



TECHNICAL DATA SHEET

ALOCIT 28.15 EPOXY COATING FINISH

STANDARD GRADE (All temps above water - underwater below 17°C/63°F)

TROPICAL GRADE (For use underwater where water temp exceeds 17°C)

- Outstanding adhesion on all surfaces including oily, wet & underwater
- Environmentally friendly - solvent free and no heavy metals
- Proven protection against corrosion, including Accelerated Low Water Corrosion (ALWC)
- An inexpensive solution to problem coating needs
- Abrasion resistant

USAGE

Long-lasting abrasion-resistant finish for concrete, steel, ironwork. For protection of steel structures, industrial floors, cellars, bund/storage containment areas, sheet piles, locks and channels, docks, harbours, oil rigs, oil tanks, ships hulls and bilges, bridges, conduits, caverns, industrial plants for wet or oily surfaces, railway and subway tunnels, underpasses, swimming pools etc. Can be used as self-priming coat on minimal surface prep.

- resistant to many alkalis, some acids, oils, sewage, mechanical wear and chemical attack
- can be applied on dry, wet, or even underwater surfaces
- high build (200 - 400 microns/8-16 mil) per coat

TECHNICAL DETAILS

Product Description:	Two component/epoxy resin based/pigmented/solvent free
Volume Solids:	100%
Mixing Ratio (by weight):	5 parts resin - 1 part hardener
Specific Gravity	Mixed - 1.55; Base only - 1-75 (+ or - 10% depending on colour)
Dilution:	Do not dilute
Brush/Tool Cleaner:	Immediately after use. Acetone
Theoretical Coverage Rate*	@ 400µ/16 mil (Maximum WFT) = 1.35m ² /mixed Kg @ 300µ/12 mil (Optimum WFT) = 1.8m ² /mixed Kg @ 200µ/8 mil (Minimum WFT) = 2.7m ² /mixed Kg 1 US gallon @ 25µ/1 mil = 1600 ft ²
Number of Coats	Two coats
Working Life**	@ +27°C/81°F 30/40 minutes @ +20°C/68°F 45/60 minutes
Drying Times	@ +27°C/81°F Touch dry 3-4 hours @ +20°C/68°F Touch dry 6-8 hours
Min Practical Cure Temp.***	+5°C/41°F
Resistant to	Water, sea water, oils, petroleum, some solvents, alkalis and a certain range of acids.
Flash Point	Above +200°C/+392°F
Shelf Life	Resin: 2 years in original container Hardener: 5 years in original container
Storage	Moderate room temperature 15-30°C/59-86°F
Colors	White, Black, Grey - others on request - min quantity may apply US FED-STD-595, RAL, BS 36, BS 3800
Pack Size	Std: 3 kg (2.5 resin 0.5 hardener) 3kg is equivalent to 1/2 US gallon Tropical: 3kg or 1.2 kg (Other sizes in both grades available to order)

- Notes
- * Underwater application can result in reduced coverage rates.
 - ** Working life is dependent on unit size, ambient/product temperature, mixing method and time, application speed relative to reduction in vol. of mixed product.
 - *** Curing will take place at lower temperatures but over an extended period.

SURFACE PREPARATION

A) NEW STEEL

All millscale to be removed by abrasive blasting, check for rogue peaks and laminations, take remedial action. Remove dust and other contaminations. A blast profile of between 50 and 100 μ (2-4 mil) is recommended based on Swedish Pictorial Standards / ISO-8501-1/SSPC/NACE. We recommend SA2 (SP6, NACE 3) as a minimum, and SA 2.5 (SP10, NACE 2) as the optimum. A secondary choice for surface preparation is mechanical abrading to remove surface contamination before coating application.

B) WEATHERED/EXPOSED/CORRODED STEEL

Our basic aim is to remove surface contamination such as corrosion deposits, marine growths, chemical compounds etc., to revealing a clean steel substrate with a surface profile of a minimum 25 microns/1 mil (50 microns/2 mil underwater), various options are:-

- 1) Abrasive blasting, dry, in areas of low chemical contamination followed by optional high pressure water blast (15-20,000psi).
- 2) UHP hydroblasting (30/40,000psi) to remove all previous coatings etc and reveal original profile. Especially suitable for wet environments such as ships tanks, piers, jetties etc. Clean to an agreed standard and check soluble salts level.
- 3) UHP and High Pressure water blasting may sometimes be employed with added abrasive.
- 4) Mechanical cleaning (power) i.e. needle gunning, rotary wire brushing etc to remove all contamination/dust etc.

Notes:

- 1) Stains of rust, paint or mill scale remaining on the surface do not present a problem providing minimum surface profile criteria are met.
- 2) Alocit product range can be applied to both dry, wet and underwater surfaces, however whilst clean steel in saltwater is acceptable, steel heavily contaminated with salt and/or other chemicals is not acceptable. This type of steel requires decontamination, with chemical levels measured before and after.

C) CONCRETE

The substrate should be free from high levels of laitence, dust, oil contamination, large surface voids etc. Sometimes brush blasting (dry) or UHP hydroblasting are appropriate methods, especially for large areas, large cracks/surface voids should be repaired prior to coating.

D) NONFERROUS METALS

Light surface abrading, remove dust etc. If there are any queries re surface preparation prior to applying the Alocit coating system, please contact our technical dept. for further advice.

E) NON METALLIC

If possible, surface abrading, then remove dust etc if in doubt, apply a test patch before coating

PRODUCT APPLICATION - Methods

Atmospheric: Brush & Roller
Airless spray: Minimum 68:1
Tip size: Standard - 21-23 thou
Tropical - 23-25 thou

Underwater: Alocit hand brushes - use firm circular motion with downward pressure.
Airless pump with Alocit round brush adaptor - use firm circular motion with downward pressure.

Notes:

- 1) Please contact our technical department for specific details or if in any doubt.
- 2) All equipment should be cleaned immediately after use with acetone or suitable thinner.
- 3) Airless spray is not suitable for wet/damp surfaces

PRODUCT APPLICATION - COATING SYSTEMS

Steel: **Above and below water:**
2 coats Alocit 28.15

Concrete: **Above and below water:**
2 coats Alocit 28.15

Notes:

- 1) Using Alocit 28.15 in different colors for each of a multi-coat system helps ensure full coverage of each coat

PRECAUTIONS

Always use up the entire can. Product cannot be reused after working life expires. Always empty the entire amount of hardener into the epoxy, because the proper mixing ratio must be maintained. Containers are pre-measured and resin containers are oversized to allow adding and mixing of the hardener.

Mix thoroughly by hand or with a mechanical mixer - avoid aeration of mixed product. Make sure that the material is mixed well around the walls and the bottom of the can before mixing with hardener.

In hot ambient conditions store equipment and material in the shade, keep product, equipment and supply lines as cool as possible to preserve pot life.

IMPORTANT - APPLICATION AND RECOATING

Alocit 28.15 must be brushed onto the surface with circular motions, using pressure on moist, wet, submerged, or oily surfaces. 2nd coat may be applied once first coat is touch dry (6-8 hours at 20°C/68°F) and must be applied before the first coat is fully cured (3 - 6 days depending on substrate temp).

All information is based on results gained from experience and tests and is believed to be accurate but is given without acceptance of liability for loss or damage attributable to reliance thereon as conditions of use lie outside our control. Users should always carry out sufficient tests to establish the suitability of any products for their intended applications. No statements shall be incorporated in any contract unless expressly agreed in writing nor construed as recommending the use of any product in conflict of any patent.

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