SCHEDULE

Interior Finishes

Concrete Block (Repaint Over Existing)

First Coat: B73W00111 - Waterbased Tile-Clad® Epoxy

Walls to be wiped clean with Denatured Alcohol to remove all signs of Dirt, Debris etc. Sheen to be scuff sanded to dull finish-

Second Coat: B73W00111 - Waterbased Tile-Clad® Epoxy

2nd Coat may be required assuming a color change to be made

Steel (Doors and Frames)

First Coat: B54W00101 - Industrial Enamel Pure White

Scuff sand and solvent clean full surface prior to coating application.

Second Coat: B54W00101 - Industrial Enamel Pure White

2nd Coat may be required due to color Change from existing

Concrete (Floors)

First Coat: B70A08101 - AS 8100 WB Epoxy DK GRY A

Recommended full grind to remove existing. If not fully grinding existing, new coating will only be as good as existing for adhesion.

Second Coat: B70A08101 - AS 8100 WB Epoxy DK GRY A

2nd Coat may be required

END OF SECTION

SURFACE PREPARATION

1) Previously Coated Surfaces
Maintenance painting will frequently not permit or require complete removal of all old coatings prior to repainting. However, all surface contamination such as oil, grease, loose paint, mill scale, dirt, foreign matter, rust, mold, mildew, mortar, efflorescence, and sealers must be removed to assure sound bonding to the tightly adhering old paint. Glossy surfaces of old paint films must be clean and dull before repainting. Thorough washing with an abrasive cleanser will clean and dull in one operation, or, wash thoroughly and dull by sanding. Spot prime any bare areas with an appropriate primer.
Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system. Check for compatibility by applying a test patch of the recommended coating system, covering at least 2 to 3 square feet. Allow to dry one week before testing adhesion per ASTM D3359. If the coating system is incompatible, complete removal is required.

END OF SPECIFICATION

Data Pages

Protective & Marine Coatings

WATERBASED TILE-CLAD®
EPOXY FINISH

PART A	B73-100	SERIES
PART B	B73V100	HARDENER

Revised Nov 25, 2015

PRODUCT INFORMATION

4.19

PRODUCT DESCRIPTION

WATERBASED TILE-CLAD EPOXY FINISH is a two component, low VOC, high performance, water based, epoxy/cycloaliphatic amine finish coating. Developed for use in industrial environments. Waterbased Tile-Clad is a high gloss, abrasion resistant, low yellowing epoxy finish with excellent weathering properties.

- Early moisture resistance
- Chemical resistant
- Impact and abrasion resistant
- Low odor
- Outstanding application properties
- Resists yellowing
- Fast dry
- Nonflammable
- Low VOC

PRODUCT CHARACTERISTICS

Finish:	High Gloss
Color:	Wide range of colors available
Volume Solids:	44% ± 2%, mixed
Weight Solids:	54% ± 2%, mixed
VOC (EPA Method 24):	<200 g/L; 1.67 lb/gal, mixed
Mix Ratio:	4:1

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**4.5** (112)	**9.0** (225)
Dry mils (microns)	**2.0** (50)	**4.0** (100)
~Coverage sq ft/gal (m^2/L)	**176** (4.3)	**352** (8.6)
Theoretical coverage **sq ft/gal** (m^2/L) @ 1 mil / 25 microns dft	**704** (17.2)	

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):

	@ 50°F/10°C	@ 77°F/25°C *50% RH*	@ 100°F/38°C
To touch:	1.5 hours	45 minutes	25 minutes
To handle:	5.5 hours	4.5 hours	2 hours
To recoat:			
minimum:	8 hours	6 hours	3 hours
maximum:	30 days	30 days	30 days
To cure:	7 days	7 days	7 days
Pot Life:	4.5 hours	3.5 hours	1.5 hours
Sweat-in-time:	30 minutes	30 minutes	10 minutes

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

Shelf Life:	36 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point:	>200°F (93°C), SETA Flash, mixed
Reducer/Clean Up:	Water

RECOMMENDED USES

For use over prepared steel and concrete surfaces in industrial exposures such as:

- Marine applications
- Structural steel
- Storage tank exteriors
- Nuclear power facilities
- Food processing facilities
- Wastewater treatment facilities
- Manufacturing plants
- Pulp and paper mills
- Pharmaceutical facilities
- Clean rooms
- Bridges

- Suitable for use in USDA inspected facilities
- Conforms to AWWA D102 OCS #5
- Acceptable for general purpose use on floors.
- Acceptable for use in high performance architectural applications.
- Complies with performance criteria of SSPC Paint 34.

