

Selection & Specification Data

Generic Type	Modified epoxy polyamine
Description	Self-priming epoxy coating with excellent adhesion, flexibility, chemical and abrasion resistance. May be applied directly to suitably prepared steel to provide outstanding chemical resistance and corrosion protection.
Features	<ul style="list-style-type: none"> - Multi-coat system for internal lining of storage tanks and pipelines. - Improves throughput of pipelines and prevents bacterial corrosion in pipelines & tanks carrying crude oil. - Excellent resistance to water, brine, hydrocarbon gases, crude and processed petroleum products, and unleaded and jet fuels. - Very good flexibility. - Good weathering (chalks). - Excellent abrasion resistance. - Not recommended for immersion service in strong mineral or organic acids. For solvent exposures, consult StonCor Africa Technical Service Department for specific recommendations.
Colour	Red Oxide and Medium Grey
Finish	Glossy
Topcoat	This product is used as a multi-coat system and serves both as first and finish coats.
Dry Film Thickness	250 Microns – normally applied in 2 coats to a total dry film thickness of 500 microns nominal. Recommended film thickness may vary with system and exposure.
Solids Content	By Volume 98% ± 1%
Theoretical Coverage Rate	4.0m ² /litre at 250 microns NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
Temp Resistance	Non-immersion Continuous 60°C Non-continuous 75°C For immersion service, consult StonCor Africa for specific recommendations. It is recommended that tanks operating at 60°C or higher be insulated to extend the coating life.

Substrates & Surface Preparation

General	Remove any oil, grease and dust from surface to be coated prior to blast cleaning.
Steel	For immersion service: Dry abrasive blast clean to a near white metal finish in accordance with ISO 8501 Sa2½ to obtain a 50 to 100 micron blast profile. * Soluble salt concentration must be below 100mg/m ² when tested with a Weber Reilly detection kit.
Concrete	Consult StonCor Africa for specific recommendations.

Performance Data

Test Method	System	Results
Salt Water Immersion NACE TM0174 Procedure B	1 Coat Gasohol	At 32°C – no blisters, softening or cracking. Slight discolouration observed
• Regular Gasohol		At 32°C – no blisters, softening or cracking. Slight discolouration observed
• Premium Gasohol		Slight discolouration observed
Adhesion ASTM D4541	1 Coat Gasohol	5 MPa average

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Gasohol Tank Lining

Application Equipment

- Spray** **Single Component Airless Spray:**
Graco 80:1 pump or equivalent.
- Spray hose should be 12 to 15mm I.D. Use a high delivery airless spray gun (direct material feed to spray heat) equipped with a reversible, self-cleaning tip, orifice size .017 to .023" and no whip end hose.
- Recommended operating pressure is 3 to 6 bar.
- Brush or Roller** Brush recommended for small areas and touch-up only. Roller application is not recommended.

Mixing & Thinning

- Mixing** Power mix separately, then combine by adding Part B to Part A. Mix thoroughly in such a manner as to avoid entraining air into mixture. Transfer mixed material to another container and remix thoroughly.
- | | |
|--------|---------------------|
| | 20 Litre Kit |
| Part A | 13.8 litre |
| Part B | 6.2 litre |
- Thinning** Thinning is not permitted for tank linings. For other applications, consult StonCor Africa for specific recommendations.
- NOTE:** Use of thinners other than those supplied or recommended by StonCor Africa may adversely affect product performance and void product warranty, whether expressed or implied.
- Pot Life** 45 Minutes at 25°C and less at higher temperatures for 1 litre mix. Larger mix volumes will reduce pot life if not sprayed within 15 minutes.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	18-29°C	18-29°C	18-29°C	30-70%
Minimum	16°C	16°C	6°C	0%
Maximum	32°C	45°C	43°C	90%

Do not apply or cure material when the surface temperature is below 16°C or less than 3°C above the dew point.

Curing Schedule

Surface Temperature	Surface Dry	Hard Dry
25°C	8 Hours minimum	36 Hours minimum

Recoat:

Surface Temperature	Minimum	Maximum
16°C	36 Hours	72 Hours
25°C	24 Hours	48 Hours
30°C	18 Hours	36 Hours

Force curing is recommended for all linings.

Final cure temperature below 16°C is not recommended for linings.

It is recommended that application takes place when the substrate temperature is expected to rise over the next 8 hours. This will enhance the film cure and performance.

Final cure after 7 days at 25°C or less at higher temperatures. Cure condition may be assessed by MEK rub test.

If maximum recoat time is exceeded and recoat is necessary, special surface preparation will be required, which may adversely affect the product performance and warranty. Consult StonCor Africa for specific recommendations.

NOTE: Excessive film thickness or poor ventilating conditions require longer dry times and in extreme cases may cause premature failure.

Cleanup & Safety

- Cleanup** Thinner # 2
- Safety** Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions.
- Ventilation** While this is a solventless epoxy, it is common practice when used as a tank lining or in enclosed areas to circulate the air during and after application until the coating is cured. Follow all current OSHA requirements for respirator use.
- Caution** If product is thinned with flammable solvents, keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Packaging, Handling & Storage

Shipping Weight (Approximate)		5 Litre Kit	20 Litre Kit
	Part A		26kg
	Part B		7.5kg
	Thinner # 2	4.6kg	
Flash Point (Setaflash)	Part A	>93°C	
	Part B	>93°C	
	Thinner # 2	22°C	
Storage Temperature & Humidity	4 to 32°C		
	0 to 100%		
	Store indoors		
Shelf Life	12 Months minimum when stored at 25°C		

*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.



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