

PRODUCT CODE: AS8304 (M2) FSC# 30045 BROWN TOPCOAT

END USE: RUST INHIBITIVE COATING FOR USE AS A DTM OR OVER AS8300 RED OXIDE PRIMER ON STRUCTURAL STEEL, BRIDGES, DAMS, DAM GATES TRANSMISSION TOWERS AND TANK EXTERIORS.

RESIN TYPE: CALCIUM SULFONATE ALKYD (CSA), 4:1 RATIO SULFONATE TO ALKYD (MAXIMUM 25% ALKYD by Weight)

SOLVENT TYPE: ALIPHATIC HYDROCARBON

VISCOSITY: 90 - 130 KU @ 77°F (25°C)

WEIGHT/GALLON: 9.43 ± 0.5 lbs./gallon (1.1316 kg/liter)

WEIGHT % SOLIDS: 72 ± 2.0 (31% CALCIUM SULFONATE by Weight)

VOLUME % SOLIDS: 58 ± 2.0

SURFACE PREPARATION: SSPC SP-1, SSPC SP-2, SSPC SP-3, SSPC SP-6, SSPC SP-7, SSPC SP-12 OR SSPC SP-14 (OR EQUIVALENT NACE STANDARDS).

WET FILM: 7 - 18 mils (175 – 450 microns)

DRY FILM: 4 - 10 mils (100 – 200 microns)

FLASH POINT: 105°F (40.5°C)

GLOSS 60°: LOW

THINNER RATIO: IF REQUIRED USE UP TO 10% MINERAL SPIRITS BY VOLUME.

V.O.C. 2.64 lbs./gallon (317 gms/liter).

CHARACTERISTICS: FIRM DRY PROPERTIES. HIGH SOLIDS AND EXCELLENT CORROSION RESISTANCE. CAN BE APPLIED OVER TIGHT RUST.

PERFORMANCE CHARACTERISTICS:

SYSTEM TESTED: STEEL BLASTED TO SSPC-SP10, AS8304 @ 8 mils (200 microns) DFT

CYCLIC WEATHERING: ASTM D5894, 4 CYCLES OR 5000 HOURS

RUSTING	ASTM D610	– RATING 10
BLISTERING	ASTM D714	– RATING 10
UNDERCUTTING	ASTM D1654	– RATING 10

SALT FOG RESISTANCE: ASTM B117, 5000 HOURS

RUSTING	ASTM D610	– RATING 10
BLISTERING	ASTM D714	– RATING 10
UNDERCUTTING	ASTM D1654	– RATING 10

PENCIL HARDNESS: ASTM D3363 5B

FLEXIBILITY: ASTM D522 PASES 180° BEND, 1/8" (3.2 mm) MANDREL

APPLICATION INSTRUCTIONS

THE RECOMMENDED APPLICATION METHOD FOR ARMOR-SHIELD CSA PRODUCTS IS AS A SINGLE COAT SYSTEM APPLIED AT 7 – 18 mils (175 – 450 microns) WFT OR AS SPECIFIED BY DRY FILM REQUIREMENTS. WHEN USING A TWO-COAT APPLICATION METHOD (i.e. PRIMER/TOPCOAT), A MINIMUM OF 6 HOURS IS REQUIRED BETWEEN COATS.

EQUIPMENT: AIRLESS SPRAY – 30:1 GRACO BULLDOG WITH 3/8” (9.5 mm) I.D. HIGH PRESSURE LINE AND A GRACO SILVER GUN WITH A 0.017”-0.021” (0.43 – 0.53 mm) SPRAY TIP.

CONVENTIONAL SPRAY – USE A DV-MBC GUN OR EQUIVALENT WITH A “D” FLUID NOZZLE AND A 64 AIR CAP.

NOTE: BRUSH AND ROLLER APPLICATION CAN BE USED AS WELL AS OTHER SPRAY EQUIPMENT. CONTACT YOUR REPRESENTATIVE FOR RECOMMENDATIONS.

SAG RESISTANCE: 30 mils (750 microns) DFT

COVERAGE: 175-190 SQ. FT. PER GAL. @ 5 mils DFT (4.295 – 4.663 m²/l @ 125 microns DFT).

THINNING: UP TO 10% WITH MINERAL SPIRITS AS NECESSARY.

MIXING: MIX TO A UNIFORM CONSISTANCY BY HAND OR POWER MIXER.

DRYING TIMES: DUST FREE.....2 -6 hours* @ 77°F (25°C), 5 mils (125 microns) DFT, 50% RH
FIRM.....20 - 48 hours* @ 77°F (25°C), 5 mils (125 microns) DFT, 50% RH
RECOATABILITY....NO MAXIMUM

* TIMES VARY DEPENDING UPON ENVIROMENTAL CONDITIONS, WIND, SUN EXPOSURE, ETC.

- MAY BE APPLIED TO SURFACES AND IN AMBIENT TEMPERATURES DOWN TO 0°F (-17.7°C) AS LONG AS NO VISIBLE CONDENSATION OR ICE IS PRESENT.
- THE MATERIAL TEMPERATURE, PRIOR TO BEING APPLIED, MUST BE ELEVATED TO ACHIEVE A WORKABLE VISCOSITY. THIS TEMPERATURE MAY BE HIGHER THAN THE MINIMUM RECOMMENDATION OF 35-45°F (1.6 – 7.2°C) BASED ON EQUIPMENT, DESIRED WORKING TIMES AND AMBIENT CONDITIONS.
- AMBIENT TEMPERATURES MUST REMAIN 3° DEGREES ABOVE THE DEW POINT DURING THE APPLICATION PROCESS.
- MATERIALS SHOULD NOT BE APPLIED WHEN THE RELATIVE HUMIDITY EXCEEDS 90%.
- MAY BE STORED AT TEMPERATURES DOWN TO 0°F (-17.7°C).

CLEAN-UP: CLEAN EQUIPMENT WITH MINERAL SPIRITS.

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