

ACS EPOXY TC 510®

Phenolic Epoxy Resin Based,
Heavy-Duty Topcoat Coating



■ Description

ACS EPOXY TC 510® is a phenolic epoxy resin based two-component solvent-based semi-gloss topcoat paint.

■ Place of usage

- Factories.
- Warehouses.
- On interior surfaces of steel and concrete storage tanks where high chemical resistance is desired.
- As topcoat at petrol stations.
- Epoxy and polyurethane floor coating systems as top coat.

- In production and storage facilities where corrosive chemicals are used.
- Interior lining of crude oil (upto 90 °C), fueloil and solvent storage tanks.
- Interior lining of process water (upto 95 °C) storage tanks

■ Advantages

- Abrasion and chemical high resistance.
- Resistant to petrol and diesel fuels.
- Easy to apply.
- Excellent adherence to concrete and steel surfaces.
- Cleaning is easy.

TECHNICAL CHARACTERISTICS

ACS EPOXY TC 510® Component A	Epoxy resin
ACS EPOXY TC 510® Component B	Epoxy hardener
Color	Various colors of RAL - Semi-Shiny
Density	1,55 ± 0,05 kg/lt (A+B / 20 °C)
Solid Volume	%74 (A+B)
Mixing Ratio	7:1 (A:B - By volume)
Applying Time(+20°C)	35 Minutes
Waiting Between Coats Minimum	6 Hours -20 °C
Waiting Between Coats Maksimum	4 Days -20 °C
Application Systems	At 100-at 300 micron (Dry film thickness)
VOC	210 gr/lt
Flash Point	>21 °C
Theoretical Spread	5, 00 m ² /kg (100 Millimicron thickness)
Ambient Temperature	+8 °C -+ 35 °C
Surface Temperature	+8 °C -+ 35 °C

NOTE: The above values are given at + 23 °C and 50% relative humidity environment. High temperatures shorten the time, low temperatures prolong the time.

Application Equipment:	Airless Spray	Roller
Thinning Ration (by weight):	%4-5	%10-15
Pressure (bar):	140-240	-
Nozzle (inch):	0, 019-0, 023 inch	-

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APPLICATION PROCEDURE / SURFACE PREPARATION

Prior to the application with ready-to-apply mix all weldseam sands harpangels shall be striped. The prepared mix of paint shall be applied at recommended dry film thickness and consumption rate indicated in paint system controlling with wet film thickness gauge. During the applications pray dust and excessive film thickness shall be avoided. **ACS EPOXY TC 510®** the surface to be treated must be dry, clean, dust-free and of a certain strength. **ACS EPOXY TC 510®** should be applied considering the application time of the last application or topcoat application.

MIXING

ACS EPOXY TC 510® is supplied as ready to use kits in the exact ratio. Before mixing, precondition both A and B parts to the temperature of +15 - +25°C. **ACS EPOXY TC 510®** A Component contains pigment. Mix with epoxy / polyurethane resin mixer with 300 - 400 rpm mechanical stirrer for 3 - 4 minutes until it is homogenous. After pour the entire contents of B ingredient into the container of A ingredient; make sure that there is no product left in the ingredient B package. Components A and B must be used after homogenous mixing (at least 3 minutes).

MIXING RATIOS

ACS EPOXY TC 510®	Component A	Component B
Mixture Amount	21 kg	3,0 kg
Mixture Density	1,55 kg/liter	

APPLICATION METHOD

ACS EPOXY TC 510® the surface to be treated must be dry, clean, dust-free and of a certain strength.

Metal Surfaces: Oil and grease on the new metal surface should be cleaned off by help of detergent or steam; salt and other impurities should be removed off by high pressure fresh water. After the cleaning operation, scraping should be performed at level of Sa 2½ as a minimum according to the ISO 8501. Clean the surface to St 2 - St 3 level mechanically according to ISO 8501 depending on application and ambient conditions. Scraped surfaces must be painted within 4-6 hours.