PERFORMANCE CHARACTERISTICS

Substrate*: Steel

Surface Preparation*: SSPC-SP10 / NACE 2

System Tested*:
1 ct. Waterbased Tile-Clad Epoxy Primer @ 4.0 mils (100 microns) dft
1 ct. Waterbased Tile-Clad Epoxy @ 4.0 mils (100 microns) dft
*unless otherwise noted below

Test Name	Test Method	Results
Abrasion Resistance (topcoat only)	ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load	120 mg loss
Adhesion	ASTM D4541	550 psi
Corrosion Weathering	ASTM D5894, 20 cycles, 6720 hours	Passes
Dry Heat Resistance	ASTM D2485	250°F (121°C)
Flexibility	ASTM D522, 180° bend, 1/4" mandrel	Passes
Impace Resistance, Direct (topcoat only)	ASTM D2794	160 in. lb.
Impact Resistance, Indirect (topcoat only)	ASTM D2794	100 in. lb.
Irradiation-Effects on Coatings used in Nuclear Power Plants	ANSI 5.12 / ASTM D4082-89	Passes
Moisture Condensation Resistance	ASTM D4585, 100°F (38°C), 2000 hours	Passes
Pencil Hardness	ASTM D3363	HB
Salt Fog Resistance	ASTM B117, 2000 hours	Passes
Surface Burning*	ASTM E84/NFPA 255	Flame Spread Index 15; Smoke Development Index 5
Thermal Shock	ASTM D2246, 20 cycles	Passes

*Report No. IM54.1157-01-01

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Protective & Marine Coatings

WATERBASED TILE-CLAD®
EPOXY FINISH

PART A	B73-100	SERIES
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PRODUCT INFORMATION

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RECOMMENDED SYSTEMS

		Dry Film Thickness / ct. Mils	(Microns)
Steel:			
1 ct.	Waterbased Tile-Clad Epoxy Primer	2.0-4.0	(50-100)
1-2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)
Steel:			
1 ct.	ProCryl Universal WB Primer	3.0-4.0	(75-100)
1-2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)
Steel:			
1 ct.	Recoatable Epoxy Primer	4.0-6.0	(100-150)
1-2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)
Concrete/Masonry:			
1 ct.	Cement-Plex 875	13.0-25.0	(325-625)
(as required to fill voids and provide a continuous surface)			
Other acceptable surfacers are:			
	Heavy Duty Block Filler		
	Kem Cati-Coat HS Epoxy Filler/Sealer		
Topcoat			
1-2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)
Concrete, smooth:			
2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)
Galvanized Steel:			
1 ct.	Waterbased Tile-Clad Epoxy Primer	2.0-4.0	(50-100)
1-2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)
Drywall:			
1 ct.	ProMar 200 Interior Latex Primer	1.0-1.4	(25-35)
2 cts.	Waterbased Tile-Clad Epoxy Finish	2.0-4.0	(50-100)

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.

Do not use hydrocarbon solvents for cleaning.

Minimum recommended surface preparation:

* Iron & Steel:	SSPC-SP2
Galvanizing:	SSPC-SP1
Concrete & Masonry:	SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3
Wood, interior:	Clean, smooth, dust free

* Primer recommended

Surface Preparation Standards

	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted	C St 2	C St 2	SP 2	-
	Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted	C St 3	C St 3	SP 3	-
	Pitted & Rusted	D St 3	D St 3	SP 3	-

TINTING

Tint Part A with EnviroToner Colorants at 100% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Do not use Blend-A-Color Toner.

