



Dudick inc.

Corporate Offices
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**PROTECTO-COAT EPG
EPOXY PHENOLIC GLASS FLAKE COATING**

FEATURES

Self Priming

RECOMMENDED APPLICATIONS

- Interior tank lining
- Acid areas for maximum protection from fumes, splash to spillage
- Clarifiers and treatment tanks
- Under insulation on carbon and austenitic stainless steel
- For high abrasion areas

CHEMICAL RESISTANCE

Resistance Properties:

Sour and Sweet Crude – Excellent
Waste Water/Salt Water – Excellent
MTBE – Excellent
Weak Acids/Weak Caustics (PH 2.5-11) – Excellent
Most aliphatic and aromatic compounds - Excellent

Contact Dudick Inc. for a complete specification and recommendation.

**TEMPERATURE LIMITS
(METAL APPLICATIONS)**

MAXIMUM SERVICE TEMPERATURE

400°F (204°C) in continuous and intermittent (dry). For immersion, contact Dudick Inc. for specific recommendations.

COLORS:

Desert Sand
Off-white
Grey

PHYSICAL PROPERTIES

Volume Solids	65%
VOC-Thinned 5%	2.95 lbs./gal.
VOC-Un-thinned	2.70 lbs./gal.

SPECIFICATIONS

Protecto-Coat EPG shall be an amine cured glass flake filled epoxy phenolic coating applied in two 6-7 mil coats as manufactured by Dudick, Inc. Materials can be applied by brush, roller, or spray in accordance with the manufacturer’s recommended practices.

THE PROTECTO-COAT EPG SYSTEM

Protecto-Coat EPG is a self-priming amine-cured, epoxy phenolic, glass flake filled coating designed for use in highly corrosive environments where abrasion and chemical resistance is required. **Protecto-Coat EPG** also exhibits excellent heat resistance.

Primer 67 is the recommended holding primer designed to prevent abrasive blasted steel from developing rust bloom prior to the application of the **Protecto-Coat EPG**. Concrete can be primed to aid in the “wetting out” required for good bonding and retarding out-gassing.

***Refer to Primer 67 Bulletin**

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.

Basecoat/Topcoat: The unique hybrid binder in **Protecto-Coat EPG** provides high film integrity, and excellent chemical resistance required for prolonged substrate protection.

For heavy spillage or total immersion areas, two 6-7 mil finished coats must be applied to achieve a DFT of 12-15 mils.

ESTIMATING QUANTITIES AND ORDER BILL OF MATERIAL

APPROXIMATE SQUARE FEET PER GALLON	
Protecto-Coat EPG	
348 ft. ² /gallon	@ 3 mils DFT (5% thinning)
208 ft. ² /gallon	@ 5 mils DFT (5% thinning)
148 ft. ² /gallon	@ 7 mils DFT (5% thinning)

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

SUGGESTED FILM BUILD (DFT)

- 6-7 mils DFT/coat (10-12 mils wet) via airless spray applied in multiple wet passes.
- 4-5 mils DFT/coat (6-8 mils wet) via conventional spray applied in multiple wet passes.
- 3-4 mils DFT/coat (5-6 mils wet) roller applied in multiple wet passes.

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 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 minimum 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 procedure.

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

PRIMING

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

APPLICATION SPECIFICATIONS

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

Relative humidity must not exceed 85%.

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

PROTECTO-COAT EPG MIX RATIO (BY VOLUME)

BASE	1 gallon
ACTIVATOR	6 fl. oz.

ACTIVATION

Mechanically mix colored base until a uniform color is achieved. Slowly add the activator. Mix for 3-5 minutes. Allow a 5-10 minute induction time before applying. Activate complete kits only. Do not short mix. For maximum working time, reduce 5% with **S-12 Thinner**. No other thinner is recommended without approval from Dudick’s technical department.

PACKAGING

Available in 5 gallon units.

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



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POT LIFE

2 hours @ 77°F with normal recommended thinner.

1 hour @ 90°F with normal recommended thinner.

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

COMPATABILITY WITH OTHER COATINGS

Protecto-Coat EPG may be used direct to metal and can be applied over itself within 3 days. Higher temperatures will shorten the recoat window. **Protecto-Coat EPG** may also be applied over **Primer 67** when a holding primer is needed. Do not apply over other coatings. Please contact Dudick Inc. for specific information.

APPLICATION SPECIFICATIONS

- Airless spray application is the preferred method of applying **Protecto-Coat EPG**.
- Can be applied by brush, roll or spray

BRUSH & ROLL

- Use a high quality brush
- Roll: ¼” lambs wool or synthetic roller cover with phenolic cores such as One Coater®. Keep roller wet. Roll in one direction.

Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

AIRLESS SPRAY

Pump: Capability to product 3000 psi (e.g. Graco Bulldog, EH333 or GM5000)
High Pressure Filter: 60 mesh
Fluid Hose: 3/8” x 100’ max. (Note: If more than 100’, use 45:1 King and to ½” x 100’ plus 3/8” x 50’)
Airless gun: Graco 207945, 208663, 220-954 or 220-730
Tips: .017” - .021”
Minimum pressure to avoid fingering: 3000 PSI
****See Additional Comments #2**

AIR SPRAY

	Binks	DeVilbiss	Graco
Spray Gun	18 or 62	JGA502 or MBC510E	800 or 900
Fluid Nozzle	66 or 67		04 or 086
Air Cap	66 or 67PB	78, 704, 764	02, 03 or 952

ADDITIONAL COMMENTS

1. For spray, add 1 qt. S-12 Thinner per 5 gallon kit
2. Bar at back of tip will cause packing of glass flake.
3. **Protecto-Coat EPG, if topcoated, must be done within 3 days.**

PROTECTO-COAT EPG CURE CYCLE

Cure Times (Hours @ 4-5 mils DFT-77°F, 25°C and 50% R.H.)

To Touch	4 hours
To Recoat	6 hours minimum / 3 days maximum
Full Cure	7 days

Force Curing Schedule

140°F	10 – 14 hours
160°F	8 – 10 hours
180°F	4 – 6 hours
200°F	3 – 4 hours

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.

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 pin holes, using **Protecto-Coat EPG**. Retest only the repairs.

CLEANING

Use **S-12 Thinner** to clean equipment.

SHIPPING

Refer to Material Safety Data Sheets.

STORAGE

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

All products should be stored in a cool, dry area, away from open flames, sparks, or other hazards.

When properly stored in their original, unopened containers at 50°F-75°F, **Protecto-Coat EPG** has a six month 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 EPG 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 EPG** 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 EPG** liquid can be removed with **S-12 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;



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5/21/18