



# Protective & Marine Coatings

# HI-SOLIDS CATALYZED EPOXY

PART A  
PART A  
PART A  
PART B

B62W201  
B62H200  
B62L200  
B60V20

SANITARY WHITE  
BEIGE  
LIGHT BLUE  
HARDENER

Revised 9/09

## PRODUCT INFORMATION

4.76

### PRODUCT DESCRIPTION

**HI-SOLIDS CATALYZED EPOXY** is a polyamide/bisphenol A epoxy resin coating formulated for immersion service in fresh and salt water. May also be used as part of a system for tank exteriors.

- Chemical resistant
- Corrosion resistant
- Direct to metal application
- Outstanding application properties

### PRODUCT CHARACTERISTICS

<b>Finish:</b>	Low sheen
<b>Color:</b>	Sanitary White, Beige, Light Blue (SW4061)
<b>Volume Solids:</b>	61% ± 2%, mixed
<b>Weight Solids:</b>	77% ± 2%, mixed
<b>VOC (EPA Method 24):</b>	Unreduced: <340 g/L; 2.8 lb/gal mixed Reduced 10%: <400 g/L; 3.33 lb/gal
<b>Mix Ratio:</b>	4:1 by volume

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
<b>Wet mils (microns)</b>	<b>8.0</b> 200	<b>10.0</b> 250
<b>Dry mils (microns)</b>	<b>5.0</b> 125	<b>6.0</b> 150
<b>~Coverage sq ft/gal (m<sup>2</sup>/L)</b>	<b>165</b> 4.0	<b>195</b> 4.8
<b>Theoretical coverage sq ft/gal (m<sup>2</sup>/L) @ 1 mil / 25 microns dft</b>	<b>976</b> 23.9	

*NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.*

#### Drying Schedule @ 8.0 mils wet (200 microns):

	@ 55°F/13°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
<b>To touch:</b>	4 hours	1 hour	30 minutes
<b>Tack free:</b>	8 hours	4 hours	2 hours
<b>To recoat:</b>			
<b>minimum:</b>	24 hours	12 hours	4 hours
<b>maximum:</b>	60 days	60 days	60 days
<b>To cure:</b>	14 days	7 days	3 days

*Force cure requirement is 3 days, consisting of 24 hours ambient, 24 hours at 100°F (38°C), and 24 hours ambient.  
If maximum recoat time is exceeded, abrade surface before recoating.  
Drying time is temperature, humidity, and film thickness dependent.*

<b>Shelf Life:</b>	36 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
<b>Flash Point:</b>	80°F (27°C), PMCC, mixed
<b>Reducer/Clean Up:</b>	Xylene, R2K4

### RECOMMENDED USES

**According to FDA Regulation 175.300**, this product (Sanitary White) is suitable for use on surfaces intended for use in the production, manufacturing, packing, processing, treating, transporting or storage of dry food at ambient temperatures when applied as a continuous film.

**According to FDA Regulation 175.300**, this product (Sanitary White) has been tested and complies with standards for wet food storage (as a coating intended for use in containers for repeated use, not to exceed 18 mg/sq in extractables). We have compliance with condition of use "A". The types of foods approved are: I. Non-acid (pH above 5.0), aqueous products; may contain salt or vinegar or both and including oil-in-water emulsions of low- or high-fat content.; and IV.B. Dairy products and modifications: oil-in-water emulsion, high- or low-fat.