Painted surfaces: Oil and grease on the old painted surface should be cleaned off by help of detergent or steam; salt and other impurities should be removed off by high pressure fresh water. Clean the casted and old surfaces, steady painted surfaces the surface to St 2 - St 3 level mechanically according to ISO 8501. Scraping should be performed at level of Sa 2½, preferably level of Sa 2½. To obtain a better adhesion, water-jet may be preferred as an alternative to scraping. After water-jet the paint with the roughened surface must be stiff.

Concrete Surfaces: Surface should be prepared and obtain a solid, rough and uniform structure by scraping, or by other mechanical methods and should be cleaned from dust by an

industrial vacuum cleaner. Prior to the application on the clean surface apply **ACS EPOXY PRIMER MAX®** 300-500 gr/m² layer thickness. Before applying pay attention to cleaning the surface. In case if the surface will be retouched it should be dry, clean and free from dirt, should be cleaned according to ISO 8501 standard St 2 level and right after then recoating should be done.

TIPS TO NOTICE

- The relative humidity of air is highest % 80, Avoid application under excessive heat or wind and/or when the ambient and/or substrate temperature is below +8°C or above +35°C.
- If the maximum time is exceeded during application of coatings between layers, the surface should be roughened and if the surface is left in dirty environment for a long time, it should be washed and washed with high pressure fresh water.
- For use as undercoat coating, the system should not exceed 300 microns in dry film thickness, the paint system thickness should be 125 microns and fully cured at service temperatures above 175 °C (maximum 260 °C). Color changes can occur at dry temperatures above 150 °C, but this does not affect the performance of the paint.
- Surface temperature should be 3°C above the then dew point. (Please call our company for the Ambient temperature-Ambient Moisture-Dew Point table).
- The materials to be used at the appropriate temperatures should be brought and stored in the application area 1-2 days prior to the application and enabled to adjust the ambient conditions.
- In extremely cold conditions, heaters should be used to increase the ambient and the workability of the product, the packages should be preconditioned to +20 °C - +25 °C to become ready to use. Epoxy and polyurethane based floor coatings should be applied by specialists.
- The reaction and workability times of resin based systems depend on the ambient and substrate temperatures as well as the relative humidity. Under lower temperatures, the chemical reaction times are prolonged and this increases the pot life, coating interval and the working time. In addition to this, the consumption is increased as the viscosity increases. High temperatures ignite stronger chemical reactions and the above mentioned times decrease accordingly. After completion of the coating, the coating should not fall below + 8 °C at an air temperature of at least 36-48 hours, and no direct water contact, snow on the newly applied product. Within this period, a contact with water may cause a surface carbonation and/or tackiness both of which will make the coating lose its characteristics.

CLEANING OF TOOLS

Tools and equipment used after application can be cleaned with cellulosic or epoxy thinner. Once cured **ACS EPOXY TC 510®** can only be removed by mechanical means.

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PACKAGING

Component A : 21 kg pail Component B : 3,0 kg gallon

STORAGE

In unopened original package, it should be stored in a cool and dry environment at + 10 °C + 25 °C temperature protected from the freezing. In short-term storing, maximum 3 palettes can be stowed on top of each other and delivery has to be according to first in first out system. In long-term storing, the palettes must not be stowed on top of each other.

SHELF LIFE

The shelf life is 12 months from the date of production under suitable storage conditions.

SAFETY

During the application, work clothes, protective gloves, goggles and masks should be used in accordance with the Occupational Health and Safety Rules. Due to the irritating effects of uncured materials, the components should not be allowed to come into contact with the skin and the eye. In case of contact, immediately wash with plenty of water and soap. If swallowed, seek medical advice immediately. Food and beverages should not be left at the application areas. Keep out of reach of children.



Responsibility

The technical information given in this publication is based on the present state of our best scientific and practical knowledge. ACS A PLUS CONSTRUCTION SOLUTION YAPI ANONİM ŞİRKETİ is only responsible for the quality of the product. ACS A PLUS CONSTRUCTION SOLUTION YAPI ANONİM ŞİRKETİ is not responsible for results that may occur because the product is used other than advised and/or out of instructions regarding the place and the method of use. This technical form is valid only till a new version is implemented and nullifies the old ones (06/2019)

