

<b>PRODUCT CODE:</b>	<b>ARMOR SHIELD AS8386 (B2) FSC#13531 TAN</b>
END USE:	RUST INHIBITIVE COATING FOR USE AS A DTM OR OVER AS8411 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:	85 - 115 KU @ 77°F (25°C)
WEIGHT/GALLON	11.26 ± 0.5 lbs./gallon (1.351 kg/liter)
WEIGHT % SOLIDS:	78 ± 2.0 (33% CALCIUM SULFONATE by Weight)
VOLUME % SOLIDS:	60 ± 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). KYTC: 12 - 15 mils (300 – 375 microns)
DRY FILM:	4 - 10 mils (100 – 175 microns). KYTC: 7 - 9 mils (175 – 225 microns)
FLASH POINT:	105°F ( 40.5°C)
GLOSS 60°:	LOW
THINNER RATIO: V.O.C.	IF REQUIRED USE UP TO 10% MINERAL SPIRITS BY VOLUME. 2.45 lbs./gallon (294 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, AS8386 @ 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 SERIES PRODUCTS IS 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 m<sup>2</sup>/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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