



**Dudick inc.**

Corporate Offices  
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**PROTECTO-COAT 1130**

**HIGH SOLIDS, HIGH PERFORMANCE,  
MULTI-FUNCTIONAL EPOXY  
COATING, 30-40 MILS (1 mm)**

**FEATURES**

Meets all VOC Requirements  
Low Odor  
Low Temperature Cure  
Excellent Solvent Resistance

**RECOMMENDED APPLICATIONS**

Containment Areas                      Pump Housings  
Structural Steel                            Storage Tanks  
Solvent Storage

**CHEMICAL RESISTANCE**

Inorganic Acids                              Oils  
Alkali Solutions                                Salts  
Solvents ( including Methylene  
Chloride and Ethylene Dichloride )

**TEMPERATURE LIMITS  
(METAL APPLICATIONS)**

Immersion up to 120°F  
Dry -      200°F - Continuous  
            250°F - Intermittent

**COLORS:** Consult Dudick, Inc. for available colors

**PHYSICAL PROPERTIES**

Compressive Strength ASTM C-579	12,000 PSI
Tensile Strength ASTM C-307	4,000 PSI
Flexural Strength ASTM C-580	6,000 PSI
Shore D Hardness ASTM D-2240	92
Taber Abrasion ASTM D-4060	58 mg.
Flame Spread ASTM D-635	<5 mm
VOC ASTM D-3960	<50 g/l

**SPECIFICATIONS**

**Protecto-Coat 1130** shall be a 30-40 mils thick, 100% solids, flake glass filled, polymer alloy epoxy coating consisting of a basecoat and topcoat of 15-20 mils each, as manufactured by Dudick, Inc. Materials shall be applied by brush, roller or plural component spray in accordance with manufacturer’s recommended practices.

**THE PROTECTO-COAT 1130 SYSTEM**

**The Protecto-Coat 1130** uses a moisture tolerant primer and two coats of low temperature cure, multi-functional epoxy resin to protect concrete and metal substrates.

**Primer** is designed to prevent abrasive blasted metal from developing rust bloom prior to the application of the **Protecto-Coat 1130**. For maximum performance, all metal surfaces should be primed, but primer may not be needed for mild, non-immersion service. Concrete must be primed to aid in the “wetting out” required for good bonding.

Conductive Primers are available for applications on concrete where spark testing is required or specified.

**Protecto-Coat 1130** is applied in two coats by brush, roller. Each coat to be 15-20 mils thick for a total of 30-40 mils DFT.

**ESTIMATING QUANTITIES AND ORDER BILL OF MATERIAL**

<b>Protecto-Coat 1130</b>		
Actual 30-40 MIL DFT	30 ft. <sup>2</sup>	30 ft. <sup>2</sup>
Theoretical 40 MIL DFT	45 ft. <sup>2</sup>	45 ft. <sup>2</sup>
S-10 Solvent	500 ft. <sup>2</sup>	500 ft. <sup>2</sup>

\*Quantities shown are for estimating purposes only. Actual field usage may vary.

**APPLICATION INSTRUCTIONS  
SURFACE PREPARATION**

**Metal:** Metal surfaces must be abrasive blasted to an appropriate finish.

Immersion and heavy spillage service: White Metal, SSPC SP 5 or NACE #1, minimum 3.0 mil profile. Heavy non-immersion service (i.e. fumes and spillage): Near white, SSPC SP 10 or NACE #2, minimum 2.0 mil profile. Atmospheric service: Commercial SSPC SP 6 or NACE #3, minimum 2.0 mil profile.

**Concrete:** Concrete must be mechanically prepared to remove surface laitance. Oils, grease or other contaminant must be removed prior to surface preparation. Concrete must be free of curing compounds and form release agents. Surface texture should be similar to 40-60 grit sandpaper or the visual standard, CSP-5 from the International Concrete Repair Institute **with exposed pea gravel**. The prepared surface should have a nominal tensile strength of 250 PSI per ASTM D-7243.

All concrete substrates must be checked for moisture prior to product application using the Plastic Sheet Test, ASTM D-4263.

Additional surface preparation will be required if a 40-60 grit texture **with exposed pea gravel** is not achieved and the surface laitance not completely removed with the first mechanical preparation.

Mechanical preparation removes laitance, exposing honeycombs or voids beneath the surface which must be filled with **Scratch Coat 300**. (Refer to separate product bulletin)

**APPLICATION SPECIFICATIONS**

Substrate temperature for both concrete and metal must be between 50°F and 110°F.

Relative humidity must not exceed 90%.

Substrate temperature must be 5°F above the Dew Point.

**PRIMING**

The following Primers are compatible with **Protecto-Coat 1130**: Primer 67, Primer 67LV, Primer 67DPLV, Primer 67DTO & Primer 60.

**Metal:** Mix the pre-measured units of **Component A with Component B**. Prime all metal surfaces to be coated with **Primer** at 3-4 mils WFT.

**Concrete:** Mix the pre-measured units of **Component A with Component B**. Prime all concrete surfaces to be coated with either Primer at 3-4 mils WFT. The basecoat may be applied over Primer that is “tacky”. Do not allow the Primer to puddle.

**Important** – With all epoxies after priming and before each additional coat, examine the surface for amine blush (oily film). If present, remove by washing with warm water and detergent.

**Protecto-Coat 1130 Mix Ratio**

Component A 97 fl. oz.  
Component B 31 fl. oz.

