



SEAPOXY 73

November 2015

Multi-purpose Re-coatable Anti Corrosive Epoxy Primer

Product Description:

SEAPOXY 73 is a high Solids, , two component polyamide epoxy primer designed for use in marine environments to protect steel and other non-ferrous metal substrates from corrosion. It is also applicable on gel-coat, fiberglass and wood substrates. This product has excellent adhesion forms a tough, durable, anti-corrosive film at ambient temperatures as low as 40°F (+5°C). This epoxy primer is specifically formulated to allow extended re-coat interval with itself and without the need to abrasive blast the surface. It is specially designed to be used in conjunction with SEA-SPEED V10 X Hard Film Siloxane Foul Release Coating.

Features and Advantages:

- Low VOC - 2.08 lbs./gal (250 g/liter) EPA Method 24
- Excellent saltwater (immersion) resistance
- Excellent corrosion resistance
- Low temperature cure
- May be recoated with a variety of solvent-borne coatings with extended time interval
- Available in grey or red oxide and white

Recommended Uses:

SEAPOXY 73 is designed as a multipurpose primer for a variety of uses primarily for marine applications including immersion service and splash zone service. This product can also be used on all types of vessels and off-shore equipment in salt corrosive atmospheres.

Product Data:

Coating Type: Two Component Polyamide Epoxy

VOC: (as used) 2.08 lbs. /gal (250 g/L)

VOC: (minus exempt) 2.08 lbs. /gal (250 g/L)

Volume Solids: 73.0% (+/- 2%)

Weight Solids: 85.1% (+/- 2%)

Density: 12.9 lbs. /gal (1.55Kg/L) mixed

Mixing Ratio

By Volume: 1 Part A (Activator) to 1 Part B (Base)

Film Thickness: **5 mils** Dry Film Thickness =125 microns DFT
Apply at **7 mils** (175 microns) Wet Film Thickness per coat

Immersion service: two 5 mil ((125 micron) coats = **10+mils (250 microns) DFT**

Coverage: 234 sq. ft. /gallon (5.75 sq meters/liter)@ (5 Mils DFT)

Mixing: Thoroughly mix each component separately until uniform re-disperse any pigments or solids that may have settled during shipment. An air driven or other mechanical power mixer (Jiffy Mixer) is recommended. Add 1 part of component A = Activator to 1 part of component B = Base by volume and mix thoroughly until uniform. This is a two component product and it will not dry or cure without the proper combination and amount of Part A and Part B. Allow the mixture to sweat in 20-30 minutes before applying. Remix prior to starting application to ensure all pigments are well dispersed.

Application:

Check weather conditions before attempting exterior applications. Apply only in good weather or in areas protected from exterior environmental conditions. Air and substrate temperatures must be at least 35°F or higher and should be 5°F (3°C) above the dew point and should remain steady or rising during the application and drying period. Avoid painting late in the day when air temperature decreases and the relative humidity increases toward the dew point. Water condensation on the newly painted film may cause surface imperfections and contribute to poor cure. Humidity should be 85 % or less.

The preferred application method is by spray; conventional, airless, or air-assisted airless spray. Small areas may be coated using brush or roller application.

Conventional spray – Separate air and fluid regulators are recommended. Use DeVilbiss MBC 510 gun; 704 air cap; E tip. Atomization air pressure 60-65 psi. Fluid pressure 10-20 psi

Airless Spray – Use a 30:1 ratio or higher Graco air driven fluid pump; Tips 0.017” – 0.023” orifice. reversa-clean tips or equal. Fluid pressure should be 2800-3000 psi or as needed to eliminate “fingering”.

Brush and Roller – Use only natural bristle brushes. Use 3/8” nap, phenolic or solvent resistant core, rollers. Apply in a manner to avoid excessive back brushing or back rolling over previously painted areas.

Dry Times, recoat and cure Schedule: – Dry times (25°C) 50% Relative Humidity, 5-10 mils DFT

	@ 77°F	@50°F	@35°F
To Touch:	1 hours	8 hours	3.5 hours
To Recoat:	4 hours	8 hours	16 hours
To Handle:	8 Hours	14hours	48 hours
Full Cure:	5-7 Days	10 days	14 days

Overcoat Interval with SEA-SPEED V 10 X: Minimum 4 hours/ Maximum 12 hours

Note: Dry times vary depending on temperature, humidity, film build and air movement.

