



## PRODUCT DATA SHEET

# WEATHERSKIN: MARINE GRADE

### ONE COAT MARINE EPOXY

#### General Description

Weatherskin's One Coat Marine Epoxy is a two component, phenalkamine epoxy designed for applications where excellent corrosion, moisture and water barrier properties are required. Weatherskin's One Coat Marine Epoxy is high solids, high build and will cure at temperatures as low as 10°F in the presence of moisture. This product is especially suitable for marine and water submerged applications. Typical uses include, but aren't limited to: Barges, drilling rigs, pools, truck bays, car washes, public restrooms, locker rooms, non-potable tank interiors, heavy duty structural, piping and any substrates requiring a high wash cycle finish.





## **Directions for Use:**

### **1). SURFACE PREPARATION**

Surface must be clean, dry, sound and free of dirt, dust, grease, oils, residues, waxes, water, foreign particles, and any other contaminants that may interfere with coating adhesion and intimate contact with substrate. Steel surface preparation should meet SSPC-SP6/NACE 3 commercial blast cleaning. Metal surface must be 5 degrees above the dew point temperature.

### **2). EQUIPMENT PREPARATION**

Weatherskin: Marine Grade is designed to be applied by spray, brush, roll or squeegee.

- Spraying - Airless spraying at 3500-4500 psi with 0.019-0.027 tips is recommended. 60:1 pumps are ideal, but not necessary. High pressure rated tips, guards, guns and hoses are necessary. A pressure gauge or regulator affixed between gun and hose is also helpful in controlling your spray.
- Rolling – Low nap thickness, 5-10 mm, double woven microfiber roller pads are recommended, to achieve as smooth of finish as possible.

### **3). PRODUCT PREPARATION**

- Agitate each component thoroughly before combining. This will properly disperse the polymers and catalyst.
- Mix 3 parts RP One Coat Marine Part A by volume with 1 part B Hardener. Ensure that no unmixed resin is left on the side of the pail. If unmixed resin droplets are present on the surface they will not cure.
- Once mixed, pot life is 6 hours at 75 degrees and significantly reduced at elevated temperatures. Pot life is extended with reduction.
- If using an electric or gas-powered spray machine that is not capable of the minimum 3500 psi, then product reduction is required. 5-10% Acetone (approx. 1 - 1.5 quarts / 4-gallon kit) may be used after both components have been mixed together. If reducing or thinning is required, please contact your Weatherskin technical service representative for instructions.

### **4). PRODUCT APPLICATION**

- When spraying, ensure you are the correct distance from the surface you are spraying to achieve the appropriate fan size determined by your spray tip. Standing too close will cause high, uneven product buildup, and can cause sagging. Standing too far away will cause overspray and thin buildup.
- Ensure the corners are not sprayed twice in the same coat, to avoid sagging.
- For rough or uneven surfaces, like OSB, corrugated metal, or pitted concrete, a crosshatch spraying technique (sprayed both vertically and horizontally) is recommended to ensure all faces of the surface are evenly coated.
- If back-rolling is required, do not exceed more than 5-10 minutes since first applied to do so, or the product will have become tacky and will not roll evenly.

### **5). CLEAN UP**

Clean all equipment immediately after use with MEK or acetone. Use clean solvent only. In case of spill, absorb and dispose of in accordance with local, State, and/or Federal regulations.



## TYPICAL MIXED PROPERTIES

COLOR:	BLACK, GRAY, WHITE & RED
TYPE:	EPOXY/AMINE
RECOMMENDED PUMP:	60:1 AIRLESS - GRAYCO OR TITAN
RECOMMENDED SETUP	HIGH PRESSURE GUN, HOSE, GUARD & TIP
RECOMMENDED TIP SIZE	0.19 - 0.27
RECOMMENDED SOLVENT	ACETONE
RECOMMENDED DILUTION	5%-10% IF NECESSARY
VISCOSITY (25°C):	105 -115 KU'S
SPECIFIC GRAVITY (25°C):	1.15-1.25
DENSITY (25°C):	9.58-10.4 LBS/GAL
% SOLIDS (BY VOLUME):	80-84%
SOLIDS (BY WEIGHT):	86-88%
VOC:	.01 LBS/GAL
VOC (LESS WATER/EXEMPT):	.01 LBS/GAL
FLASH POINT:	16°F
GLOSS:	80°
RECOMMENDED DFT:	10-20 MILS (250-500 UM)
MAXIMUM DFT:	30 MILS (750 UM)
COVERAGE / GALLON:	1323 FT2 @ 1.0 MIL
COVERAGE (FULL SYSTEM)	APPROX: 65 - 90 SQ. FT / GALLON
DRY @ 75 DEGREES F:	1-2 HRS TOUCH, 3-4 HRS HANDLE, 8 HRS HARD
POT LIFE @ 75°F:	6 HRS
SERVICE TEMPERATURE:	-40°F TO 350°F
MIX RATIO:	3:1
HAPS:	<0.006 LBS/GAL
PENCIL HARDNESS:	3H-4H - ASTM D3363
IMPACT RESISTANCE:	60 IN LBS - ASTM D2794
ADHESION -PULL OFF:	1500 PSI - ASTM D4541 TBD - ASTM D4541
ABRASION - TABER:	65MG LOSS - ASTM D4060 1000CYCLES/1000GM/CS17

*Typical properties given do not constitute a supply specification.*



### **Packaging/Storage**

WS: Marine Grade is available in 1-gallon kits, 4-gallon kits and 55-gallon steel drums. For additional packaging options, please contact your local Weatherskin representative.

### **Safety, Health and Environmental Info:**

Before handling or using this product please refer to the Safety Data Sheet for complete health, safety and environmental information. Dispose of waste in accordance with local, state and federal regulations.

### **For professional use only not for residential use keep out of reach of children**

Avoid contact with skin and use good ventilation. Wear chemically resistant gloves (nitrile are recommended) and chemical safety glasses. If skin contact is made, wash immediately with soap and water. Do not use solvents to clean skin.

#### Disclaimer

This information is disclosed without warranty, representation, inducement, or license of any kind and is believed to be as accurate according to Weatherskin Corporation's knowledge and other primary sources. Weatherskin Corporation does not assume any legal responsibility for use of reliance on same. Customers are encouraged to conduct their own tests.

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