APPLICATION CONDITIONS

Temperature:	50°F (10°C) minimum, 100°F (38°C) maximum (air, surface, and material)
	At least 5°F (2.8°C) above dew point
Relative humidity:	85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:	5 gallons (18.9L) mixed
Part A:	4 gallons (15.1L) in a 5 gallon (18.9L) can and 1 gallon (3.78L)
Part B:	1 gallon (3.78L) and 1 quart (0.94L)
Weight per gallon:	10.5 ± 0.2 lb ; 1.26 Kg/L, mixed

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

WATERBASED TILE-CLAD®
EPOXY FINISH

PART A	B73-100	SERIES
PART B	B73V100	HARDENER

Revised Nov 25, 2015

APPLICATION BULLETIN

4.19

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.

Do not use hydrocarbon solvents for cleaning.

Iron & Steel
Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1 (recommended preparation is Steam Cleaning). For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel within 8 hours or before flash rusting occurs. Primer required.

Masonry and Block
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 Cement-Plex 875. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get to a hard, firm surface. Laitance must be removed.

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 (recommended preparation is Steam Cleaning). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 (recommended preparation is Steam Cleaning) 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.

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	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted	C St 2	C St 2	SP 2	-
	Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted	C St 3	C St 3	SP 3	-
	Pitted & Rusted	D St 3	D St 3	SP 3	-

APPLICATION CONDITIONS

Temperature:	50°F (10°C) minimum, 100°F (38°C) maximum (air, surface, and material) At least 5°F (2.8°C) above dew point
Relative humidity:	85% 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 ..... Water

Airless Spray
Pressure.....2000 psi
Hose.....1/4" ID
Tip .....015" - .017"
Filter .....60 mesh
Reduction.....As needed up to 10% by volume

Conventional Spray
Gun .....DeVilbiss MBC-510
Fluid Tip .....E
Air Nozzle.....704
Atomization Pressure.....40-60 psi
Fluid Pressure.....10-20 psi
Reduction.....As needed up to 10% by volume

Brush
Brush.....Nylon/Polyester
Reduction.....Not recommended

Roller
Cover .....3/8" woven with solvent resistant core
Reduction.....Not recommended

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

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Protective & Marine Coatings

WATERBASED TILE-CLAD®
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APPLICATION BULLETIN

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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly using low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine four parts by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated prior to application. Re-stir before using.

If reducer is used, add only after both components have been thoroughly mixed, after sweat-in.

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

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**4.5** (112)	**9.0** (225)
Dry mils (microns)	**2.0** (50)	**4.0** (100)
~Coverage sq ft/gal (m^2/L)	**176** (4.3)	**352** (8.6)
Theoretical coverage **sq ft/gal** (m^2/L) @ 1 mil / 25 microns dft	**704** (17.2)	

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):

	@ 50°F/10°C	@ 77°F/25°C *50% RH*	@ 100°F/38°C
To touch:	1.5 hours	45 minutes	25 minutes
To handle:	5.5 hours	4.5 hours	2 hours
To recoat:			
minimum:	8 hours	6 hours	3 hours
maximum:	30 days	30 days	30 days
To cure:	7 days	7 days	7 days
If maximum recoat time is exceeded, abrade surface before recoating.			
Drying time is temperature, humidity, and film thickness dependent.			
Pot Life:	4.5 hours	3.5 hours	1.5 hours
Sweat-in-time:	30 minutes	30 minutes	10 minutes

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 soap and warm water. Clean hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with Mineral Spirits, R1K4, to prevent rusting of the equipment. 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.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with water.

Do not use hydrocarbon solvents for cleaning.

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

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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WARRANTY

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Protective & Marine Coatings

INDUSTRIAL ENAMEL

B54 SERIES

Revised May 20, 2014

PRODUCT INFORMATION

2.15

PRODUCT DESCRIPTION

INDUSTRIAL ENAMEL is a medium oil/alkyd all-purpose enamel. Designed for interior and exterior use.