Induction Time: 20-30 min. @ 77°F; 35 - 40 min @35°F

Pot Life: 2Hours @ 77°F (25°C) 50% RH

Note: Pot Life may be significantly shortened (< 30 minutes) at higher temperatures (90°F+). Lower temperatures will increase Pot Life and Dry Times.

Surface Preparation: For best results, substrate should be clean, dry and free of contaminates. Remove all grease or oil from surface prior to abrasive blasting. For atmospheric exposure, prepare substrate to minimum SSPC-SP6/NACE 3/Sa2 Commercial Blast Cleaning Standard; profile 2-3 mils (50-75 µm).

For marine or immersion service, prepare the substrate to SSPC-SP-10/NACE 2/Sa 2.5 Near-White Blast Cleaning; profile 2-3 mils (50-75 µm). PLEASE CONSULT Seacoat for technical specifications.

Clean up: Clean equipment with Sherwin Williams R7K15 or equivalent. In California use R7K111 or Oxsol 100. Use hand cleaners (Goop etc.) or soap and water to remove any material from hands or skin. The use of hand and skin lotions is recommended after skin clean-up.

Packaging: - This product is a two component material formulated to a **1A to 1B** volume mixing ratio.

Shipping classifications:

DOT – UN1263 PAINT, PAINT RELATED MATERIAL
Class 3, Packing Group II (ERG # 128)

IMDG - UN1263 PAINT RELATED MATERIAL
Class 3, Packing Group III Label 3
EmS (IMDG) F-E, S-E, MARINE POLLUTANT

IATA – Un 1263 Paint, Paint related Materials
Class III, Packing group II, MARINE POLLUTANT

Shelf Life: 36 months (stored in unopened containers stored at 77°F/25° C)

Health and Safety:

Keep out of reach of children.

Use with adequate ventilation.

This product contains flammable liquids. Keep away from heat, sparks or open flames. If applied in enclosed areas, provide proper air circulation to maintain exposure to solvents below the permissible levels (see MSDS) or provide air supplied respirators or air supplied hoods to prevent exposure. Avoid prolonged contact with skin and avoid exposure to spray vapors or mists. Use protective barrier cream on exposed skin to prevent contact. Persons who are hypersensitive to polyurethane coatings should avoid contact with this product.

Follow the manufacturer's instructions on the proper use and maintenance of spray equipment. High pressure airless spray equipment can inject coatings into the skin and may cause serious injury. Follow all local, state and federal regulations for the proper handling and disposal of all paint, and paint related waste generated from the use of this product.

Use only fiberglass or fire resistant filters for spray booth operations. Follow OSHA regulation 1910.107 (CFR 29) pertaining to spray finishing. Dispose of used filters according to OSHA 1910.107(b) (5) (ii) to prevent spontaneous combustion of waste materials. Information on spray paint regulations and proper disposal may be obtained at www.osha.gov.

Read and understand the Material Safety Data Sheet (MSDS) before using this product.

Disclaimer: Information presented in this Product Data Sheet is believed to be true and accurate and is generated or obtained from accurate and reliable sources. Information is provided here only as a guide to proper product use. However, since Seacoat Technology, LLC has no direct control over the transport, storage or application of this product, no guarantee of accuracy, completeness, fit-for- use, or ultimate performance of this product is given or implied.

MADE IN THE USA

Performance Information

Substrate: Steel

Preparation: SSPC-SP10/ NACE 2

Product as tested: 1 coat SEAPOXY 73 @ 6 mil (150 μ) DFT

Test Name	Method	Results
Abrasion Resistance	ASTM D4060, CS 17 wheel 1000 cycles, 1 Kg load	86 mg loss
QUV	ASTM D 4587, QUV A 12,500 hours	Passed
Adhesion	ASTM D 4541	1,087 psi
Corrosion weathering	ASTM D 5894, 36 cycles, 10,000 hours	Rating 9 per ASTM D714 For blistering
Direct impact Resistance	ASTM D 2794	118 in. lbs
Dry Heat Resistance	N/A	
Flexibility	ASTM D 522, 180 ° bend, ¾" Mandrel	Passed
Immersion	18 months Fresh and Salt water	Passed, no blistering, Rusting or adhesion loss
Pencil Hardness	ASTM D 3363	3 H
Salt Fog Resistance	ASTM B 117, 7000 hours	10 rating per ASTM D 610 /rusting 10 rating per ASTM D1654/corrosion
Water Vapor Permeance	ASTM D 1653 Method B	1.18 perms