



ICI Devoe Coatings is a member of the ICI Paints World Group

DEVVRAN® 220MX

Heavy Duty Micaceous Iron
Oxide Epoxy

Cat. # 220BXXXX/220C903MX
(Special Order)

PRODUCT DESCRIPTION

Generic: Catalyzed Micaceous Iron Oxide Polyamide Epoxy

General Description: A high performance, multi-purpose, two-component chemically-cured epoxy semi-gloss coating containing micaceous iron oxide for industrial applications. For use on properly prepared steel surfaces.

Typical Uses: Ideal for structural steel, piping, tanks and equipment in chemical, fertilizer, power plants, petroleum refineries, pulp and paper mills, water and sewage treatment plants, mining operations and bridges.

SPECIFICATION DATA

Color: Off- white, oxide red, gray

Finish: Semi-Gloss

Reduction Solvent: T-10 Thinner.

Clean-up Solvent: T-10 Thinner

Weight/Gallon: 11.65 lbs./gal. (1.4 kg/L)

VOC (EPA 24): 2.38 lbs./gal. (284 g/L)

Solids By Volume (ASTM D 2697-7 days): 67%

Theoretical Coverage at 1.0 Mil (25 microns) Dry:
1075 sq. ft. (26.4 m²/L)

Recommended Film Thickness: 5-7 mils (125-175 microns) dry – 7.5-10.5 mils (188-263 microns) wet. (Make allowances for loss due to overspray & irregular surfaces.)

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: 250°F (121°C) dry

Minimum Dry Time (ASTM D 1640): At 6 mils (150 microns) DFT

(Use of cold weather additive will decrease times noted. See cold weather applications on back page.)

Substrate Temp.	50°F (10°C)	60°F (16°C)	70°F (21°C)	80°F (27°C)
Minimum Recoat	20 Hours	8 Hours	6 Hours	4 Hours
Dry Hard	35 Hours	22 Hours	16 Hours	10 Hours
Maximum Recoat				
Self	90 Days	90 Days	90 Days	90 Days
359, 369, 389	14 Days	14 Days	14 Days	14 Days
378, 379	7 Days	7 Days	7 Days	7 Days

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): 5B

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

Induction: 15 minutes at 60-80°F (16-27°C) after mixing – see mixing instructions.

Pot Life: 8 hours @ 77°F (25°C) & 50% R.H.

FEATURES

Advantages:

- Excellent corrosion protection – contains micaceous iron oxide
- Excellent solvent and chemical resistance – resists splash and spillage of solvents, alkalis, salts, moisture, oils, greases, foodstuffs and detergents
- Low VOC
- Self-priming on steel
- Abrasion resistant
- High build/high solids coating

Limitations of Use: Exterior exposure will cause a color change, early dulling, and loss of gloss, but this does not affect protective properties. Epoxy coatings may yellow during application and cure if exposed to the combustion by-products of improperly vented fossil fuel burning heaters. Commonly finished with Devoe Coatings DEVTHANE™ Urethane Enamel for maximum exterior color & gloss retention.

PERFORMANCE DATA

Adhesion: (ASTM D 4541) – Excellent

Salt Spray Resistance: (ASTM B 117) – Excellent

Direct Impact Resistance: (ASTM D 2794) – Very Good

Abrasion Resistance: (ASTM D 4060) – Excellent

Humidity Resistance: (ASTM D 2247) – Excellent

Exterior Exposure: (45° South – Lt. Industrial) – Very Good (Normal, expected loss of gloss for epoxy coatings)

Chemical Resistance: (ASTM D 1308 – 24 hr. contact) – Excellent. Resists splash and spillage of alkalis, salts, moisture, oils, greases, food stuffs, and detergents, 50% sodium hydroxide, 28% ammonia, 5% trisodium phosphate, 25% citric acid, 25% lactic acid, 10% sulfuric acid, crude oil, 10% hydrochloric acid, 20% tannic acid, 5% sodium chloride, 10% ammonium hydroxide, sewage, 50% ethanol, gasoline, methanol, kerosene, naphtha, xylol.

All results based on testing of system comprised of two coats of Devran 220MX at 6 mils (150 microns) DFT per coat.



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GENERAL SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease, form release agents, curing compounds, laitance, other foreign matter and be structurally sound. Remove all loose paint, mortar spatter, mill scale, and rust. All direct to metal coatings provide maximum performance over blasted surfaces. There are situations and cost limitations which preclude blasting. DEVTRAN 220MX was designed to provide excellent protection over less than ideal surface preparation. The minimum standard for non-immersion service is SSPC-SP2 (SSI-St2). **This minimum surface preparation standard applies to steel that has been previously abrasive blasted, coated and deteriorated.** Where very rusty surfaces still remain after cleaning use PRE-PRIME 167™ Sealer before application of DEVTRAN 220MX Coating.

