



SHERWIN-WILLIAMS.

Coating System Specification

Date:	06/05/2019
System:	Epoxy / Polysiloxane / Polysiloxane
Prepared for:	City of LaGrange
Attention:	Mr. Jason Clifton Water Division Superintendent
Prepared By:	Richard Pickering Sr. Protective Coatings Specialist
Area or Equipment:	Area 49 Pipe Gallery / Walls / Handrails and Walkway

Surface Preparation: All surfaces to be coated shall be clean, dry and in sound condition. Remove all oil, dust, grease, dirt, loose rust and other foreign material to ensure adequate adhesion. Minimum surface preparation is Hand Tool Cleaning per SSPC-SP 2/3 followed by pressure washing the entire surface with a minimum PSI of 3,500. Spot Primer shall be applied after pressure washing and the substrate is blown down with clean air and substrate free of any contaminants/bond breakers and is completely dry.

CT	Product Name	Volume Solids	Recommended DFT Range		Theoretical Coverage per SF/Gal.
			Min	Max	
1.	(spot primer for all bare steel and rusted areas) Corothane I Mio-Aluminum (B65S14)	65%	2.0	3.0	See product data sheets
2.	Sher-Loxane 800 (B80-500/B80V500)	90%	4.0	6.0	See product data sheets

Additional Notes:

- 1) Please review Product Data Sheets and SDS for additional information that may be required.
- 2) Special care shall be taken to follow all minimum/maximum recoat windows for all specified products.
- 3) Please consult with the City of LaGrange project engineer/manager for finish coat color.

SSPC: The Society for Protective Coatings

SURFACE PREPARATION SPECIFICATION NO. 2

Hand Tool Cleaning

1. Scope

1.1 This standard covers the requirements for hand tool cleaning steel surfaces.

2. Definitions

2.1 Hand tool cleaning is a method of preparing steel surfaces by the use of non-power hand tools.

2.2 Hand tool cleaning removes all loose mill scale, loose rust, loose paint, and other loose detrimental foreign matter. It is not intended that adherent mill scale, rust, and paint be removed by this process. Mill scale, rust, and paint are considered adherent if they cannot be removed by lifting with a dull putty knife.

2.3 SSPC-VIS 3 or other visual standard of surface preparation agreed upon by the contracting parties may be used to further define the surface (see Note 8.1).

3. Referenced Standards

3.1 The latest issue, revision, or amendment of the referenced standards in effect on the date of invitation to bid shall govern, unless otherwise specified. Standards marked with an asterisk (*) are referenced only in the Notes, which are not requirements of this standard.

3.2 If there is a conflict between the requirements of any of the cited reference standards and this standard, the requirements of this standard shall prevail.

3.3 SSPC SPECIFICATIONS:

SP 1	Solvent Cleaning
*SP 3	Power Tool Cleaning
*SP 11	Power Tool Cleaning to Bare Metal
*SP 15	Commercial Grade Power Tool Cleaning
VIS 3	Guide and Reference Photographs for Steel Surfaces Prepared by for Power- and Hand-Tool Cleaning

3.4 INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO):

* 8501-1	Preparation of steel substrates before application of paints and related products: Visual assessment of surface cleanliness—Part I.
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4. Surface Preparation Before and After Hand Tool Cleaning

4.1 Before hand tool cleaning, visible deposits of oil, grease, or other materials that may interfere with coating adhesion shall be removed in accordance with SSPC-SP 1 or other agreed-upon methods. Nonvisible surface contaminants such as soluble salts shall be treated to the extent specified by the procurement documents [project specifications] (see Note 8.2).

4.2 After hand tool cleaning and prior to painting, reclean the surface if it does not conform to this standard.

4.3 After hand tool cleaning and prior to painting, remove dirt, dust, or similar contaminants from the surface. Acceptable methods include brushing, blow off with clean, dry air, or vacuum cleaning.

5. Methods of Hand Tool Cleaning

5.1 Use impact hand tools to remove stratified rust (rust scale).

5.2 Use impact hand tools to remove all weld slag.

5.3 Use hand wire brushing, hand abrading, hand scraping, or other similar non-impact methods to remove all loose mill scale, all loose or non-adherent rust, and all loose paint.

5.4 Regardless of the method used for cleaning, if specified in the procurement documents, feather the edges of remaining old paint so that the repainted surface can have a reasonably smooth appearance.

