Mobil Chemical Product Data

OCTOBER 1, 1971 / Printed in U.S.A.
This supercedes all previous publications.
Always consult your Mobil representative for latest information and recommendations for Mobil Products.

SHEET NUMBER **V-6**

VAL-CHEM HI-BUILD EPOXY - 89 SERIES

FINISH	Low Sheen
VEHICLE TYPE	Epoxy Resins and Polyamide Curing Agents
PIGMENT TYPE	Chemical resistant pigments
SOLVENT OR DILUENT	Ketones and Aromatic Solvents
RESISTANCE TO	Heat – up to 150° F. maximum dry heat. For exterior surfaces such as hot tanks, lines, etc., consult your Mobil representative for specific recommendations. Somechange of color is to be expected with elevated temperature exposure. Weather – Excellent Moisture – Excellent Acid – Good Alkali – Very Good Adhesion – Excellent
FLASH POINT, MINIMUM	22° F. (T.O.C.) Mixed Material
% SOLIDS BY VOLUME	53% after mixing equal parts by volume of Base Component and Catalyst 89-T-1
DRY FILM THICKNESS & COVERAGE (THEORETICAL)	5.0 mils at 170 sq. ft. per gal. 7.0 mils at 121 sq. ft. per gal. The actual coverage will be less depending on application technique, job conditions and type of surface.
VISCOSITY	80-90 Krebs Units at 75° F.
AVERAGE DRYING TIME – 75° F.	To touch 4 hours. Recoat 16 hours at 75° F. at high film build.
RECOMMENDED THINNER	Normally no thinning required, if necessary use Thinner 7-T-25.
APPLICATION	Spray preferred. Brush application limited to small areas. Brush application suggested for priming rough, porous, or hand cleaned surfaces.
RECOMMENDED PRIMER STEEL – BLAST CLEANED GALVANIZED MASONRY WOOD STEEL – HAND CLEANED	 Self Prime, 13-R-56 Epoxy Primer, or Mobilzinc Self Prime Self Prime (thin first coat with Thinner 7-T-25 – 1 quart per gallon) Self Prime (thin first coat with Thinner 7-T-25 – 1 quart per gallon) Self Prime (thin first coat with Thinner 7-T-25 – 1 quart per gallon)
TYPICAL USES	Petroleum Refineries Chemical Plants Sewage Plants Pulp and Paper Mills Off Shore Drilling Boats and Barges Electroplating Industry Fertilizer Industry
POT LIFE	16-20 hours at 75° F.
CAUTION	For best results apply to sand blasted surfaces and do not apply when temperatures are below 50° F. (a minimum of 65° F. is preferred) or at relative humidities above 80%.
EQUIPMENT RECOMMENDATION	CONVENTIONAL SPRAY DeVilbiss MBC-510 Spray Gun, equipped with an "E" Fluid Tip and Needle, and #704, #765 or #78 Air Cap or equivalents. AIRLESS SPRAY DeVilbiss Airless Spray outfit equipped with a JGA-5026 Spray Gun and a Spray Cap of suitable orifice diameter .015 to .021 or equivalents, and using a minimum of 2800 psi tip pressure.

DSW 379406

VAL-CHEM HI-BUILD EPOXY - 89 SERIES

GENERAL AND MIXING: Val-Chem Hi-Build Epoxy is supplied as a two-component system in full containers. Thoroughly mix equal volumes of Base Component and Catalyst 89-T-I and allow to stand for one-half hour. Coating is then ready for application and has a usable pot life of 16 to 20 hours at 70-75° F. It will be less at higher temperatures. Do not mix more coating than can be applied during this period. For conventional spray, if thinning becomes necessary, use Thinner 7-T-25. Can be airless sprayed. Thinning depends upon selection of orifice diameter (from .015 to .021), pump ratio, air pressure, and paint heaters available. Limit brush application to small areas and touch up. Do not use nylon brushes because of the harmful effect of the strong solvents. For best results do not apply at temperatures below 65° F. or at relative humidities above 80%.

COVERAGE AND DRY TIME: 170 square feet per gallon (theoretical) at 5.0 mils dry. The actual coverage will be less, depending on application technique, climatic conditions, and type of surface to be coated. This product will dry in 4 hours and can be recoated after overnight dry. Maximum resistance is developed in 7 to 10 days at room temperature.