- Not for use in potable water storage tanks
- Suitable for use in USDA inspected facilities
- Acceptable for use with cathodic protection systems

### PERFORMANCE CHARACTERISTICS

**Substrate\*:** Steel

**Surface Preparation\*:** SSPC-SP10/NACE 2

**System Tested\*:**

2 cts. Hi-Solids Catalyzed @ 5.0 mils (125 microns) dft/ct  
\*unless otherwise noted below

Test Name	Test Method	Results
<b>Abrasion Resistance</b>	ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load	120 mg loss
<b>Adhesion</b>	ASTM D4541	1169 psi
<b>Direct Impact Resistance</b>	ASTM D2794	60 in. lbs.
<b>Dry Heat Resistance</b>	ASTM D2485	200°F (93°C) (discolors)
<b>Exterior Durability</b>	1 year at 45° South	Excellent, chalks
<b>Flexibility</b>	ASTM D522, 180° bend, 1" mandrel	Passes
<b>Freshwater Immersion</b>	ASTM D870, 4 years	No blistering, cracking, or rusting
<b>Moisture Condensation Resistance</b>	ASTM D4585, 100°F (38°C), 2000 hours	No failure, no blistering, creepage, or underfilm corrosion
<b>Pencil Hardness</b>	ASTM D3363	4H
<b>Salt Fog Resistance</b>	ASTM B117, 3000 hours	No blistering, creepage, or underfilm corrosion

Epoxy coatings may darken or yellow following application and curing.



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### RECOMMENDED SYSTEMS

	Dry Film Thickness / ct.	
	Mils	(Microns)
<b>IMMERSION SERVICE (Note: Do Not Tint)</b>		
<b>Steel:</b> 2-3 cts. Hi-Solids Catalyzed Epoxy	5.0-6.0	(125-150)
<b>Steel:</b> 1 ct. Steel Seam FT910 as required to seal seams and radius joints 2 cts. Hi-Solids Catalyzed Epoxy	5.0-6.0	(125-150)
<b>Steel, shop applied system:</b> 1 ct. Hi-Solids Catalyzed Epoxy 1-2 cts. Hi-Solids Catalyzed Epoxy	3.0-6.0 5.0-6.0	(75-150) (125-150)
<b>Concrete:</b> 1-2 cts. Kem Cati-Coat HS Epoxy Filler/Sealer as required to fill pores and provide a continuous substrate 2 cts. Hi-Solids Catalyzed Epoxy	10.0-20.0 5.0-6.0	(250-500) (125-150)
<b>ATMOSPHERIC EXPOSURE</b>		
<b>Steel:</b> 1-2 cts. Hi-Solids Catalyzed Epoxy	5.0-6.0	(125-150)
<b>Steel:</b> 1 ct. Hi-Solids Catalyzed Epoxy 1 ct. Hi-Solids Polyurethane	5.0-6.0 3.0-4.0	(125-150) (75-100)
<b>Steel (Zinc Rich Primer):</b> 1 ct. Zinc-Clad II Plus 1-2 cts. Hi-Solids Catalyzed Epoxy	3.0-5.0 5.0-6.0	(75-125) (125-150)
<b>Concrete:</b> 1-2 cts. Kem Cati-Coat HS Epoxy Filler/Sealer (as required to fill pores and provide a continuous substrate) 2 cts. Hi-Solids Catalyzed Epoxy	10.0-20.0 5.0-6.0	(250-500) (125-150)

The systems listed above are representative of the product's use, other systems may be appropriate.

### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

### SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

Iron & Steel  
 Atmospheric: SSPC-SP6/NACE 3 2.0 mil (50 micron) profile  
 Immersion: SSPC-SP10/NACE 2, 2.0-3.0 mil (50-75 micron) profile

Concrete & Masonry:  
 Atmospheric: SSPC-SP 13/Nace 6, or ICRI 03732, CSP 2-3  
 Immersion: SSPC-SP 13/Nace 6-4.3.1 or 4.3.2 or ICRI 03732, CSP 2-3

#### Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted C St 3	C St 3	SP 3	-
	Pitted & Rusted D St 3	D St 3	SP 3	-

### TINTING

Tint with Blend-A-Color Toner at 75% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color. Tint Part B side, 1 oz. per gallon maximum.

Do not tint for Immersion Service.