5.5 If approved by the owner, use power tools or blast cleaning as a substitute cleaning method for this standard.

6. Inspection

6.1 Unless otherwise specified in the procurement documents, the contractor or material supplier is responsible for quality control to assure that the requirements of this document are met. Work and materials supplied under this standard are also subject to inspection by the purchaser or an authorized representative. Materials and work areas shall be accessible to the inspector.

6.2 Conditions not complying with this standard shall be corrected. In the case of a dispute, an arbitration or settlement procedure established in the procurement documents (project specification) shall be followed. If no arbitration or settlement procedure is established, then a procedure mutually agreeable to purchaser and material supplier (or contractor) shall be used.

7. Disclaimer

7.1 While every precaution is taken to ensure that all information furnished in SSPC standards and specifications is as accurate, complete, and useful as possible, SSPC cannot assume responsibility nor incur any obligation resulting from the use of any materials, coatings, or methods specified herein, or of the specification or standard itself.

7.2 This standard does not attempt to address problems concerning safety associated with its use. The user of this standard, as well as the user of all products or practices described

herein, is responsible for instituting appropriate health and safety practices and for ensuring compliance with all governmental regulations.

8. Notes

Notes are not requirements of this standard.

8.1 Note that the use of visual standards in conjunction with this standard is required only when they are specified in the procurement documents (project specification) covering the work. It is recommended, however, that the use of visual standards be made mandatory in the procurement documents.

SSPC-VIS 3 provides a suitable comparative visual standard for SSPC-SP 2, SSPC-SP 3, SSPC-SP 11, and SSPC-SP 15. ISO 8501-1 may also serve as a visual standard.

8.2 The SSPC Surface Preparation Commentary (SSPC-SP COM) contains additional information and data relevant to this specification. The Commentary is non-mandatory and is not part of this specification. The table below lists the subjects discussed relevant to hand tool cleaning and the appropriate Commentary Section.

Subject	Commentary Section
Film Thickness	10
Maintenance Painting.....	4.2
Rust, Stratified Rust, Pack Rust, and Rust Scale	4.3.1
Visual Standards	11
Weld Spatter.....	4.4.1



Protective & Marine Coatings

COROTHANE® I MIO-ALUMINUM

B65S14

Revised: April 18, 2019

PRODUCT INFORMATION

5.10

PRODUCT DESCRIPTION

COROTHANE I MIO-ALUMINUM is a single component, moisture curing, aluminum and Micaceous Iron Oxide (MIO) filled urethane primer, intermediate coating, or a finish coat.

- Excellent adhesion to most substrates
- Low temperature application - down to 20°F (-7°C)
- Excellent exterior durability
- Outstanding abrasion resistance
- Excellent corrosion and chemical resistance
- Recoat up to 30 days
- Outstanding application properties

PRODUCT CHARACTERISTICS

Finish:	Matte
Color:	Aluminum
Volume Solids:	65% ± 2%
Weight Solids:	77% ± 2%
VOC (calculated):	<310 g/L; 2.60 lb/gal, Reduced 7% <340 g/L; 2.80 lb/gal

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	3.0 (75)	4.5 (112)
Dry mils (microns)	2.0 (50)	3.0 (75)
~Coverage sq ft/gal (m²/L)	348 (8.5)	521 (12.8)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1040 (25.5)	

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 5.0 mils wet (125 microns):

	@ 40°F/4.5°C	@ 77°F/25°C 50% RH	@ 100°F/38°C
To touch:	4 hours	2 hours	1 hour
To recoat:			
minimum:	16 hours	7 hours	3 hours
maximum:	30 days	30 days	30 days
To cure:	5 days	3 days	1 day

*Abrade surface if maximum recoat time is exceeded.
Drying time is temperature, humidity, and film thickness dependent.*

Shelf Life:	12 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point:	103°F (39°C), PMCC
Reducer/Clean Up:	
Spray:	Reducer #15, R7K15
Brush and Roll:	Reducer #100, R7K100
VOC Exempt:	Reduce R7K111

RECOMMENDED USES

- For use over prepared surfaces in industrial environments
- Heavy Duty interior and exterior structural coating
- High performance, one coat or multiple coat, coating for steel, aluminum, concrete, and most plastics in industrial and marine environments
- Universal primer for poorly prepared surfaces, old paint, tightly adherent rust, weathered galvanized steel, and concrete
- Excellent intermediate coat providing superior adhesion of subsequent coats
- Enhanced film strength and edge protection with aluminum and micaceous iron oxide addition
- Meets requirements of SSPC Paint Spec No. 41

