

Tile-Clad® Waterbased Epoxy Primer

Part A B73A00200 Gray, Part B B73V00200 Hardener



**SHERWIN
WILLIAMS®**

CHARACTERISTICS

WATERBASED TILE-CLAD EPOXY PRIMER is a two component, high performance, water based, cycloaliphatic amine, corrosion resistant primer. Developed for use in conjunction with other industrial coatings to provide excellent corrosion resistance.

Features:

- Chemical resistant
- Lower temperature cure (40°F / 4.5°C)
- Fast dry
- Suitable for use in USDA inspected facilities

For use on properly prepared:

Steel, Galvanized & Aluminum

Recommended for use in:

Structural steel, Pharmaceutical houses, Storage Tanks & Piping, Manufacturing plants

Finish: 5-15° @60° Flat

Color: Gray

Recommended Spreading Rate per coat:

Wet mils: 4.0-8.5

Dry mils: 1.9-4.1

Coverage: sq.ft. per gallon 187-404

Theoretical Coverage: 769

sq. ft. per gallon @1 mil dry

Approximate spreading rates are calculated on volume solids and do not include any application loss. **Note:** Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 4.0 mils wet, @ 50% RH:

Drying, and recoat times are temperature, humidity, and film thickness dependent.

	@40°F	@77°F	@100°F
To touch:	2 hrs.	45 min.	25 min.
To handle:	5 hrs.	4.5 hrs.	45 min.
Minimum recoat:	10 hrs.	6 hrs.	3 hrs.
Maximum recoat:	30 days	30 days	30 days
To cure:	7 days	7 days	7 days
Pot Life	6 hrs.	4 hrs.	1.5 hrs.
Sweat-In-Time	30 min.	none	none
Mix Ratio:	2 components, premeasured 4:1		

*If maximum recoat time is exceeded, abrade surface before recoating.

Tinting: DO NOT TINT

Gray B73A00200/B73V00200

(may vary by color)

V.O.C. (less exempt solvents): As mixed
108 grams per litre; 0.90 lbs. per gallon

As per 40 CFR 59.406

Volume Solids: 48 ± 2%

Weight Solids: 63 ± 2%

Weight per Gallon: 11.53 lb

Flash Point: N/A

Vehicle Type: Cycloaliphatic amine epoxy

Shelf Life: Part A and B: 36 months

COMPLIANCE

As of 02/18/2020, Complies with:

OTC	Yes
OTC Phase II	Yes
SCAQMD	No
CARB	Yes
CARB SCM 2007	Yes
Canada	Yes
LEED® v4 & v4.1 Emissions	No
LEED® v4 & v4.1 V.O.C.	No
EPD-NSF® Certified	No
MIR-Product Lens Certified	No
MPI	Yes

APPLICATION

Temperature:

minimum 40°F
maximum 100°F

air, surface, and material

At least 5°F above dew point

Relative humidity: 85% maximum

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 compatible with the existing environmental and application conditions.

Reducer: Water

Airless Spray:

Pressure 2000 p.s.i.
Hose 1/4 inch I.D.
Tip .015-.017 inch
Filter 60 mesh

Reduction As needed up to 10% by volume

Brush Nylon-polyester

Roller Cover 3/8 inch woven solvent resistant core

If specific application equipment is listed above, equivalent equipment may be substituted.

Apply paint at the recommended film thickness and spreading rate as indicated. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. 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, over thinning, climatic conditions, and excessive film build.

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. Re-stir before using. If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in. Do not apply the material beyond recommended pot life. Do not mix previously catalyzed material with new.

Stripe coat 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. No painting should be done immediately after a rain or during foggy weather.

All epoxies will chalk and fade when un-topcoated in exterior environments. Topcoat required.

SPECIFICATIONS

Interior Steel, Aluminum & Galvanized Metal:

1 coat Tile-Clad Waterbased Epoxy Primer
1-2 coats Of the following acceptable topcoats

Water Based Topcoats:

Pro Industrial Acrylic Coating
Pro Industrial Acrylic Dryfall
Pro Industrial Multi-Surface Acrylic
Pro Industrial Pre-Catalyzed Epoxy
Pro Industrial Pre-Catalyzed Urethane
Pro Industrial Water Based Acrolon 100
Pro Industrial Water Based Catalyzed Epoxy

Exterior Steel, Aluminum & Galvanized Metal:

1 coat Tile-Clad Waterbased Epoxy Primer
2 coats Of the following acceptable topcoats

Water Based Topcoats:

Pro Industrial Acrylic Coating
Pro Industrial Multi-Surface Acrylic
Pro Industrial Pre-Catalyzed Urethane
Pro Industrial Water Based Acrolon 100

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

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SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at **1-800-424-LEAD** (in US) or contact your local health authority.

When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon solvents for cleaning.

Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Existing peeled or checked paint should be scraped and sanded to a sound surface. Glossy surfaces should be sanded dull. Stains from water, smoke, ink, pencil, grease, etc. should be sealed with the appropriate primer/sealer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Iron & Steel - Minimum surface preparation is Power Tool Clean per SSPC-SP3. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1 (recommended preparation is Steam Cleaning). For better performance, use Commercial Blast Cleaning per SSPC-SP6-NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.

Aluminum - Remove all oil, grease, dirt, oxide and other foreign material per SSPC-SP1. Prime the area the same day as cleaned.

Galvanizing - Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP16 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

Previously Painted Surfaces - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

SURFACE PREPARATION

Mildew- Prior to attempting to remove mildew, it is always recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised.

Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach/water solution.

PERFORMANCE

Gray B73A00200/B73V00200

System Tested: (unless otherwise indicated)

Substrate: Steel

Surface Preparation: SSPC-SP6

Finish: 1coat Tile-Clad Waterbased Primer @ 24 mils D.F.T.

Adhesion¹:

Method: ASTM D4541

Result: 400 p.s.i. minimum

Corrosion Resistance¹:

Method: ASTM D5894, 1080 hours

Result: Pass

Dry Heat Resistance:

Method: ASTM D2485

Result: 250°F

Flexibility: 14 day dry

Method: ASTM D522, 1/4 inch mandrel

Result: Pass

Fineness of Grind²:

Method: Hegman

Result: 4 Hegman minimum

¹ 2.4 mils D.F.T. over sand blasted steel without topcoat
7 day dry

² Standard test based on Certificate of Analysis

SAFETY PRECAUTIONS

Before using, carefully read **CAUTIONS** on label.

Refer to the Safety Data Sheets (SDS) before use.

FOR PROFESSIONAL USE ONLY.

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

CLEANUP INFORMATION

Clean spills, spatters, hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with compliant cleanup solvent to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using solvents.

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