 1600 ft ²
1 US gallon	
Number of Coats	Two coats
Working Life**	@ +20°C/68°F 45/60 minutes
Drying Times	@ +20°C/68°F Touch dry 6-8 hours
Min Practical Cure Temp.***	+5°C/41°F
Resistant to	Water, sea water, oils, petroleum, some solvents, alkalis and a certain range of acids.
Flash Point	Above +200°C/+392°F
Shelf Life	Minimum 1 year in original container
Storage	Moderate room temperature 15-30°C/59-86°F
Colours	White, Black, Grey - others on request - min quantity may apply US FED-STD-595, RAL, BS 36, BS 3800
Pack Size	UK/Europe 3 KG (2.5 kilo resin/0.5 kilo hardener) US 1 Quart, 1 Gallon, 5 Gallon (Pack includes both components)

- Notes
- * Underwater application can result in reduced coverage rates.
 - ** Working life is dependent on unit size, ambient/product temperature, mixing method and time, application speed relative to reduction in vol. of mixed product.
 - *** Curing will take place at lower temperatures but over an extended period.

SURFACE PREPARATION

A) NEW STEEL

All millscale to be removed by abrasive blasting, check for rogue peaks and laminations, take remedial action. Remove dust and other contaminations. A blast profile of between 50 and 100 μ (2-4 mil) is the aim, based on Swedish Pictorial Standards / ISO-8501-1/SSPC/NACE. We recommend SA2 (SP6, NACE 3) as a minimum, and SA 2.5 (SP10, NACE 2) as the optimum. A secondary choice for surface preparation is mechanical abrading to remove surface contamination before coating application.

B) WEATHERED/EXPOSED/CORRODED STEEL

Our basic aim is to remove surface contamination such as corrosion deposits, marine growths, chemical compounds etc., to revealing a clean steel substrate with a surface profile of a minimum 25 microns/1 mil (50 microns/2 mil underwater), various options are:-

- 1) Abrasive blasting, dry, in areas of low chemical contamination followed by optional high pressure water blast (15-20,000psi).
- 2) UHP hydroblasting (30/40,000psi) to remove all previous coatings etc and reveal original profile. Especially suitable for wet environments such as ships tanks, piers, jetties etc. Clean to an agreed standard and check soluble salts level.
- 3) UHP and High Pressure water blasting may sometimes be employed with added abrasive.
- 4) Mechanical cleaning (power) i.e. needle gunning, rotary wire brushing etc to remove all contamination/dust etc.

Notes:

- 1) Stains of rust, paint or mill scale remaining on the surface do not present a problem providing minimum surface profile criteria are met.
- 2) Alocit product range can be applied to both dry, wet and underwater surfaces, however whilst clean steel in saltwater is acceptable, steel heavily contaminated with salt and/or other chemicals above water is not acceptable. This type of steel requires decontamination, with chemical levels measured before and after.

C) CONCRETE

The substrate should be free from high levels of laitence, dust, oil contamination, large surface voids etc. Sometimes brush blasting (dry) or UHP hydroblasting are appropriate methods, especially for large areas, large cracks/surface voids should be repaired prior to coating.

D) NON-FERROUS METALS

Light surface abrading, remove dust etc. If there are any queries re surface preparation prior to applying the Alocit coating system, please contact our technical dept. for further advice.

E) NON METALLIC

If possible, surface abrading, then remove dust etc if in doubt, apply a test patch before coating.

PRODUCT APPLICATION - Methods

Atmospheric:	Brush & Roller Airless spray - minimum 68:1, Tip size 21-23 thou.
Sweating, damp or underwater:	Alocit brushes - use vigorous circular motion. Alocit K1 underwater pump with round brush - use vigorous circular motion.

Notes:

- 1) Please contact our technical dept for specific details or if any doubt.
- 2) All equipment should be cleaned immediately after use with acetone.
- 3) Airless spray is not suitable for wet/damp surfaces

PRODUCT APPLICATION - COATING SYSTEMS

STEEL **Atmospheric and Underwater:**

Minimum - 1 coat Alocit 28.14 primer plus 1 coat Alocit 28.15.
Optimum - 1 coat Alocit 28.14 primer plus 2 coats Alocit 28.15
OR 2 coats Alocit 28.15

CONCRETE

Atmospheric: 1 coat Alocit 28.95 sealer plus 1 coat Alocit 28.15
OR 1 coat Alocit 28.95 sealer plus 2 coats Alocit 28.15
OR 2 coats Alocit 28.15

Underwater: 2 coats Alocit 28.15

Notes:

- 1) Use Alocit 28.15 of different colours in a multi-coat system.
- 2) Alocit 28.14 zinc primer is specially designed for application onto clean, rust-free profiled steel.
- 3) Alocit 28.95 primer sealer is for application onto wet, oily, concrete etc - not underwater.

PRECAUTIONS

Always use up the entire can. Product cannot be reused after working life expires.

Always empty the entire amount of hardener into the epoxy, because the proper mixing ratio must be maintained. Containers are pre-measured with most epoxy containers oversized to allow adding and mixing of the hardener.

Mix thoroughly by hand or with a mechanical mixer - avoid aeration of mixed product. Make sure that material is mixed well around the walls and the bottom of the can before mixing with hardener.

IMPORTANT

Alocit 28.15 must be brushed onto the surface with circular motions, using pressure on moist, wet, submerged, or oily surfaces. 2nd coat must be applied as soon as the first coat is touch dry - not later.

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