PERFORMANCE CHARACTERISTICS

Substrate*: Steel

Surface Preparation*: SSPC-SP6/NACE 3

System Tested*:

- 1 ct: Corothane I Aluminum @ 3.0 mils (75 microns) dft
- 1 ct: Corothane I Iron Ox B @ 4.0 mils (100 microns) dft
- 1 ct: Corothane I Aliphatic @ 3.0 mils (75 microns) dft

*unless otherwise noted below

Test Name	Test Method	Results
Adhesion	ASTM D4541	1000 psi
Corrosion Weathering (Zinc Primer/Mastic/Aliphatic Finish)	ASTM D5894, 1700 hours, 5 cycles	Rating 9 per ASTM D610 for rusting; Rating 9 per ASTM D714 for blistering
Direct Impact Resistance	ASTM D2794	140 in. lb.
Dry Heat Resistance	ASTM D2485	300°F (149°C)
Flexibility	ASTM D522, 180° bend, 1/8" mandrel	Passes
Moisture Condensation Resistance	ASTM D4585, 100°F (38°C), 300 hours	Passes
Pencil Hardness	ASTM D3363	2B
Salt Fog Resistance (Zinc Primer/Mastic/Aliphatic)	ASTM B117, 2300 hours	Rating 10 per ASTM D610 for Rusting; Rating 10 per ASTM D714 for Blistering



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5.10

RECOMMENDED SYSTEMS

	Dry Film Thickness / ct.	
	Mils	(Microns)
Steel:		
1 ct. Corothane I MIO-Aluminum	2.0-3.0	(50-75)
1 ct. Corothane I Iron Ox B	3.0-5.0	(75-125)
1 ct. Corothane I Aliphatic Finish Coat	2.0-3.0	(50-75)
or Corothane I HS	2.0-3.0	(50-75)
or Corothane I Iron Oxide A HS	2.5-3.5	(63-88)
Steel: (Zinc Primer)		
1 ct. Corothane I GalvaPac Zinc Primer	3.0-4.0	(75-100)
2 cts. Corothane I MIO-Aluminum	2.0-3.0	(50-75)
Concrete: Smooth		
2 cts. Corothane I MIO-Aluminum	2.0-3.0	(50-75)
Concrete: Rough		
1 ct. Kem Cati-Coat HS Epoxy Filler/Sealer	10.0-30.0	(250-750)
as required to fill voids and provide a continuous substrate.		
2 cts. Corothane I MIO-Aluminum	2.0-3.0	(50-75)
Galvanized:		
1-2 cts. Corothane I MIO-Aluminum	2.0-3.0	(50-75)
(Check Compatibility)		
Aluminum:		
1-2 cts. Corothane I MIO-Aluminum	2.0-3.0	(50-75)
(Check Compatibility)		
Previously Painted Steel:		
Spot prime bare steel with 1 coat of Corothane I MIO-Zinc Primer		
1 ct. Corothane I Iron Ox B	3.0-5.0	(75-125)
1 ct. Corothane I Aliphatic Finish Coat	2.0-3.0	(50-75)

The systems listed above are representative of the product's use, other systems may be appropriate.

DISCLAIMER

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SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

Iron & Steel	SSPC-SP2/3
Concrete:	SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3
Galvanized:	SSPC SP-1
Aluminum:	SSPC-SP-1
Previously Painted:	SSP-SP2 or SP-3

Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	SSPC	NACE
White Metal	Sa 3	SP 5	1
Near White Metal	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	SP 7	3
Brush-Off Blast	Sa 1	SP 6	4
Hand Tool Cleaning	Rusted C St 2	SP 2	-
Pitted & Rusted	D St 2	SP 2	-
Power Tool Cleaning	Rusted C St 3	SP 3	-
Pitted & Rusted	D St 3	SP 3	-

TINTING

Do not tint.

APPLICATION CONDITIONS

Temperature:	
air and surface:	20°F (-7°C) minimum, 100°F (38°C) maximum
material:	45°F (7°C) minimum
	Do not apply over surface ice
Relative humidity:	30% minimum, 99% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:	1 gallon (3.78L) and 5 gallon (18.9L) containers
Weight:	10.05 ± 0.2 lb/gal ; 1.26 Kg/L

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.



