



PRODUCT DATA HRCSA 10-826

Engineers Choice

HRCSA-10 Series; High Ratio Co Polymerized Calcium Sulfonate Coatings

Resin: High Ratio Co-Polymerized Calcium Sulfonate HRCSA (Minimum 9.5% active sulfonate, must maintain a 9-11 to 1 ratio Total Base Number to Active Sulfonate ie. total base number of 85 to 104 to 9.5% Active Sulfonate as determined by Titration Testing (See Bipacco technical dept. for protocols)

Description: HRCSA -10 High Ratio Co-Polymerized Calcium Sulfonate Primer/Topcoat is a pigmented High Ratio Co-Polymerized Calcium Sulfonate coating, designed and engineered exclusively for encapsulation (overcoat) of existing aged leaded paints, vinyls, coal tar epoxy, polyurethanes, epoxy mastics, organic or inorganic zinc, galvanizing, metallizing, acrylics, CORTEN steel and tightly adhered contaminant free rust, or re-coating of new or prepared structural steel..

Colors: Gray Fed# 26373

Viscosity: 7000-15000 CPS ASTM D2196 RVT #6 AT 10 RPM

VOC'S: 240-290 grams per litre (depending on color)
2.0 - 2.42 lbs per US gal (depending on color)

Mixing: as required.

Thinning: Brush/Roller: Up to 10% with WCC thinner # 101
Conventional Spray: 10% with WCC thinner # 101.
Airless Spray: No thinning required

Recommended Film Thickness: 10 - 12 mils DFT recoat (prepared steel)
5 - 7 mils DFT overcoat (existing coatings).

Spread rate 1018 sq. ft. per U.S. Gal. @ 1 mil DFT)

Solids: 63.5% ± 2% (depending on color) ASTM D2697

Weight Per Gallon: 9.13 lbs/US Gal. ± .25%.

Drying Times: 12 to 24 hours depending on film thickness and ambient temperature

Note: Does not get brittle like conventional paints

Products uses: An industrial maintenance coating primarily used in the Bridge & Marine industries. Consult your manufactures representative for technical assistance.

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Surface Preparation: All grease, oil, grime, and other contaminants must be removed from the surface using, commercial detergent or other suitable cleaning method (SSPC-SP1). Hand tool cleaning (SSPC-SP2), power tool cleaning (SSPC-SP3), or High Pressure Water Cleaning (SSPC-SP12-WJ4), is sufficient preparation to produce excellent results, SSPC-SP6 or SSPC-SP12-WJ3 (L to M) is recommended for immersion service. The prepared surface must be analyzed for Chloride, Nitrate and Sulfate content (Termarust has test kits available). Upper limit Chloride NVC3 3 ug/cm², Sulfate NVS10 10ug/cm² when using water. All surface areas should be clean and dry. In addition can be

applied over SSPC-SP-1; SP-2; SP-3; SP-6; SP-7; SP-10; SP-5; SP-11; SP-12; SP-13; SP-14. Consult manufacture for specific surface preparation requirement to meet your requirements.

Application: HRCSA-10 Self Priming/ Topcoat should not be applied at temperatures below 2°C or 35.5°F with a steel temperature not less than 2°C or 35.5°F. There must be a 2° C or 5° F spread between temperature and dew point. To apply the coating the relative humidity should be no greater than 99% and the steel should be free of surface moisture.

Note: As a touchup procedure HRCSA-10 Self Priming / Topcoat may be applied below freezing (-18°C or 0°F). This is not recommended unless steps are taken to control ice crystals on the steel before application. i.e. spot heating. Cold temperatures will slow the coating's cure.

Application Equipment: Airless: use a pump with a ratio of at least 30:1 and ¼ " line with a .017-.023 spray tip.

Conventional spray equipment: Use a pressure feed pot with 25 lbs of pot pressure and 40 lbs of atomization pressure with no more than 50' of 3/8 " spray line. Use a DV-JGA with a D set up or equivalent.

Brush & Roll: Use good quality China bristle brushes and phenolic core roller covers up to 1" nap. (Note: because application equipment varies and the desired finish must be determined before choosing application method)

Performance Data ASTM D5894 Cyclic Corrosion Freeze-Thaw 360 hr cycles FHWA 2009 Test results: @ 4-6 mils DFT, 19 cycles 6840 Hrs.

Salt Spray Resistance:* (ASTM B117): @4 mils DFT 4,000 - 5,000 hours with < 2mm creep at the scribe (ASTM D1654)@10 mils DFT 8000-10,000 hours

QUV Weatherometer Result: (ASTM 653) @ 4 mils DFT 4,000 - 5,000 hours. Passes with no peeling, flaking or corrosion

C151B Xenon Arc: @ 4 mils DFT Passes with no peeling, flaking, or corrosion

Weatherometer Performance:* @ 4 mils DFT 4,000 - 5,000 hours

K.T.A. Tator Enviro-Test ASTM Standard Practice draft #1 Date 04-10-92: 10 mils DFT SP6-Steel 4,445 hours

10 mils DFT Aged Alkyd 1,200 hours

5 mils DFT SP6 - Steel 2,248 hours

5 mils DFT Aged Alkyd 1,520 hours

Application Ambient application Information: Can be applied at temperatures as low as 0 degrees F. Can be used on substrate temperatures up to 500 F.

Shelf Life: 24 months minimum in original unopened container stored between 32 F and 100 F. Material subject to reinspection after 24 months.

Safety Information: For Industrial USE ONLY. Read MSDS prior to opening. Avoid contact with skin and eyes. Use organic respirators when using this product. Vapors might be harmful. Use caution as adequate ventilation, protective clothing, respirators, and gloves.

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