Pot life of the mixed **Protecto-Coat 1130** will depend on the temperature. To prevent material waste and avoid damage to equipment, do not mix more material than can be used according to the following table.

TEMPERATURE	POT LIFE
50°F	40 min.
75°F	25 min.
90°F	12 min.

*This material develops high exotherm when in mass.*

*Catalyzed material must never be left unattended!*

**BASECOAT/TOPCOAT  
(Plural Component Spray)**

Premix **Component A** to a uniform consistency with a drill and paddle mixer. Add the correct amount of **Component B** to **Protecto-Coat 1130 Component A** and mix thoroughly until a uniform color and consistency is achieved. Apply at 15-20 mils WFT per coat using a brush or roller.

Brush or roller applications may require additional coats to meet the specified dry film thickness.

**PROTECTO-COAT 1130 CURE CYCLE**

TEMPERATURE	RECOAT TIME	
	MIN	MAX
50°F	20 hrs.	120 hrs.
75°F	4 hrs.	96 hrs.
90°F	2 hrs.	72 hrs.

*This material develops high exotherm when in mass.*



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COATING, 30-40 MILS (1 mm)**

### *Catalyzed materials must never be left unattended!*

Do not attempt to store mixed material. Residual material should be properly disposed of at the end of each work period.

If these recoat times are exceeded, consult a Dudick representative. Sanding or abrasive blasting may be required before the next coat.

Recoat times are dramatically reduced when the coating is exposed to direct sunlight.

**Application of Protecto-Coat 1130** in direct sunlight may lead to blistering, pinholes, or wrinkling due to outgassing of air in the concrete and high substrate temperatures. Double priming, shading, or evening application may be required. Consult a Dudick representative.

### TESTING

If spark testing is required, use a DC spark/holiday tester set to the appropriate voltage to achieve a minimum 100 volts per mil of applied coating. An AC tester can be used, but is not as effective as a DC tester. Mark and repair all pinholes using **Protecto-Coat 1130**. Retest only the repairs.

### CLEANING

Use **S-10 Cleaning Solvent** to clean tools and equipment.

### SHIPPING

Refer to Material Safety Data Sheets.

### STORAGE

**Warning:** All Dudick products classified by DOT with either white, yellow or red labels must not be mixed or stored together as an explosive reaction may occur.

All products should be stored in a cool, dry area, away from open flames, sparks or other hazards. Exposure to direct sunlight or excessive heat may cause premature gelling and reduce working time and shelf life.

When properly stored in their original, unopened containers at 50°F-75°F, **Primer** and **Protecto-Coat 1130** will have a six-month shelf life. Keep all containers tightly sealed when not in use. Conductive Primers will have a

thirty day shelf life. Storage in direct sunlight or excessive heat will reduce working time and shelf life.

### SAFETY

**M.S.D.S - Material Safety Data Sheets must always be read before using products.** **Protecto-Coat 1130** systems are intended for application by experienced, professional personnel. Dudick, Inc. can supply supervision to help determine that the surface has been properly prepared, the ingredients correctly mixed, and the materials properly and safely applied.

If **Protecto-Coat 1130** materials are to be applied by your own personnel or by a third party contractor, please be sure that they are aware of the following safety precautions:

- Exposure to resins and hardeners through direct skin contact and/or inhalation may cause severe dermatitis reactions in some people. Cleanliness of the skin and clothing is critical and must be of paramount concern.
- Fumes are flammable and heavier than air. Proper ventilation should be maintained to minimize breathing of concentrated fumes.
- Suitable respirators should be used during application.

- Safety glasses, gloves and suitable protective clothing must be worn at all times during application.
- If contact with hardeners occurs, remove any clothing involved and flush the skin with flowing water. Discard the clothing. Do not attempt to wash and reuse it. **Protecto-Coat 1130** liquid can be removed with S-10 Cleaning Solvent, MEK, or lacquer thinner.
- Keep open flames and sparks away from the area where materials are being mixed and applied.
- If a rash occurs, remove the individual from the work area and seek a physician's care for dermatitis.
- In case of eye contact, flush with water for at least 15 minutes and consult a physician.
- If swallowed, do not induce vomiting; call a physician immediately.

**NOTE:** Dudick, Inc. ("Dudick") warrants all goods of its manufacture to be as represented in its catalogs and that the manufacture of its products by its employees or sub-contractors shall be performed in a workmanlike manner. Dudick's sole obligation under this warranty shall be to replace any material which its examination shall disclose to be defective. Dudick makes no warranty concerning the suitability of its product for application to any surface, it being understood that the goods have been selected and the application ordered by the Purchaser. DUDICK, INC. MAKES NO WARRANTY, EXPRESS OR IMPLIED, THAT THE GOODS SHALL BE MERCHANTABLE OR THAT THE GOODS ARE FIT FOR ANY PARTICULAR PURPOSE. THE WARRANTY OF REPAIR OR REPLACEMENT SET FORTH HEREIN IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES ARISING BY LAW OR OTHERWISE; AND DUDICK INC. SHALL NOT BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES, INCLUDING BUT NOT LIMITED TO LOST PROFITS, DOWN TIME, DAMAGES TO PROPERTY OF THE PURCHASER OR OTHER PERSONS, OR DAMAGES FOR WHICH THE PURCHASER MAY BE LIABLE TO OTHER PERSONS, WHETHER OR NOT OCCASIONED BY DUDICK'S NEGLIGENCE. This warranty shall not be extended, altered or varied except by written instrument signed by Dudick and Purchaser.

5/30/18