### APPLICATION CONDITIONS

Temperature: 55°F (13°C) minimum, 120°F (49°C) maximum (air, surface, and material)  
 At least 5°F (2.8°C) above dew point  
 Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

Packaging:  
 Part A: 5 gallons (18.9L) mixed  
 4 gallons (15.1L) in a 5 gallon (18.9L) container  
 Part B: 1 gallon (3.78L)  
 Weight: 12.30 ± 0.2 lb/gal ; 1.48 Kg/L, mixed

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.



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## APPLICATION BULLETIN

4.76

### SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

#### Iron & Steel (immersion service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2-3 mils / 50-75 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

#### Iron & Steel (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

#### Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI 03732, CSP 2-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910. Primer required.

#### Always follow the standard methods listed below:

ASTM D4258 Standard Practice for Cleaning Concrete.  
ASTM D4259 Standard Practice for Abrading Concrete.  
ASTM D4260 Standard Practice for Etching Concrete.  
ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.  
SSPC-SP 13/Nace 6 Surface Preparation of Concrete.  
ICRI 03732 Concrete Surface Preparation.

#### Concrete, Immersion Service:

For surface preparation, refer to SSPC-SP13/NACE 6, Section 4.3.1 or 1.3.2 or ICRI 03732, CSP 2-3.

#### Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted C St 3	C St 3	SP 3	-
Pitted & Rusted	D St 3	D St 3	SP 3	-

### APPLICATION CONDITIONS

Temperature: 55°F (13°C) minimum, 120°F (49°C) maximum (air, surface, and material)  
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

### APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

**Reducer/Clean Up** .....Xylene, R2K4

Use of any other solvent than Xylene, R2K4 may affect the performance or compliance of this product for its intended service.

#### Airless Spray

Pressure.....3000 psi minimum  
Hose.....1/4" - 3/8" ID  
Tip .....017" - .021"  
Filter .....30 mesh  
Reduction.....As needed up to 10% by volume

#### Conventional Spray

Gun .....Binks 95  
Cap/Tip .....68 PB/68  
Atomization Pressure.....80 psi  
Fluid Pressure.....30 psi  
Reduction.....As needed up to 10% by volume

#### Brush

Brush.....Small areas only, Natural Bristle  
Reduction.....Not recommended

#### Roller

Cover .....Small areas only, 3/8" woven with solvent resistant core  
Reduction.....Not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.



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## APPLICATION BULLETIN

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### APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine four parts by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated below prior to application. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	8.0 200	10.0 250
Dry mils (microns)	5.0 125	6.0 150
~Coverage sq ft/gal (m <sup>2</sup> /L)	165 4.0	195 4.8
Theoretical coverage sq ft/gal (m <sup>2</sup> /L) @ 1 mil / 25 microns dft	976 23.9	

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

#### Drying Schedule @ 8.0 mils wet (200 microns):

	@ 55°F/13°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
To touch:	4 hours	1 hour	30 minutes
Tack free:	8 hours	4 hours	2 hours
To recoat:			
minimum:	24 hours	12 hours	4 hours
maximum:	60 days	60 days	60 days
To cure:	14 days	7 days	3 days
Force cure requirement is 3 days, consisting of 24 hours ambient, 24 hours at 100°F (38°C), and 24 hours ambient.			
If maximum recoat time is exceeded, abrade surface before recoating.			
Drying time is temperature, humidity, and film thickness dependent.			
Pot Life:	10 hours	5 hours	2 hours
Sweat-in-time:	1 hour	30 minutes	15 minutes

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

### CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Xylene, R2K4. Clean tools immediately after use with Xylene, R2K4. Follow manufacturer's safety recommendations when using any solvent.

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### PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Insufficient ventilation, incomplete mixing, miscatalyzation, and external heaters may cause premature yellowing.

Excessive film build, poor ventilation, and cool temperatures may cause solvent entrapment and premature coating failure.

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Xylene, R2K4.

**For Immersion Service:** (if required) Holiday test in accordance with ASTM D5162 for steel, or ASTM D4787 for concrete.

Refer to Product Information sheet for additional performance characteristics and properties.

### SAFETY PRECAUTIONS

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