New Surfaces: Steel – New steel surfaces should be initially blasted to a minimum commercial blast cleanliness in accordance with SSPC-SP6 or SSI-Sa2 for non-immersion service. Blast profile on steel should be 1 1/2

to 2 1/2 mils (38-63 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. **Galvanized Steel** – Remove dirt and oils by solvent cleaning or with DEVPREP® 88 Cleaner followed by a thorough water rinsing. Prime with DEVTRAN 205 Epoxy Primer for non-immersion. For severe moisture condition, abrasive blasting is recommended before priming with DEVTRAN 201 Epoxy Primer.

Previously Painted Surfaces: Old coatings should be tested for lifting. If lifting occurs, remove the lifted coating. Otherwise scuff sand glossy areas and aged epoxy coatings. Clean aged epoxy or urethane coatings with DEVPREP 88 Cleaner. Remove cracked and peeling paint. Prime bare areas with primer specified under **New Surfaces**.

DIRECTIONS FOR USE

Tinting: Do not tint.

Thinning: Thinning is not normally required or desired; however, at extreme environmental conditions, small amounts (10% or less by volume) of the solvents on the reverse page can be added depending on local VOC and air quality regulations. Any solvent addition should be made after the two components are thoroughly mixed.

Mixing: Devtran 220MX Coating is a two component product supplied in 10 gallon and 2 gallon kits which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix both portions first to obtain a smooth, homogeneous condition. Then add the converter slowly with continued agitation. After the converter add is complete, continue to mix slowly. Allow the mixed material to stand 15 minutes at 60-80°F (16-27°C) before use. Always restir before use. Mixed material is usable for 8 hours; if it thickens, do not add thinner, but discard and mix fresh material. Higher temperatures will reduce working life of the coating; lower temperatures will increase it. Surfaces coated with this product may become slippery when wet. For additional slip resistance in areas of pedestrian traffic, add one pound per gallon of coarse pumice or other texturing material.

Application: Spray is preferred for appearance and film build control. For air spray application, use a fluid tip of .070" or larger, a Graco #800 Gun and an air cap with good break-up. The fluid pressure should be kept low, with just enough air pressure to get good break-up of the coating. Excessive air pressure can cause overspray problems. Where airless equipment is used, an airless spray pump capable of 3,000 psi (207 bars) and .019" to .025" tip size will provide a good spray pattern. Ideally, fluid hoses should not be less than 3/8" ID and not longer than 50 feet to obtain optimum results. Longer hose length may require an increase in pump capacity, pressure, and/or thinning. DEVTRAN 220MX Coating may also be applied by brush or roller. Care should be taken that proper and uniform thicknesses are obtained.

Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding. For roller work use a clean synthetic roller with 1/4"-1/2" nap. New rollers should be thoroughly wet with the specified thinner and spun vigorously to remove loose fibers.

Cold Weather Applications: For substrate temperatures between 25°F (-4°C) and 40°F (5°C), cold weather additive 060A0000 may be added. Two pint containers of 060A0000 may be added to the converter portion of a 10 gallon kit of DEVTRAN 220MX. Thoroughly mix the 060A0000 additive in the converter with a power mixer prior to adding the converter to the base portion. Caution: Use of the cold weather additive will shorten the pot life.

Dry Time: (ASTM D 1640): At 6 mils (150 microns) DFT with Cold Weather Additive (060A0000)

	25°F(-4°C)	30°F(-1°C)	40°F(4°C)
To Recoat	20 hours	14 hours	6 hours
Dry Hard	>30 hours	26 hours	20 hours

Spreading Rate: Apply at 150-215 sq.ft. per gallon (3.7-5.3 m²/L) depending on surface texture and porosity. Make allowance for any losses due to overspray or surface irregularities.

Topcoats: Can be used as a finish for interior areas. Accepts a variety of topcoats. In interior or exterior areas, DEVTHANE™ Urethane Enamels could be used as a finish to enhance performance and/or appearance.

Dry Time: At 77°F (25°C) & 50% R.H., dries to recoat with epoxy or urethane in 6 hours and dry hard in 9 hours.

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.

	COMPONENT	HEALTH	FLAMMABILITY	REACTIVITY
HMIS DATA	220 BASE 220BXXXX	2*	2	1
	220 CONVERTER 220C903MX	2*	2	1

* Indicates possible chronic health hazard

SHIPPING

Freight Classification: Paint, 3, PG III. UN1263 (Flammable Liquid)
Flash point: 85°F (29°C)
Packaging: 2 gallon kit (7.570L) 10 gallon kit (37.850L)
 1.00 gallon base 5.00 gallon base
 1.00 gallon converter 5.00 gallon converter

Shipping Weight: 4 gallon case (base or converter) - 53 lbs. (24.0 kg)
 10 gallon kit - 128 lbs. (58.4 kg)

220MX (9/99)
 Ad Stock #67023A



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