

Coal Tar Epoxy

Technical Data Sheet (TDS)

Product Description

Crown Coal Tar Epoxy is a two-component, high build, polyamide-cured epoxy coal tar coating which can be applied at high film thickness in one coat.

Product features:

- Hi build 2-component epoxy/polyamide
- Tough, abrasion, and chemical resistant
- Excellent flexibility
- Brush, roller, or spray application.
- Interior/Exterior applications
- Good corrosion and salt water resistance.
- Product is lead, chrome, and heavy metal free

Recommended Uses

Crown Coal Tar Epoxy is intended for industrial applications; either new build or maintenance. **Crown Coal Tar Epoxy** is ideal for steel or concrete surfaces in industrial and marine environments. Use on petroleum storage tanks, dam gates, non-potable applications, and heavy duty structural coating,

Application Areas:

- Petroleum storage tanks
- Dam gates
- Non- potable applications
- Extreme Duty Structural coating

Note: Exterior applications will chalk, but will not detract from other qualities

Mixing

Stir each container thoroughly prior to use.

Mix:

4 parts by volume of **Crown Coal Tar Epoxy(EX235)** to 1 part by volume of **Coal Tar Epoxy Catalyst (EX273)**

Product Characteristics

Gloss: Eggshell 26-40 GU at 60°

Volume Solids Mixed: 59% +/- 2%

Pot Life: 16 Hours at 77°F (25°C)

VOC Mixed (Unreduced): (EPA Method 24):
414 g/l (3.46 lb/gal)

Weight Gallon: 11.1 lb/gal ± 0.2 lb/gal

Shelf Life:

Component A: 2 years at 77°F (25°C)

Component B: 2 years at 77°F (25°C)

Note: For unopened product

Surface Prep

Surfaces to be finished must be clean, dry and free of dirt, oil or any contamination that would adversely affect adhesion, protective properties or appearance of the coating.

Prepare metal surfaces to SSPC-SP2, SSPC-SP3 for normal requirements;

Prepare metal surfaces to SSPC-5 white metal blast for immersion service.

All other substrates contact your Crown representative.

Application Method

Material can be applied by airless spray equipment

Note: Not recommended for brush or roller application over large areas. Small touch-up areas may be brushed or rolled.

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Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Airless	0.015-0.019"	2,000-3,000 psi	

Note: Do not spray catalyzed material with heated spray equipment.

Spray Viscosity

125 KU @ 77°F	Reduce as necessary*
Conventional	Airless

Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.

IF thinning is required:

Recommended Solvent: **TS145 HAP Free Reducer**

Material is packaged at a viscosity requiring little or no reduction for application by airless spray equipment.

Film Build

Crown Coal Tar Epoxy has a recommended film build thickness of:

Wet (unreduced): 13-16 mils wet (325-400 microns)

Dry: 8-10 mils dry (200-250 microns)
 Theoretical coverage at 1.0 mil (25 microns)
 DFT: 946 ft² per gallon at 100% transfer efficiency per 1 dry mil.

Dry Times

	70°F (21°C)
To Touch	1 Hour
To Handle	4 Hours
To Recoat	4 Hour
Through Dry	18 Hours
Immersion Service	7 Days

Optimum drying conditions are 60°F to 90°F (16°C to 32°C) at 50% R.H. Lower temperatures and high humidity will slow dry.

Surface must be dry and at least 5°F above the dew point.

Product may also be force cured to enhance dry. Force cure temperatures in the range of 110-180°F may be utilized to accelerate solvent evaporation and speed oxidation.

Topcoating Information

Crown Coal Tar Epoxy may be topcoated with the entire range of Crown Topcoats

Clean Up

Clean all equipment immediately after use **with TS-145 HAPS Free Reducer** for spray guns and line, pots and other equipment

Follow manufacturer's safety recommendations when using any solvent.

Note: Due to limited potlife, never leave catalyzed paint in spray equipment.

Ordering Information (sizing)

Available in 5 gallon kits
 Custom sizes may be available.

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Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be above 50°F (10°C). To prevent condensation during application the surface temperature must be 5°F (3°C) or more above the dew point at all times.

Note: For use outside this range please contact your Crown Representative.

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be obtained by contacting Crown Paint.

Specifications

Test	Method	Result
Salt Spray / Corrosion	ASTM B117	400 hours. no field rusting, less than 1/8" creep from scribe
Adhesion:	ASTM D3359	5A; 100% B-1000 panel
Impact resistance	ASTM D2794	80 lbs direct 40 lbs reverse
Flexibility	ASTM D522	1/8 mandrel bend: Pass

Storage Conditions

Storing partially used container Uncatalyzed:

Pour a small amount of the recommended thinner over the surface. Do not stir. Replace lid securely. Mix thoroughly before reusing.

Store away from heat or open flame

Mix thoroughly before reusing.