

## FEATURES

: Coal Tar Epoxy # 111 is a two-pack rust preventing coal tar epoxy paint.

: As a rust preventing coal tar epoxy for protective coating of tank interior, concrete, steel and underwater area. It has excellent to chemical resistance, salt water, crude oil and dilute acids.

## TECHNICAL INFORMATION

Type	: High build rust preventing coal tar epoxy
Color	: Black and Brown
Film appearance	: Semi-Gloss
Specific gravity	: 1.50 ± 0.05
Solid by volume	: 68 ± 2 %
Flash point	: 25 °C

		Minimum	Maximum	Recommended
Dry film thickness	(Microns)	100	150	125
Wet film thickness	(Microns)	147	221	184
Theoretical coverage.	m <sup>2</sup> / Liter	6.8	4.5	5.4
	m <sup>2</sup> / Gallon	25.7	17.2	20.6
Practical coverage.	m <sup>2</sup> / Liter	6.5	4.3	5.2
	m <sup>2</sup> / Gallon	24.5	16.3	19.6

Remark : Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique; as well as the structure and dimensions of the object to be coated.

	Temperature	25 °C	30 °C	35 °C
Touch dry	Surface dry	60 mins	50 mins	40 mins
	Hard dry	16 hrs.	12 hrs.	8 hrs.
Full cure	Minimum	16 hrs.	12 hrs.	8 hrs.
	Maximum	7 days	5 days	3 days
Potlife		8 hrs.	6 hrs.	4 hrs.

Remark : Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly.

## FILM PERFORMANCE

Properties	Test Method	Criteria	Results
Adhesion	ASTM D 3359	5B	Passed
Pencil Hardness	ASTM D 3363	2H	Passed
Flexibility	ASTM D 522 (Method B)	3 mm	Passed
Impact Resistance	ASTM D 2794	60 inch-pounds	Passed
Abrasion Resistance	ASTM D 4060	101 mg (loss)	Passed
	<small>CS-17 Wheels, 1000 g load, 1000 cycles</small>		
Salt Spray Resistance	ASTM B 117	500 hrs.	Passed

## APPLICATION

Mixing Ratio	Part A	Part B
By Volume	4	1
By Weight	5.5	1

Application Method	Airless Spray	Air Spray	Brush / Roller
Diluted by <b>TOA Thinner 31</b>	5-10	15-20	10-15
Applicator	Graco 421 Graco 423	Coventional Spray (Iwata)	Short Hair Stiff Nylon Roller (Stanley) Stiff Nylon Brush
Pressure	150-180 kg/cm <sup>2</sup>	3-4 kg/cm <sup>2</sup>	-

Mix Part A and Part B, strictly follow mix ratio recommendations before dilute by Thinner mixing and stir for 2-3 minutes until the mixture is homogeneous after leave 5 minutes before application.

## APPLICATION SYSTEM

### Surface Preparation

#### Steel

: Should be blast cleaned in accordance with NACE No.2 / SSPC-SP10 / ISO 8501:1 / SIS Sa 2.5 to a near-white finish using a suitable abrasive. And/or by use the surface preparation with requirements. of the primer and/or as the Spec of the project.

**Remark** : The surface must be thoroughly dry and apply the protective coating within 4 hours to cleaned surface.

#### Wall

: For New concrete - The concrete prior to laying plastic sheets to block moisture from underground. Then it should be left for curing concrete to solid and dry for about 3-4 weeks. Then, clean the surface free from dust, dirt, grease and most importantly, the surface is completely dry. (Check moisture content must be less than 14%)

: For Old concrete - To remove the old paint film which loosely adhesion to as much as possible by Scraping with a shovel or Grinding machine to enhance adhesion. Then, clean the surface free from grease and oil with suitable solvent. Before primer coating should clean all surfaces free from dust, dirt, grease and most importantly, the surface is completely dry. (Check moisture content must be less than 14%).

#### Before Recoat by Topcoat

: Remover all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning before coating.

: If over 7 days gives cleaning surface by sand paper no. 320-400 and cleaning surface per SSPC-SP1, Solvent Cleaning before coating.

: Surface reparaire (cracks, pores, holes) done with TOA Epoxy putty and polishing of surface with moltoprene disk.

### Coating System

Protective Coating  
and  
Concrete protective Coating

: **Primer & Topcoat**      **Coal Tar Epoxy # 111**      **125 microns x 2 coats**

### Recommendation

: The proper relative humidity in the work shall not exceed 85% RH.

: The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate for prevent moisture and water drop on substrate effective adhesion and drying time.

## HANDLING AND STORAGE

### Storage condition

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

### Shelf life

: 24 months at 30-35 °C



Package	Packaging size	Part A :	Part B :
	1 Gallon Set	1 Gallon	1/4 Gallon
	5 Gallon Set	5 Gallon	1 Gallon
HEALTH AND SAFETY	<p>: Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.</p> <p>: For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.</p>		
DISCLAIMER	<p>: The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything only the quality of the product itself. We reserve the right to change the given data without notice.</p>		