

Coating Description: RCT 100 Liner – Epoxy Modified Novolac Coating

Application Description: Tank Interiors

Product Description & Suggested Uses:

RCT 100 Liner is a high-build Novolac Epoxy designed for industrial interior direct-to-metal (DTM) applications requiring excellent corrosion, chemical, and heat resistance. Sufficient film build can be achieved with a single coat application. Typical uses include tank car liners, frac tank liners, storage tank interiors, and structural steel.

Surface Preparation:

- In accordance with SSPC-SP1, remove all oil and grease from the surface.
- In accordance with NACE No.2/SSPC-SP10, abrasive blast to a minimum near white to obtain a 2.0 to 4.0 mil blast profile.
- Welds must be smooth and continuous without projections or irregularities. All weld flux, spatter, slag and bb's must be removed. Undercuts or pinholes will only be filled with weld metal, not caulking material.
- Any laminations or steel surface defects must be removed by grinding
- Surface temperature of the tank should be 50°F minimum. Do not paint unless metal surface is at least 5°F above the dew point.

Mixing and Thinning/Reducing Instructions:

- All containers should be thoroughly mixed and checked for uniformity.
- Mix 1 part RCT 100 Liner Component A to 1 part Hardener Component B, allow a 10 minute induction time. When coating temperatures are below 60°F, allow an extra 10 minutes sweat-in time after mixing to prevent possible film defects.
- For spray applications, thin from 0% to 20% with RCT recommended reducer.
 - o Manual Mixing - Reducer should only be added after components A & B are mixed to assure proper mix ratio and performance.
 - o Reducer in plural component equipment should be added equally to components A & B before mixing.
- Use of reducers other than those approved by RCT may affect product performance and void product warranty.
- When using inline heaters or Plural Component Equipment, use a static mixer and avoid thinning.

- All spray equipment must be thoroughly cleaned. Paint line should be free from old paint and other contaminants.

Equipment:

- Spray equipment from Graco, Devilbiss, or Binks recommended
- Dew point, humidity, and temperature measuring equipment
- Broom with natural bristles and vacuum for blast residue removal
- Surface profile, dry & wet film thickness, and low voltage holiday detecting equipment
- Standards from NACE & SSPC for surface preparation, lining, and inspection
- Minimum specifications for airless spray equipment:

Pump Ratio	45 to 1 min
Air Pressure Output	3000 psi min
GPM Output	3.0 gal/min
Hose	3/8" ID min
Tip Size	.017" - .027"
Heater	200°F min (if applicable)

Application:

Coating must be applied before any visible rusting occurs. Stripe coat all interior weld seams thoroughly with reduced (10-20%) RCT 100 Liner.

- Spray tanks to a wet film thickness of 12-16 mils (10-12 mils dry), do not exceed 22 mils wet (18 mils dry). Measure film thickness in accordance with SSPC-PA2. A second coat is not required but can be applied within 72 hours.
- Continuous ventilation is recommended and care must be taken to keep dust and other contaminants from entering the tank.
- Pot Life is 2 hours at 75°F, shorter at higher temperatures.

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Dry Times and Force Curing:

Prior to coating inspection, sufficient dry is required. Circulating clean dry air can help the cure. If necessary, heat can be used to speed the cure process.

Dry to Touch	3-4 hours @ 75°F
Dry to Handle	6-7 hours @ 75°F

If tank is to be force cured at an elevated temperature, allow for a 1-hour minimum flash-off @ 75°F with proper ventilation. Ramp the temperature at a rate of 1-2°F per minute up to 160-180°F. Hold for an additional 1.5 hours.

In Service Times:

- 7 days @ 50°F
- 4 days @ 75°F
- 3 days @ 90°F
- 24 hours after force cured

Blistering may develop:

- With insufficient flash-off time before a force-dry.
- If the dry film thickness is higher than recommended prior to a force-dry.
- If the ramp-up in temperature is too rapid.

Discoloration may occur if exposed to moisture or condensation prior to sufficient cure.

Inspection & Touch-up Procedure:

- After the lining has dried, but before force curing, inspect for holidays, overspray, pinholes, runs or sags.
 - o Overspray can be removed by and recoated by brush or spraying
 - o Runs and sags can be removed by sanding or scraping. Care should be taken to not damage the intact lining and repaired sections can be re-sprayed or brushed.
 - o Holidays can be identified using a 67.5 volt tester. Any defects shall be repaired.
- Dry film thickness should be taken with a type 1 or 2 gauge.

- o Low film thickness may be corrected by re-spraying or brush, depending on the size of the area and location.
- o Excessive film thickness may be corrected by sanding or blasting, depending on the size of the area. The prepared area may be corrected by brushing or re-spraying.

- Re-inspect the coating film after any corrections have been made to assure a continuous film has been applied at the recommended thickness.

Clean-up:

Methyl Ethyl Ketone (MEK) solvent may be used for cleaning up. If not flushed out, batch mixed material will set up in the lines and equipment. With plural component equipment, be sure to flush from the mixing head through the delivery hose and guns.

Storage & Shelf Life:

- Containers must be closed tightly
- Do not store at temperatures above 100°F
- Do not store outside
- Rotate stock
- Do not use shelf life expired materials
- Shelf Life is one year from date of manufacture when properly stored.

Packaging:

RCT 100 liner is available in 1-gallon, 5-gallon and 55-gallon steel drums. For additional packaging options, please contact your local Rapid Cure Technologies representative.

Safety Information:

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. Refer to Material Safety Data Sheet for further safety and handling information.

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NOT FOR RESIDENTIAL USE
KEEP OUT OF REACH OF CHILDREN