Protective & Marine Coatings

COROTHANE® I MIO-ALUMINUM

B65S14

Revised: April 18, 2019

APPLICATION BULLETIN

5.10

SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Hand/Power Tool per SSPC-SP2/3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Coat any bare steel the same day as it is cleaned or before flash rusting occurs.

Aluminum

Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910.

Follow the standard methods listed below when applicable:

ASTM D4258 Standard Practice for Cleaning Concrete.
ASTM D4259 Standard Practice for Abrading Concrete.
ASTM D4260 Standard Practice for Etching Concrete.
ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.
SSPC-SP 13/NACE 6 Surface Preparation of Concrete.
ICRI No. 310.2R Concrete Surface Preparation.

Previously Painted Surfaces

If in sound condition, clean the surface of all foreign material. Smooth, hard, or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	SSPC	NACE
White Metal	Sa 3	SP 5	1
Near White Metal	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	SP 7	4
Hand Tool Cleaning	C St 2	SP 2	-
Pitted & Rusted	D St 2	SP 2	-
Rusted	C St 3	SP 3	-
Power Tool Cleaning	D St 3	SP 3	-

APPLICATION CONDITIONS

Temperature:	
air and surface:	20°F (-7°C) minimum, 100°F (38°C) maximum
material:	45°F (7°C) minimum Do not apply over surface ice
Relative humidity:	30% minimum, 99% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up

Spray.....	Reducer #15, R7K15
Brush and Roll	Reducer #100, R7K100
VOC Exempt.....	Reducer R7K111

Airless Spray

Pump.....	30:1
Pressure.....	1800-2000 psi
Hose.....	1/4" ID
Tip015" - .019"
Filter.....	60 mesh
Reduction.....	As needed up to 10% by volume

Conventional Spray

Unit.....	Graco	Binks
Gun	900	95
Fluid Nozzle	070	66/65
Air Nozzle.....	947	66PR
Atomization Pressure.....	60-70 psi	60-70 psi
Fluid Pressure.....	15-20 psi	15-20 psi
Reduction.....	As needed up to 10% by volume	

Brush

Brush.....	Natural Bristle
Reduction.....	As needed up to 10% by volume

Roller

Cover	1/4" natural or synthetic with solvent resistant core
Reduction.....	As needed up to 10% by volume

If specific application equipment is not listed above, equivalent equipment may be substituted.



Protective & Marine Coatings

COROTHANE® I MIO-ALUMINUM

B65S14

Revised: April 18, 2019

APPLICATION BULLETIN

5.10

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix thoroughly prior to use with a low speed power agitator. Filter slowly through a 55 mesh screen.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	3.0 (75)	4.5 (112)
Dry mils (microns)	2.0 (50)	3.0 (75)
~Coverage sq ft/gal (m ² /L)	348 (8.5)	521 (12.8)
Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft	1040 (25.5)	

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 5.0 mils wet (125 microns):

	@ 40°F/4.5°C	@ 77°F/25°C 50% RH	@ 100°F/38°C
To touch:	4 hours	2 hours	1 hour
To recoat:			
minimum:	16 hours	7 hours	3 hours
maximum:	30 days	30 days	30 days
To cure:	5 days	3 days	1 day

Abrade surface if maximum recoat time is exceeded.

Drying time is temperature, humidity, and film thickness dependent.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer #15, R7K15. Clean tools immediately after use with Reducer #15, R7K15. Follow manufacturer's safety recommendations when using any solvent.

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PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer #15, R7K15.

Pour a small amount of Reducer #15, R7K15 over the top of the paint in the can to prevent skinning or gelling.

Place a temporary cover over the pail to keep excessive moisture, condensation, fog, or rain from contaminating the coating.

Corothane KA Accelerator is acceptable for use. See its data page for details.

It is recommended that partially used cans not be sealed/closed for use at a later date.

Refer to Product Information sheet for additional performance characteristics and properties.

SAFETY PRECAUTIONS

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WARRANTY

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Protective & Marine Coatings
PRODUCT DATA SHEET



SHER-LOXANE® 800
TWO COMPONENT POLYSILOXANE

Revised: March 19, 2019

PRODUCT DESCRIPTION

SHER-LOXANE 800 is a versatile, high performance, two component polysiloxane (epoxy siloxane hybrid) that combines the properties of both a high performance epoxy and a polyurethane.

