



FX-480

Epoxy Protective Coating

DESCRIPTION:

FX-480 Epoxy Protective Coating is a two-component, 1A:1B high solids epoxy coating. When cured, **FX-480** provides a tough finish with good flexibility and excellent abrasion resistance. It protects concrete, steel, or wood against attack by salts including sea water, acids and alkalines and some solvents. **FX-480** offers excellent corrosion resistance and very good cathodic disbondment resistance. **FX-480** can be applied over a wide temperature range and can be heat cured to give high temperature resistance up to 240°. **FX-480** complies with all current VOC regulations. **FX-480** may be applied in temperatures ranging from 40°–110°F, although curing time will vary. **FX-480**'s 1:1 ratio makes it very easy to mix and apply.

PHYSICAL PROPERTIES:

Color	White, Gray, Black
Weight per gallon	11.5 lbs.
Viscosity	5,000 cps
Pot Life at 72° F	4 hrs

DRYING SCHEDULE	40°F	72°F	90°F
Tack Free Time	12 hrs	4 hrs	1 hr
Dry Hard	24 hrs	8 hrs	2 hrs
<i>Substrate temp may affect dry time</i>			
Minimum Recoat Time	18 hrs	6 hrs	90 mins
Maximum Recoat Time	10 days	10 days	10 days

Closed cup flash point	
Part A	80° F (27° C)
Part B	90° F (32° C)
Solids by weight	80%
Solids by Volume	75%
VOC Content	1.11 lb gallon 133 grams per liter
Sag Resistance	20 mils
Flexibility, TTP-115 over 1/2 inch mandrel, no peeling or cracking	
Tensile Strength ASTM D 638	1400 psi
Adhesion to Steel ASTM D 4541	3500 psi
Abrasion Resistance ASTM D 4060	61 mg loss CS-17, 1000 gram load
Impact Resistance ASTM D 2794	68 in/lbs
Moisture Permeability ASTM E 96	0.16 perms

Excellent chemical resistance to alkalis, salts, oils, greases, detergents in splash and spill operations.

SURFACE PREPARATION:

On Steel – Prepare in accordance with Steel Structures Painting Council Surface Preparation SSPC-SP10 "Near-White Metal Blast Cleaning". Blast profile should be 2-3 mils in depth with sharp jagged nature. Previously painted surfaces should have paint removed and be treated as if new steel.

On Concrete – Concrete surfaces should be clean, sound and dry. Abrasive blast to remove dirt, curing compounds, existing coatings or laitance and provide a profile to the concrete.

MIXING:

FX-480 has a convenient 1:1 mixing ratio by volume and a long pot life to simplify mixing and application. Combine (1) one part by volume of Component "A" with (1) one part by volume of Component "B". Mix for a minimum of (3) minutes with a low speed electric drill and an FX-Mixing Paddle. **No induction time is needed** before applying. Thinning is not normally needed, however in colder temperatures up to 5% by volume MEK may be added to the mixed epoxy, depending on local VOC and air quality regulations.

APPLICATION:

FX-480 Epoxy Protective Coating may be applied by brush, roller or spray. All spray equipment must employ traps to prevent water and oil from contaminating coating. **FX-480 Epoxy Protective Coating** may be applied as high as 20 mils without sagging. Suggested spray equipment is a 45:1 minimum heavy duty airless spray pump with 3600 minimum pressure.

COVERAGE:

Typical application is approximately 200 sq. ft. per gallon. Typical WFT will be 8–10 mils wet to achieve 6–8 mils DFT. Two coats are recommended.

PACKAGING:

2 gallon and 10 gallon units.

LIMITATIONS:

Shelf Life - Unmixed 2 years in closed container. Do not apply below 40° F. Epoxies exposed to ultraviolet light will quickly lose sheen and show signs of chalking, however product performance will not be affected.

(continued on back)

CAUTION:

"A" Component contains epoxy resin. May cause skin sensitization or other allergic responses. Use with good ventilation, particularly if material is heated or sprayed. Prevent all contact with skin or eyes. Wear protective clothing, goggles, gloves and/or barrier creams. Keep container closed when not in use. Wash thoroughly after handling.

Flammable DANGER! "B" Component contains alkaline amines; strong sensitizer. May cause skin sensitization or other allergic responses. Use with good ventilation, particularly if material is heated or sprayed. Prevent all contact with skin or eyes. Wear protective clothing, goggles, gloves and/or barrier creams. Keep container closed when not in use. Wash thoroughly after handling.

FIRST AID:

In case of skin contact, immediately wash with soap and water. In case of eye contact, flush eyes with copious amounts of water for at least fifteen (15) minutes. Remove contaminated clothing, shoes. If irritation persists, seek medical attention. Wash clothing before reuse.