



# FX-421

## Hydro-Ester Coal Tar Epoxy Coating

### DESCRIPTION:

**FX-421 Hydro-Ester Coal Tar Epoxy Coating** is a two component, 100% solids coating, especially formulated for high build applications. **FX-421** produces a tough, flexible, chemical and impact resistant film. **FX-421** is formulated to be easily spray applied, as thick as 40 mils in one coat. **FX-421** provides excellent resistance to aggressive water, acids, and caustics.

### ADVANTAGES:

- Suitable for intermittent exposure to 300°F
- Excellent chemical resistance
- Excellent adhesion
- Convenient 2A to 3B mix ratio by volume
- High build to 40 mils per coat
- 100% solids, 0.0 lbs. VOC
- Sprayable
- Tough and flexible
- Moisture insensitive
- Low temperature curing

### PHYSICAL PROPERTIES:

**FX-421 Hydro-Ester Coal Tar Epoxy Coating** meets the performance criteria for the American Water Works Association Specification C-210.

Since the **FX-421 Hydro-Ester Coal Tar Epoxy Coating** is 100% solids, it meets the requirements of the U.S. Environmental Protection Agency's V.O.C. Emission.

Color	Black
Percentage Solids	100%
Pot Life	1 hour @ 75°F
Cure Times	24 hrs. @ 75°F for light service
7 days full cure	

Cure may be accelerated by heat curing @ 140°F for 6-8 hours

Adhesion to Steel	1200 psi
ASTM D 1002	
Adhesion to Concrete	Break in Concrete
ASTM C 882 (substrate)	
Tensile Strength	2200 psi
ASTM D 638	
Compressive Strength	7350 psi
ASTM C 579	
Abrasion Resistance	59.2 mg
ASTM D 4060	
Shrinkage	0%
ASTM C 883	
Pull-Off Test	Cohesion Failure
ASTM D 4541-85	

### SURFACE PREPARATION:

- All surfaces must be clean and structurally sound, free of dirt, grease, oil, paint, etc.
- Remove contamination with abrasive blasting, water blasting or wire brush. Make sure all dust is removed after abrasives. Metal should be blasted to SSPC SP-6, 2 to 4 mils profile before coating. Concrete should be blasted or acid etched before coating. Remove all acid with water before coating.

### MIXING:

Mix **FX-421** at 2A to 3B by volume. Mix well with low speed drill (300 rpm) and **FX-Mixing Paddle**. Stir until uniform, smooth material is seen. Mix minimum of three (3) minutes. Scrape sides and bottom frequently. Avoid entrapping air in mixture. For best results, when spraying, stain material through a 60 mesh screen prior to spraying.

### APPLICATION:

Apply by brush or spray. Pot Life is 30 minutes @ 100°F. If heated and sprayed, mix only what you can apply within 30 minutes. Spraying this material requires specialized equipment. Both "A" and "B" Components must be heated to 100°F before spraying. A 45:1 airless spray pump with standard airless spray gun through a .031 to .035 reversible tip is needed. Plural component guns may be used with this product. Higher temperatures and larger masses shorten pot life.

### PACKAGING:

5 Gallon Unit = 3 gallons "B" in a 6 gallon pail and 2 gallons "A" in a 2 gallon pail.

### SHELF LIFE:

2 years

### COVERAGE:

80 square feet per gallon @ 20 mils.

### LIMITATIONS:

Do not use below 40°F. Store material under dry conditions. For best results before spraying, rolling, or applying by brush, condition material to 70°F or higher.

(continued on back)

**CAUTION:**

“A” Component – WARNING! Contains epoxy resin. May cause skin irritation or allergic response. Avoid contact with skin. Avoid breathing vapor when heated. In case of skin contact, wash thoroughly with soap and water. In case of ingestion, do not induce vomiting.

“B” Component — DANGER! Causes severe burns. Contains alkaline amines. Strong sensitizer. Avoid skin contact. Avoid breathing vapor when heated. Wear protective gloves, goggles and barrier creams. In case of skin contact, wash thoroughly with soap and water. In case of ingestion, induce vomiting. If irritation persists, seek medical attention.