NEW METAL: Surface to be painted must be free of dust, dirt, grease, rust and mill scale. Sandblasting to near white metal, or pickling produces the most desirable surface. Val-Chem Hi-Build Epoxy is self priming. No special primer required. Additional coats of Hi-Build Epoxy or Epoxy Enamel can be applied, depending on requirements.

NEW WOOD AND MASONRY: For first coat reduce each gallon of Val-Chem Hi-Build Epoxy with 1 quart Thinner 7-T-25. Apply succeeding coats of Hi-Build Epoxy or Epoxy Enamel without thinning.

CONCRETE FLOORS: Etch with 10% muriatic acid solution. Rinse thoroughly and allow to dry. For first coat reduce each gallon of Val-Chem Hi-Build Epoxy with 1 quart Thinner 7-T-25. Apply finish coats without thinning.

PREVIOUSLY PAINTED SURFACES: Val-Chem Hi-Build Epoxy may lift old paint. Check a small test area before using. If there is any evidence of dissolving the coating, lifting, or loss of adhesion, old coating must be removed before application of Val-Chem Hi-Build Epoxy.

Use only Thinner 7-T-25 for thinning and cleaning purposes.

WARNING: FLAMMABLE. EYE AND SKIN IRRITANT. HARMFUL IF SWALLOWED. VAPOR HARMFUL. MIXED MATERIAL CONTAINS EPOXY RESIN, XYLOL, KETONES, POLYAMIDE AND TOLUOL. AVOID EYE AND SKIN CONTACT. This product after mixing can act as a skin sensitizer and irritant. Keep away from heat, sparks and open flame. Do not take internally. In case of contact with skin or eyes, flush IMMEDIATELY with water. For eyes call PHYSICIAN. Avoid contact with skin, eyes and clothing. Remove contaminated clothing, including shoes, and wash clothing before reuse. Avoid prolonged contact with skin and breathing of vapor or spray mist. When applying in closed area use air supplied hood respirators to avoid breathing concentrated vapor. Close container after each use. USE WITH ADEQUATE VENTILATION. KEEP OUT OF THE REACH OF CHILDREN.

The furnishing of the information contained herein does not constitute a representation by Mobil that any product or process is free from patent infringement claims of any third party nor does it constitute the granting of a license under any patent of Mobil or any third party. Mobil assumes no liability for any infringement which may arise out of the use of the product. Mobil warrants that its products meet the specifications which it sets for them. Mobil DISCLAIMS ALL OTHER WARRANTIES relating to the products, and DISCLAIMS ALL WARRANTIES RELATING TO THEIR APPLICATION, express or implied, INCLUDING but not limited to warranties of MERCHANTABILITY and FITNESS for particular purpose. Receipt of products from Mobil's Chemical Coatings Division constitutes acceptance of the terms of this Warranty, contrary provisions of purchase orders notwithstanding. In the event that Mobil finds that products delivered are off-specification, Mobil will, at its sole discretion, either replace the products or refund the purchase price thereof, and Mobil's choice of one of these remedies shall be Buyer's sole remedy. Mobil will under no circumstances be liable for consequential damages, except insofar as liability is mandated by law. Mobil will deliver products at agreed times insofar as it is reasonably able to do so, but Mobil shall not be liable for failure to deliver on time when the failure is beyond its reasonable control.

Mobil Chemical Company / MAINTENANCE & MARINE COATINGS DEPARTMENT

Edison, New Jersey 08817
P.O. Box 250 / Tel: (201) 287-2626

Beaumont, Texas 77704
P.O. Box 3431 / Tel: (713) 835-5324

Kankakee, Illinois 60901
901 North Greenwood Avenue / Tel: (815) 933-5561

Los Angeles, California 90058
2647 East 37th Street / Tel: (213) 589-6781

Louisville, Kentucky 40210 (Railroad Coatings)
1630 West Hill Street / Tel: (502) 774-4411

These products also available from: Delft, Holland/Toronto, Canada Bogota, Columbia/Sao Paulo, Brazil/Mexico City, Mexico

DSW 379407