- Dries fast and allows equipment to be placed back in service quickly
- Impact and abrasion resistant
- Chip and flake resistant
- High gloss makes it resistant to dirt
- Apply down to 40°F (4.5°C)
- Good exterior durability
- Excellent application properties

PRODUCT CHARACTERISTICS

Finish:	Gloss
Color:	Wide range of colors available including safety colors
Volume Solids:	43% ± 2%, may vary by color
Weight Solids:	58% ± 2%, may vary by color
VOC (calculated):	<450 g/L; 3.75 lb/gal

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**4.5** (112)	**9.0** (225)
Dry mils (microns)	**2.0** (50)	**4.0** (100)
~Coverage sq ft/gal (m^2/L)	**175** (4.3)	**350** (8.6)
Theoretical coverage sq ft/gal (m^2/L) @ 1 mil / 25 microns dft	**690** (16.9)	

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

Drying Schedule @ 4.6 mils wet (115 microns):

	@ 50°F/10°C	@ 77°F/25°C *50% RH*	@ 110°F/43°C
To touch:	3 hours	1-2 hours	30 minutes
Tack free:	8 hours	4-5 hours	4 hours
To recoat:	12 hours	8 hours	3 hours
To cure:	7 days	7 days	3 days

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

Shelf Life:	36 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
Flash Point:	101°F (38°C), PMCC
Reducer:	Not recommended
Clean Up:	Mineral Spirits, R1K4

RECOMMENDED USES

For use over prepared substrates in industrial environments:

- Exterior/interior all-purpose maintenance enamel
- Safety and pipe marking enamel
- Economical machinery and equipment finish
- Interior wall and ceiling enamel

• Equipment	• Fixtures	• Conveyors
• Fire escapes	• Window frames	• Pumps
• Safety markings	• Wood floors	• Railings
• Steel supports	• Blowers	• Pipe racks
• Channels	• Pipe identification	• Bracing

- Conforms to AWWA D102, OCS #1
- Acceptable for use in high performance architectural applications.
- Suitable for use in USDA inspected facilities

PERFORMANCE CHARACTERISTICS

Substrate*: Steel

Surface Preparation*: SSPC-SP6/NACE 3

System Tested*:

1 ct. Kem Kromik Universal Metal Primer @ 3.0-4.0 mils (75-100 microns) dft
1 ct. Industrial Enamel @ 3.0 mils (75 microns) dft

*unless otherwise noted below

Test Name	Test Method	Results
Abrasion Resistance (topcoat only)	ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load	180 mg loss
Adhesion	ASTM D4541	290 psi
Corrosion Weathering	ASTM D5894, 6 cycles, 2016 hours	Rating 10 per ASTM D610 for rusting ; Rating 10 per ASTM D714 for blistering
Direct Impact Resistance	ASTM D2794	68 in. lbs.
Dry Heat Resistance	ASTM D2485	200°F (93°C)
Flexibility	ASTM D522, 180° bend, 3/16" mandrel	Passes
Pencil Hardness	ASTM D3363	3B

Provides performance comparable to products formulated to federal specifications:

DOD-E-115C
MIL-E-15090

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Protective & Marine Coatings

INDUSTRIAL ENAMEL

B54 SERIES

Revised May 20, 2014

PRODUCT INFORMATION

2.15

RECOMMENDED SYSTEMS

		Dry Film Thickness / ct. Mils	(Microns)
Steel:			
1 ct.	Kem Kromik Universal Metal Primer	3.0-4.0	(75-100)
2 cts.	Industrial Enamel	2.0-4.0	(50-100)
Aluminum:			
1 ct.	DTM Wash Primer	0.7-1.3	(18-32)
2 cts.	Industrial Enamel	2.0-4.0	(50-100)
Concrete Block:			
1 ct.	Heavy Duty Block Filler	10.0-18.0	(250-450)
2 cts.	Industrial Enamel	2.0-4.0	(50-100)
Concrete Floors:			
1 ct.	Concrete and Terrazzo Sealer (reduced as needed)		
2 cts.	Industrial Enamel	2.0-4.0	(50-100)
Galvanized Metal:			
1 ct.	Galvite HS	3.0-4.5	(75-112)
2 cts.	Industrial Enamel	2.0-4.0	(50-100)
Wood, including floors:			
2 cts.	Industrial Enamel	2.0-4.0	(50-100)
Interior Plaster and Poured Concrete Walls:			
1ct.	PrepRite Masonry Primer	3.0	(75)
2 cts.	Industrial Enamel	2.0-4.0	(50-100)

