

SELECTION & SPECIFICATION DATA

Generic Type	Flake-filled, high performance epoxy coating
Description	A 100% solids, low temperature cure, flake-filled epoxy resin to protect concrete and metal substrates. The epoxy binder and overlapping flake fillers provide the low permeability, high film integrity, and excellent chemical resistance required for prolonged substrate protection.
Features	<ul style="list-style-type: none"> • Meets all VOC Requirements • 100% Solids • Can be seeded with Sand or Aluminum Oxide for Anti-Skid.
Typical Uses	<ul style="list-style-type: none"> • Storage Tanks • Secondary Containment • Pump Housings • Structural Steel • Floors (Spillage)
Color	Standard Color Chart available upon request.
Primer	<p>For maximum performance, all metal surfaces should be primed with Primer 67 Series, but primer may not be needed for mild, non-immersion service.</p> <p>Concrete must be primed to aid in the “wetting out” required for good bonding. Use Primer 67 series or other primer recommended by Dudick or Carboline technical service. Primer 67C is designed for applications on concrete where spark testing is required or specified.</p>
Dry Film Thickness	12 - 30 mils (305 - 762 microns) per coat
Solids Content	By Volume 100%
Theoretical Coverage Rate	<p>1604 ft²/gal at 1.0 mils (39.4 m²/l at 25 microns)</p> <p>134 ft²/gal at 12.0 mils (3.3 m²/l at 300 microns)</p> <p>53 ft²/gal at 30.0 mils (1.3 m²/l at 750 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Values	As Supplied : 0 g/L
Dry Temp. Resistance	<p>Continuous: 250°F (121°C)</p> <p>Non-Continuous: 300°F (149°C)</p>
Chemical Resistance	<ul style="list-style-type: none"> • Mineral Oils • Salt & Brine Solutions • Sodium Hydroxide • Sweet & Sour Crude

Protecto-Coat 325HB

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Concrete | Concrete must be prepared mechanically 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 or greater from the International Concrete Repair Institute with pea gravel exposed. Additional surface preparation will be required if 40-60 grit texture with exposed pea gravel is not achieved and the surface laitance not completely removed with the first mechanical preparation procedure. The prepared surface shall have a tensile strength of 250 PSI per ASTM D7234.

All concrete substrates must be checked for moisture prior to product application using the Plastic Sheet Test, ASTM D4263.

Metal | Metal surfaces must be abrasive blasted to an appropriate finish.
Immersion and heavy spillage service: White Metal, SSPC SP 5/NACE NO.1, minimum 3.0 mil profile.
Heavy non-immersion service (i.e. fumes and spillage): Near white, SSPC SP 10/NACE No. 2, minimum 2.0 mil profile.
Atmospheric service: Commercial SSPC SP 6/NACE No.3, minimum 2.0 mil profile.

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	Results
Compressive Strength (ASTM C579)	9,000-9,500 PSI (62-65.5 MPa)
Flexural Strength (ASTM C580)	5,000-5,200 PSI (34.5-36 MPa)
Shore D Hardness (ASTM D2240)	75-80
Taber Abrasion (ASTM D4060)	90 mg
Tensile Strength (ASTM C307)	2,500-3,000 PSI (17-20.7 MPa)

MIXING & THINNING

Mixing | Add the correct amount of Part B to Part A and mix thoroughly until a uniform color is achieved.

Ratio | 2:1 (A:B by volume)

Pot Life | 75 minutes @ 50°F (10°C)
40 minutes @ 75°F (24°C)
25 minutes @ 90°F (32°F)

Pot life of the mixed material 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 above.

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Airless Spray	Pump Ratio: 45:1 or greater, capable of at least 1 GPM. Hopper or siphon feed is preferred. Filters: Ensure all filters are removed. Material Hose: 1/2" I.D. (min.), 4500 psi or greater rated. Tip Size: 0.25-0.31" Output PSI: 3000-3500 psi (min.) Gun: Airless gun rated for at least 4500 psi. Filter-free or front-fed gun is preferred. PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Brush or roller application may require additional coats to meet the specified dry film thickness.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	60°F (16°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	80°F (27°C)	125°F (52°C)	125°F (52°C)	90%

Substrate temperature must be 5°F (3°C) above the dew point.

CURING SCHEDULE

Surface Temp.	Minimum Recoat Time	Cure Time	Maximum Recoat Time
50°F (10°C)	7 Hours	96 Hours	120 Hours
75°F (24°C)	5 Hours	24 Hours	72 Hours
90°F (32°C)	3 Hours	20 Hours	3 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. Application 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

CLEANUP & SAFETY

Cleanup	Use S-10 Cleaning Solvent to clean tools and equipment.
Safety	Read and follow all caution statements on this product data sheet and on the SDS. Employ normal safety precautions. Keep container closed when not in use.
Ventilation	Ventilation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. Use MSHA/NIOSH approved air respirators as needed.
Caution	Fire and explosion hazards: This product contains less than 1% volatile components, however, vapors are heavier than air and can travel long distances, ignite and flash back. Eliminate all Ignitions sources. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

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PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Packaging	1 Gallon Kits: Part A: 0.67 Gallons (in a 1 gal pail) Part B: 0.33 Gallons (in a 1 gal pail) 5 Gallon Kits: Part A: 3.35 Gallons (in a 5 gal pail) Part B: 1.65 Gallons (in a 3.5 gal pail)
Shelf Life	12 months @ 50°F-75°F (10°C-24°C) When properly stored in their original, unopened containers. Storage in direct sunlight or excessive heat will reduce working time and shelf life.
Storage	Warning: All Dudick products classified with DOT labels as either 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.
Shipping Weight (Approximate)	1 gallon kits: 15.7 lbs (7.1 kg) 5 gallon kits: 59.3 lbs (26.9 kg)

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.