

318MP Industrial Epoxy Coating

Updated: January 2015

Specification Data

Generic Type: Polyamine Epoxy

Description: APCO 318MP is a high solids, high build, two component corrosion inhibiting epoxy coating. When applied over properly prepared surfaces it exhibits excellent adhesion and corrosion resistance. 318MP 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, 318MP provides excellent immersion protection against a variety of oil and gas environments.

Features:

- Excellent adhesion properties
- Very Good chemical resistance

Solids Content: 75% by Volume

Theoretical Coverage:

- 1203 mil ft²
- 200 ft² @ 6 Mils

Allow for loss during mixing & application.

VOC Value:

- 1.81 lbs/gal per EPA Method 24

Color: 1070 White, 1028 Gray

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

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2100 or 95 Gun w/68 series nozzles and 568 needle.
- **Airless:** Graco 70:1 Min. 3/8" material line. Tip size .015-.019 Output PSI- 4500+

Brush & Roller:

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

Mixing & Thinning

Components: 2

Mix Ratio: 4 Part A to 1 Part B

Pot Life: 90 minutes at 75°F

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

Induction Time: Let mixed material sit 15 minutes @ 75°F.

Higher temperature will shorten both pot life and induction time. Consult APCO technical representative for more information.

Thinning:

- **Spray:** Up to 12 oz/gal with S121 if necessary

Application

Pre-application: Flush all equipment with thinner S121 or MEK

Temperature: Application range from 50°F-110°F surface temperature. Surface temperature must be 5°F above the dew point. Do not apply below 50°F.

Method: Apply one coat maintaining a wet edge to achieve a wet film thickness of 8-10 Mils. Apply second coat of 8-10 mils of a contrasting color after 8 hours. Maximum performance will be achieved with two coats totaling 12-16 mils dry film thickness.

Limitations

Not suitable for immersion in strong acids, or caustics. 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, ASTM D5162. Dry film thickness can be measured with either a calibrated magnetic or electronic dry film thickness gauge.

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: 4 hours

Dry to recoat: 24 hours

Dry to cure: 48 hours

Return to service: 5 Days @ 90°F

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: Pre-measured 5 gallon kit

Shipping Weight: 11.91 lbs per gallon

UN Classification: UN1263, PAINT, CLASS 3, PGIII