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

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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
* Aluminum: SSPC-SP1
* Galvanizing: SSPC-SP1
* Concrete & Masonry: SSPC-SP13/NACE 6 or ICRI No. 310.2R, CSP 1-3
* Wood, interior: Clean, smooth, dust free

*Primer required

Surface Preparation Standards

	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted	C St 2	C St 2	SP 2	-
	Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted	C St 3	C St 3	SP 3	-
	Pitted & Rusted	D St 3	D St 3	SP 3	-

TINTING

Tint with Blend-A-Color Toner or Maxitoner Colorant at 75% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

APPLICATION CONDITIONS

Temperature:	40°F (4.5°C) minimum, 120°F (49°C) maximum (air, surface, and material)
	At least 5°F (2.8°C) above dew point
Relative humidity:	85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:	1 gallon (3.78L) and 5 gallon (18.9L) containers
Weight:	8.82 ± 0.2 lb/gl, 1.06 Kg/L may vary with color

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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WARRANTY

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Protective & Marine Coatings

INDUSTRIAL ENAMEL

B54 Series

Revised May 20, 2014

Application Bulletin

2.15

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
Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel within 8 hours or before flash rusting occurs.

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

Galvanized Steel
Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1 (recommended solvent is VM&P Naphtha). 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. Primer required.

Masonry and Concrete
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. 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 a cement patching compound. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get to a hard, firm surface. Laitance must be removed. Primer required.

Wood
Surface must be clean, dry, and sound. Paint as soon as possible. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed. All nail holes or small openings must be properly caulked. Sand to remove any loose or deteriorated surface wood and to obtain a proper surface profile. Self priming.

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, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. 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	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted	C St 2	C St 2	SP 2	-
	Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted	C St 3	C St 3	SP 3	-
	Pitted & Rusted	D St 3	D St 3	SP 3	-

Application Conditions

Temperature:	40°F (4.5°C) minimum, 120°F (49°C) maximum (air, surface, and material) At least 5°F (2.8°C) above dew point
Relative humidity:	85% 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 .....Not recommended

Clean Up .....Mineral Spirits, R1K4

Airless Spray
Pressure.....2500 psi
Hose.....1/4" ID
Tip .....015"
Filter.....100 mesh

Conventional Spray
Gun .....Binks 95
Fluid Nozzle 66
Air Nozzle.....63PB
Atomization Pressure.....50 psi
Fluid Pressure.....20-25 psi

Brush
Brush.....Natural Bristle

Roller
Cover .....3/8" woven solvent resistant core

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

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Protective & Marine Coatings

INDUSTRIAL ENAMEL

B54 SERIES

Revised May 20, 2014

APPLICATION BULLETIN

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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Mix paint thoroughly to a uniform consistency with low speed power agitation prior to use.

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

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**4.5** (112)	**9.0** (225)
Dry mils (microns)	**2.0** (50)	**4.0** (100)
~Coverage sq ft/gal (m^2/L)	**175** (4.3)	**350** (8.6)
Theoretical coverage sq ft/gal (m^2/L) @ 1 mil / 25 microns dft	**690** (16.9)	

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

Drying Schedule @ 4.6 mils wet (115 microns):

	@ 50°F/10°C	@ 77°F/25°C *50% RH*	@ 110°F/43°C
To touch:	3 hours	1-2 hours	30 minutes
Tack free:	8 hours	4-5 hours	4 hours
To recoat:	12 hours	8 hours	3 hours
To cure:	7 days	7 days	3 days

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 Mineral Spirits, R1K4. Clean tools immediately after use with Mineral Spirits, R1K4. Follow manufacturer's safety recommendations when using any solvent.

DISCLAIMER

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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.

No reduction of material is recommended as it 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 Mineral Spirits, R1K4.

Deep tinted colors may exhibit burnishing characteristics.

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

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.

