

## 300 Polyamide Epoxy Coating

Updated: January 2015

### Specification Data

**Generic Type:** Polyamide Epoxy

**Description:** APC0 300 is an economical two component corrosion inhibiting epoxy coating. When applied over properly prepared surfaces it exhibits excellent adhesion and very good corrosion resistance. 300 Epoxy is self priming and a good choice for steel or concrete structures where increased chemical resistance is required. Formulated with inert pigments and industry standard resins, 300 provides excellent immersion protection against a variety of water solutions.

**Features:**

- Excellent adhesion properties
- Good chemical resistance

**Solids Content:** 56% by Volume

**Theoretical Coverage:**

- 900 mil ft<sup>2</sup>
- 180 ft<sup>2</sup> @ 5 Mills

Allow for loss during mixing & application.

**VOC Value:**

- 3.1 lbs/gal per EPA Method 24

**Color:** 1000 White, 2001 Red

### Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

**Immersion Carbon Steel:** Minimum SSPC-SP10/NACE No 2 Near white. Surface profile 2.0-3.0 mil.

**Non-Immersion Carbon Steel:** Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 2.0-3.0 Mil.

**Previously painted surfaces:** Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

**Concrete:** Concrete must be cured 28 days at 75°F minimum. Prepare surface in accordance with ASTM D4258 surface cleaning of concrete. Maximum performance achieved when surface is abraded in accordance with ASTM D4259

**Primer:** Self priming, APC 351

**Topcoats:** APCO 400, APCO 427, APCO 220

### Application Equipment

**Spray Application:**

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2100 or 95 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .013-.015 Output PSI- 3000

**Brush & Roller:**

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

### Mixing & Thinning

**Components:** 2

**Mix Ratio:** 1 Part A to 1 Part B

**Pot Life:** 8 hours at 75°F

**Mixing:** Power mix each part separately, then combine and mix to uniform color & consistency.

**Induction Time:** Let mixed material sit 1 hour @ 75°F before application. 30 minutes @ 90°F

**Thinning:**

- **Spray:** Up to 12 oz/gal with S118 if necessary

### Application

**Pre-application:** Flush all equipment with thinner S118 or MEK

**Temperature:** Application range from 50°F-110°F surface temperature. Do not apply below 50°F.

**Method:** Apply one coat maintaining a wet edge to achieve a WFT of 3-6 Mills. Maximum performance will be achieved with two coats totaling 6-8 mils DFT.

### Limitations

Not suitable for immersion in acids, caustics, or strong petroleum solvents. Always consult an APCO technical representative before placing into any immersion service environment.

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### Application Continued

**Inspection:** Test for voids in coating film using low voltage holiday detector. Dry film thickness can be measured with either a calibrated magnetic or electronic dry film thickness guage.

**Clean up & disposal:** After use immediately flush all equipment with thinner S108 or MEK. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

#### **Curing schedule:**

Times based upon 75°F

Dry to touch: 2 hours

Dry to recoat: 3 hours

Dry to cure: 48 hours

Maximum Recoat: 48 hours

**After 48 hours surface must be mechanically abraded or sweep blasted in order to be top coated.**

Dry times are greatly affected by weather conditions and film thickness.

#### **Packaging & Handling:**

Unit sizes: 2 & 10 gallon kits

Shipping Weight: 12 lbs/gal

UN Classification: UN1263, PAINT, CLASS 3, PGIII