INTENDED USES

- Recommended for use on new construction, repair and field maintenance coating projects. It provides effective long-term corrosion control and weatherability.
- Can be applied directly over inorganic zincs
- <100 g/L VOC, no isocyanates

PRODUCT DATA

Finish:	Gloss
Colors:	Wide range of colors available
Volume Solids:	90% ± 3%, mixed
VOC (EPA Method 24):	<100 g/L; 0.77 lb/gal
Mix Ratio:	4:1 by volume
Typical Thickness:	
Recommended Spreading Rate per coat:	
	Minimum Maximum
Wet mils (microns)	5.0 (125) 7.0 (175)
Dry mils (microns)	4.0 (100) 6.0 (150)
~Coverage sq ft/gal (m²/L)	240 (6.0) 360 (9.0)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1443 (35.4)
<i>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</i>	
Shelf Life:	12 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point:	Part A: >200°F (93°C), PMCC Part B: 145°F (63°C), PMCC
Reducer:	Not required (MEK or Oxsol 100)
Clean Up:	MEK, MIBK, MAK, Oxsol 100
Weight:	10.90 ± 0.2 lb/gal ; 1.3 Kg/L, mixed May vary by color

Average Drying Times @ 5.0 mils wet (125 microns):

	40°F (4.5°C)	77°F (25°C)	90°F (32°C)
	50% RH	50% RH	50% RH
Touch:	8 hours	2 hours	1.5 hours
Handle:	21 hours	6 hours	4 hours
Recoat:			
minimum:	16 hours	3 hours	1.5 hours
maximum:	1 year	1 year	1 year
Cure to service:	7-8 days	7 days	3 days
Pot Life*:		4 hours	
Sweat-in-time:		none required	

*Pot life is dependent upon temperature and mass

*If maximum recoat time is exceeded, abrade surface before recoating.
Drying time is temperature, humidity, and film thickness dependent.*

Packaging:

- 1.25 gallons (4.7L) mixed
 - Part A:** 1 gallon (3.8L) in a 1 gallon (3.8L) container
 - Part B:** 1 quart (0.9L) container
- 5 gallons (18.9L) mixed
 - Part A:** 4 gallons (15.1L) in a 5 gallon (18.9L) container
 - Part B:** 1 gallon (3.78L) container

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Minimum recommended surface preparation:

- Iron & Steel:** Atmospheric: SSPC-SP6/NACE 3/ ISO8501-1:2007 Sa 2, 2-3 mil profile (50-75 microns)
- Concrete & Masonry:** Atmospheric: SSPC-SP13/NACE 6 - 4.3.1 or 4.3.2 or ICRI No. 310.2R CSP 2-3
- Galvanized:** Sweep blast to SSPC SP-16 with a blast profile of 1.5-3 mils (40-75 microns)



Protective & Marine Coatings
PRODUCT DATA SHEET



SHER-LOXANE® 800

TWO COMPONENT POLYSILOXANE

APPLICATION	APPLICATION CONDITIONS																																																																											
<p>Airless Spray Pump.....35:1 minimum Pressure.....2000 psi minimum (137 bar) Tip0.015"-0.019" (0.38-0.48 mm)</p> <p>Conventional Spray GunBinks 95 Fluid Nozzle67 Air Nozzle.....667 Atomization Pressure.....60 psi (4 bar) Fluid Pressure.....20 psi (0.7 bar)</p> <p>Plural Component Spray Consult your SW sales or technical service representative</p> <p>Brush Brush.....Natural Bristle Note: Required film thickness may not be achieved in one coat</p> <p>Roller Cover3/8" woven with solvent resistant core</p> <p>If specific application equipment is not listed above, equivalent equipment may be substituted.</p>	<p>Temperature (air, surface, material): 40°F (4.5°C) minimum, 120°F (49°C) maximum At least 5°F (2.8°C) above dew point</p> <p>Relative humidity: 40-85% recommended <i>Note: <40% RH will increase dry times; >85% will decrease dry times</i></p>																																																																											
	APPROVALS																																																																											
	<ul style="list-style-type: none"> Meets USDA requirement for incidental contact Two coats of Sher-Loxane 800 @ 100 microns per coat applied direct-to-metal is in full accordance with the requirements of ISO 12944-6 (1998), Corrosivity Category C3 High. 																																																																											
	ADDITIONAL NOTES																																																																											
	<p>Tint 150% tint strength with Maxitoner Colorants only into Part A. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.</p> <p>Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.</p> <p>Do not mix previously catalyzed material with new.</p>																																																																											
RECOMMENDED SYSTEMS																																																																												
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