ArmorSeal Heavy Duty Floor Coatings

ARMORSEAL® 8100
WATER BASED EPOXY FLOOR COATING

PART A B70-8100 SERIES GLOSS
PART A B70-8160 SERIES SATIN
PART B B70V8100 HARDENER

Revised: February. 13, 2017

PRODUCT INFORMATION

8.18

PRODUCT DESCRIPTION

ARMORSEAL 8100 is the next generation in water based epoxy floor coatings; a two-component polyamine epoxy with excellent chemical and abrasion resistance that is breathable. It is designed for use in commercial, industrial and residential floor applications. A LEED 4.2 compliant material that offers improved performance while maintaining ease of application properties common to water based materials. This versatile material is self-priming over concrete, can be used as a stand alone coating or as a receiver coat for paint chip floors. Available in a gloss or satin finish

- Breathable
- <50 g/L
- Color Retention, resists yellowing
- Resists disbondment due to Moisture Vapor Transmission (MVT)
- Ease of application

PRODUCT CHARACTERISTICS

Finish:	Gloss or Satin
Color:	Clear*,Tile Red, Deck Gray, Haze Gray and a wide range of tinted colors using CCE colorants
Safety Colors	Gloss only

* For Clear, use the Ultra Deep Base (for more detail, see Application Bulletin Performance Tips

Volume Solids:	41% ± 2%, mixed, may vary by color
Weight Solids:	50% ± 2%, mixed, may vary by color
VOC (EPA Method 24):	<50 g/L; 0.42 lb/gal, mixed
Mix Ratio:	4:1 by volume

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**5.0** (125)	**12.0** (300)
Dry mils (microns)	**2.0** (50)	**5.0** (125)
~Coverage sq ft/gal (m^2/L)	**130** (3.3)	**320** (8.1)

NOTE: Brush or roll to cove base or vertical surfaces may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 7.0 mils wet (175 microns):

	@ 50°F/10°C	@ 77°F/25°C *50% RH*	@ 120°F/49°C
To touch:	1 hour	45 minutes	25 minutes
To recoat*:			
minimum:	8 hours	6 hours	3 hours
maximum:	30 days	30 days	30 days
To Cure	7 days	7 days	7 days
Foot Traffic:		18 hours	
Heavy Traffic:		48 hours	

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

*If recoating after 30 days, abrade surface first.

Pot Life:	8 hours	5½ hours	3½ hours
Sweat-in-Time:	None	None	None

Shelf Life:	Part A: 24months, unopened Part B: 36 months Store indoors at 40°F (4.5°C) to 100°F (38°C)
Flash Point:	>230°F (110°C), Seta Flash, mixed
Reducer/Clean Up:	Water

RECOMMENDED USES

Durable epoxy floor coating for general purpose use in industrial and commercial environments, such as:

- Warehouse Floors
- Garages
- Residential
- Automotive Showrooms
- Industrial and Commercial Floors
- Light manufacturing Plants
- Acceptable for use in USDA inspected facilities

PERFORMANCE CHARACTERISTICS

Substrate: Concrete

Surface Preparation: Clean, dry, sound

System Tested:

2 cts. ArmorSeal 8100 @ 2.0 - 4.0 mils (50-100 microns) dft

Test Name	Test Method	Results
Abrasion Resistance	ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load	150 mg loss
Adhesion	ASTM D4541	550 psi concrete
Finish	Satin Gloss	15-25 units@ 85º 90+ units @ 60º
Flexibility	ASTM D 522	180º bend 1/8" mandrel
Impact Resistance	ASTM D2794	Direct 100 in.lb. Indirect 80 in.lb.
Pencil Hardness	ASTM D3363	H
Slip Resistance, Floors	ASTM C1028**, .60 Minimum Static Coefficient of Friction	Passes wet and dry, with and without SharkGrip Additive
WVP Perms (US)	Grains(hr ft2 in Hg)	Gloss – 2.0 Satin – 5.0
Hot Tire Pick-up	ITM @ 140ºF (60ºC)	Passes

**Test method withdrawn in 2014 without replacement

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ArmorSeal Heavy Duty Floor Coatings

ARMORSEAL® 8100
WATER BASED EPOXY FLOOR COATING

PART A	B70-8100 SERIES	GLOSS
PART A	B70-8160 SERIES	SATIN
PART B	B70V8100	HARDENER

Revised: February. 13, 2017

PRODUCT INFORMATION

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RECOMMENDED SYSTEMS

		Dry Film Thickness / ct. Mils	(Microns)
Concrete Floors, unpainted:			
1 ct.	ArmorSeal 8100	2.0-4.0	(50-100)
	(reduced with one pint of water per gallon)		
2 cts.	ArmorSeal 8100	2.0-4.0	(50-100)
Concrete Floors, previously painted:			
1 ct.	Spot prime bare areas with ArmorSeal 8100	2.0-4.0	(50-100)
2 cts.	ArmorSeal 8100	2.0-4.0	(50-100)

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

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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.

