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DEVCHEM® 755

FDA Epoxy Lining

Cat. # 755KXXXX
(Special Order)

PRODUCT DESCRIPTION

Generic: Advanced Technology Epoxy

General Description: A two-component, chemically cured high performance tank lining.

Typical Uses: DEVCHEM 755 is an ideal tank lining for any type of food contact requiring FDA compliance. Especially useful as a rail car lining and in industrial storage and process tanks.

Special Qualifications: Meets FDA requirements (21 CFR 175.300) for direct food contact.

SPECIFICATION DATA

Color: White (755K3501), Gray (755K2479)

Finish: Semi-Gloss

Reduction Solvent: T-5 Thinner

Clean-up Solvent: T-10 Thinner

Weight/Gallon: 10.7 lbs./gal. (1.28 kg/L)

VOC: 2.35 lbs./gal. (279 g/L)

Solids By Volume: 66%

Theoretical Coverage at 1.0 Mil (25 microns) Dry: 1058 sq. ft./gal. (26 m²/L)

Recommended Film Thickness: 5-6 mils (125-150 microns) dry – 7.9-9.1 mils (190-227 microns) wet.

Systems: Please consult the appropriate system guide, the particular job specification or your ICI Devoe Coatings' Industrial Coatings Specialist for proper systems using this product. Systems must be selected considering the particular environment involved.

Service Temperature Limits: 200°F (93°C) dry

Minimum Dry Time (ASTM D 1640): At 5 mils (125 microns) DFT

	50°F(10°C)	77°F(25°C)	90°F(32°C)
To Recoat	36 hours	16 hours	7 hours
Dry Hard	44 hours	22 hours	16 hours
Maximum Recoat	7 days	4 days	1 day

Ventilation, film thickness, humidity, thinning, and other factors can influence the rate of dry.

Warning: The above table provides general guidelines only. Always consult your ICI Devoe Coatings Specialist for appropriate recoat windows since the maximum aged recoat time of this product may be significantly shortened or lengthened by a variety of conditions, including, but not limited to humidity, surface temperature, and the use of additives or thinners. The use of accelerators or force curing may shorten the aged recoat of individual coatings. The above recoat windows may not apply if recoating with a product other than those listed above. If the maximum aged recoat window is exceeded, please consult your ICI Industrial Coatings Specialist for appropriate recommendations to enhance adhesion. Failure to observe these precautions may result in intercoat delamination.

Shelf Life: Over 24 months at 77°F (25°C) – unopened

Hardness (ASTM D 3363, 7 day cure @ 77°F (25°C): 6H

Mix Ratio By Volume: 3 (base): 1 (converter) – see mixing instructions.

Induction: 30 minutes at 77°F (25°C) – see mixing instructions.

Pot Life: 3 hours @ 77°F (25°C) & 50% R.H.

FEATURES

Advantages:

- Meets FDA direct food requirements
- Ambient cure. Does not require baking
- Easy application
- Two coat system
- Exceptional resistance to chemicals, food stuffs, and solvents

Limitations of Use: Exterior exposure will cause color change, early dulling and loss of gloss, but this does not affect the protective properties of the coating.

PERFORMANCE DATA

Adhesion: (ASTM D 4541) – Excellent

Humidity Resistance: (ASTM D 2247) – Excellent

Salt Spray Resistance: (ASTM B 117) – Excellent

Chemical and Solvent Resistance: (ASTM D 1308) – Excellent



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GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances.

New Surfaces: Steel – Abrasive blast to minimum SSPC-SP10 or SSI-Sa2½ near-white. Blast profile on steel should be 1½ - 2½ mils (38-62 microns) in depth and be of a sharp, jagged, nature as opposed to a "peen" pattern (from shot blasting). Surfaces must be free of grit dust. The first coat of the system should be applied to cleaned surfaces as soon as possible to prevent re-rusting or contamination.

Previously Painted Surfaces: Remove old paint, Prepare surface and prime as for new steel. Achieve a minimum of SSPC-SP10 or SSI-Sa2½.

DIRECTIONS FOR USE

Tinting: Do not tint.

Thinning: Thinning is not normally required or desirable; However, at lower temperatures, small amounts (5% or less) of Devco Coatings T-5 Thinner can be added to the mixed components depending on local VOC and air quality regulations.

Mixing: DEVCHEM 755 Lining is a two-component product supplied in 4 gallon or 1 gallon kits which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Stir the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion, add the converter slowly with continued agitation. After the converter add is complete, continue to mix slowly until the system is homogeneous.

Application: DEVCHEM 755 Lining should be applied only by air or airless spray. Brushing can be used for touch up or striping, do not use rollers. Brushing may require multiple coats to achieve correct film thickness and/or hiding. For air spray, use agitated spray pots, 1/2" ID air hoses and 1/2" fluid hose. DeVilbiss MBC-510 gun with and E or D tip and needle and a 704 air cap, or equivalent equipment is recommended. For airless spray application, use 100 psi air pressure, 3/8" ID fluid hoses not exceeding 100 feet in length, a 30 to 1 or larger heavy duty Graco pump or equivalent, and .021" to .025" range tip sizes.

Ventilation: It is very important for the safety of the applicator and the proper performance of the DEVCHEM 755 Coating that good ventilation be provided to all portions of the enclosed area. Recommended tank

ventilation involves two important phases. Phase one is to pump fresh, dehumidified air into all areas of the tank, especially "dead air" areas. Phase two is to exhaust, via an explosion proof exhaust fan, the solvent vapors from the lowest portion of the tank. This practice of pumping fresh air into the tank and exhausting solvent vapors out of the lowest part of the tank should be provided throughout the application and curing processes. This practice is to insure that all solvents are removed from the coating. Tanks must be cured 7 days at 77°F (25°C) with ventilation before being put into service. At lower temperatures, longer cure times are required.

Coating System: Two stripe coats on all sharp edges, cutouts and welds. Two coats of DEVCHEM 755 Lining at 5-6 mils (125-150 microns) per coat. Use contrasting colors for each coat and stripe coat. **Note:** The maximum dry film thickness of the DEVCHEM 755 system is 18 mils (450 microns). Dry film thickness above 18 mils (450 microns) could reduce the service life of the coating. Cure to put tank into service: 7 days with ventilation at 77°F (25°C) for maximum chemical resistance. If forced heat cure is desired, contact your ICI Devco Coatings Representative.

Dry Time: See table on front side.

Clean-up: Use T-10 Thinner.

PRECAUTIONS

For industrial use only. Keep out of reach of children. Consult Material Safety Data Sheets appropriate for this product for important health and safety information prior to use.

HMIS DATA	COMPONENT	HEALTH	FLAMMABILITY	REACTIVITY
	755 BASE 755BXXXX	2*	2	1
	755 CONVERTER 755C0910	2*	2	1

* Indicates possible chronic health hazard

SHIPPING

Freight Classification: Paint
Flash Point: 100°F (38°C)
Packaging: 1 gallon kit (3.785L) 4 gallon kit (15.14L)
 0.75 gallon base 3.0 gallon base
 0.25 gallon converter 1.0 gallon converter

Shipping Weight: 4 - 1 gallon kits - 52 lbs. (236 kg)
 4 gallon kit - 48 lbs. (21.8 kg)

755KXXXX (1/02)
 Ad Stock #68661C



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