Do not use hydrocarbon solvents for cleaning.

Minimum recommended surface preparation:
Concrete & Masonry: SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP1-3

TINTING

Tint part A with CCE colorants at 100% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

APPLICATION CONDITIONS

Temperature:	50°F (10°C) minimum, 100°F (38°C) maximum (air, surface, and material) At least 5°F (2.8°C) above dew point
Relative humidity:	85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:	1 gallon (3.78L) and 5 gallon (18.9L) containers
Weight:	9.9 ± 0.2 lb/gal ; 1.12 Kg/L mixed, may vary by color

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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WARRANTY

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PART A	B70-8100 SERIES	GLOSS
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Revised: February. 13, 2017

APPLICATION BULLETIN

8.18

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.

Do not use hydrocarbon solvents for cleaning.

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. Primer required.

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	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	-

APPLICATION CONDITIONS

Temperature:	50°F (10°C) minimum, 100°F (38°C) maximum (air, surface, and material) At least 5°F (2.8°C) above dew point
Relative humidity:	85% maximum

APPLICATION EQUIPMENT

The following is a guide. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up .....Water
Clear/Ultradeep tint base requires reduction of 5% by volume

Brush
Brush.....Nylon/Polyester or Natural Bristle
Reduction.....as needed up to 10% by volume, for primer coat only

Roller
Cover .....1/4"-3/8" woven with solvent resistant core
Reduction.....as needed up to 10% by volume, for primer coat only

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

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ArmorSeal Heavy Duty Floor Coatings

ARMORSEAL® 8100
WATER BASED EPOXY FLOOR COATING

PART A B70-8100 SERIES GLOSS
PART A B70-8160 SERIES SATIN
PART B B70V8100 HARDENER

Revised: February. 13, 2017

APPLICATION BULLETIN

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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine four parts by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation.

If reducer is used, add only after both components have been thoroughly mixed.

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

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**5.0** (125)	**12.0** (300)
Dry mils (microns)	**2.0** (50)	**5.0** (125)
~Coverage sq ft/gal (m^2/L)	**130** (3.3)	**320** (8.1)

NOTE: Brush or roll to cove base or vertical surfaces may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 7.0 mils wet (175 microns):

	@ 50°F/10°C	@ 77°F/25°C *50% RH*	@ 120°F/49°C
To touch:	1 hour	1 hour	30 minutes
To recoat*:			
minimum:	8 hours	6 hours	3 hours
maximum:	30 days	30 days	30 days
To Cure	7 days	7 days	7 days
Foot Traffic:	36 hours	18 hours	8 hours
Pot Life:	8 hours	5½ hours	3½ hours
Sweat-in-Time:	None	None	None

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

*If recoating after 30 days, abrade surface first.

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 soap and warm water. Clean hands and tools immediately after use with soap and warm water.

DISCLAIMER

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PERFORMANCE TIPS

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. Plan painting schedules to avoid these influences during the first 16-24 hours of curing.

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.

For Clear applications, use the Ultra Deep Base, reduce 5% with potable water. When first mixed and applied, the material is white, but will dry Clear. DO NOT exceed 10 mils WFT. Avoid puddling material at edges or in depressions as it may not dry clear.

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

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

Always test adhesion by applying a test patch of 2-3 square feet. Allow to dry one week before checking adhesion.

Do not use hydrocarbon solvents for cleaning.

Anti-slip additives, such as H&C SharkGrip® or Armorseal Hi-Wear Additive, may be added to the coating to provide some slip resistance. This product should not be used in place of a non-skid finish.

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

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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WARRANTY

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