



HPC/Industrial Maintenance

POLYCLUTCH® EN75

GENERAL DESCRIPTION

PPG POLYCLUTCH® EN75 chemical resistant tank lining system is formulated to meet the demanding situations required of tank lining coatings. The product is a high solids two- part system that provides outstanding chemical resistance on a myriad of chemicals and solvents. Chemicals such as gasoline, methanol; methyl isobutyl ketone and sodium hydroxide do not affect the coating over a broad range of temperatures and pressures. The use of this coating is ideal for lining the interior surfaces of: industrial storage tanks; process chemical tanks; pipelines and rail cars. POLYCLUTCH EN75 is also recommended for areas that are highly corrosive.

RECOMMENDED USES

This product can be used to line the interior of industrial storage, process chemical tanks and pipelines subjected to certain chemicals. Substrates to be coated include:

Ferrous Metal
Galvanized Steel
Concrete

FEATURES AND BENEFITS

Features	Benefits
No baking required for curing	Air dry: Additional equipment unnecessary for drying
High Volume Solids	2 coat application
Chemical and Solvent resistance	Can be used on many different substrates

PERFORMANCE DATA

Property	Test Method	Results
Adhesion X-Cut	ASTM D3359	5A Excellent
Pencil Hardness	ASTM D3363	6H
Humidity Resistance	ASTM D2247	Excellent
Impact Resistance	ASTM 2794	Good
Chemical Resistance	See Protective Coatings Specialist	

PACKAGING

Component A (95-322 and 95-323) are available in 5-Gallon (18.9 L) containers filled to 4.00 gallons (15.1 L). Component B (95-329) is available in 1-Gallon (3.78 L) containers at 128 ounce fill.

TINTING AND BASE INFORMATION

DO NOT TINT.

PRODUCT DATA

PRODUCT TYPE:	Epoxy Phenolic Novolac
BASE/COLOR:	95-322 White Component A 95-323 Gray Component B 95-329 Curing Agent Component B
GLOSS:	60° minimum
CLEAN UP:	Use PPG thinner 97-725
VOLUME SOLIDS:	72.6% +/- 2.0% (mixed, calculated)*
WEIGHT SOLIDS:	83.9% +/- 2.0% (mixed, calculated)*
VOC AIR DRIED:	1.89 lbs./gal. (227 g/L)*
VOC METHOD 24:	2.50 lbs./gal. (300 g/L)*
COVERAGE @ 1 mil:	1165 sq. ft./gal. 108 sq. m/3.78L
Wet Film Thickness:	6.9 mils to 8.3 mils*
Wet Microns:	175 to 211
Dry Film Thickness:	5.0 mils to 6.0 mils 10 mils minimum to 18 mils maximum
Dry Microns:	127 to 152
Recommended Total Dry Film:	Total dry film should be achieved in 2-3 coats.
WEIGHT/GALLON:	11.8 lbs. (5.35 kg) +/- 0.5 lbs. (1.1 g) (mixed)*
SERVICE TEMPERATURE:	Dry: 350°F (Discolors above 300°F) Immersion: Depends on application
POT LIFE:	2 to 3 hours @ 77°F (25°C) <1.5 hours @ 90°F (32°C) <1 hour @ 100°F (38°C)
DRYING TIME:	Dry time @77°F (25°C); 50% relative humidity. ASTM D5895
To Touch:	3 to 5 hours
To Handle:	5 to 9 hours
To Recoat:	24 hours minimum, 7 days maximum
IN-SERVICE TEMPERATURE:	After 7 days @75°F (24°C) or 2 hours @200°F (93°C)

Drying times listed may vary depending on temperature, humidity, color and air movement.

FLASH POINT: Component A 81°F (27.2°C)
Component B 220°F (104°C)

Product data calculated on product 95-322 mixed with 95-329. Values will vary with color.

GENERAL SURFACE PREPARATION

The service life of the coating is directly related to the surface preparation. The surface to be coated must be dimensionally stable, properly prepared, dry, clean and free of contamination. SSPC-SP2 Hand Tool or SSPC-SP3 Power Tool Cleaning is minimum. For best performance, SSPC-SP6 (NACE #3) Commercial Blast Cleaning is recommended. **WARNING!** If you scrape, sand, or remove old paint, you may release lead dust or fumes. **LEAD IS TOXIC. EXPOSURE TO LEAD DUST OR FUMES CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.** Wear a properly fitted NIOSH-approved respirator and prevent skin contact to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the USEPA National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead. In Canada contact a regional Health Canada office. Follow these instructions to control exposure to other hazardous substances that may be released during surface preparation.

STEEL: Substrate to be coated must be properly prepared, clean, dry, and free of all contamination. SSPC-SP5 (NACE #1) White Metal Blast Cleaning is required for immersion service.

CONCRETE: Allow all concrete, mortar, plaster, etc. to cure for thirty (30) days under normal drying conditions and have a moisture content of less than 8%. Remove all dirt, dust, grime, loose mortar and all other forms of contamination. Concrete which has been treated with curing compounds or hardeners, should be thoroughly abraded.

FERROUS METAL: The minimum surface preparation is Commercial Blast Clean per SSPC-SP6. For immersion service or heat resistance, Near White Metal Blast Clean per SSPC-SP10.

GALVANIZED STEEL: Solvent Clean per SSPC-SP1 to remove grease and oils. If any oxidation (white rust) has formed, sand and remove all forms of contamination. If the galvanized has been passivated or stabilized, the surface must be abraded, i.e. Brush-Off Blast Clean per SSPC-SP7 or chemically treat the surface.

RECOMMENDED PRIMERS

Self priming on steel

LIMITATIONS OF USE

Apply only when air, surface and product temperature are above 50°F (10°C) and surface temperature is at least 5°F (3°C) above the dew point.

MIXING AND APPLICATION INFORMATION

Mix Ratio:

Parts Component A by volume: 4 parts 95-322 or 95-323

Parts Component B by volume: 1 part 95-329

Agitate both components before blending. Add 95-329 to 95-322 (White) or 95-323 (Gray). **No digestion is required.**

Application Equipment: Apply by spray, roller, brush.

Changes in application equipment, pressures and/or tip sizes may be required depending on ambient temperatures and application conditions.

Air Spray: DeVilbiss MBC gun with 704 or 777 air cap with "E" tip and needle, or equivalent equipment. Atomization Pressure: 30-60 psi. Fluid Pressure: Can not specify dependent on numerous factors.

MIXING AND APPLICATION INFORMATION (cont.)

Airless Spray: Equipment capable of maintaining a minimum of 1700 psi at the tip without surge 1500 psi minimum at the tip without surge. Tip size: 0.011" (0.279 mm) to 0.015" (0.388 mm) orifice. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. High pressure injection of coatings into the skin by airless equipment may cause serious injury.

Brush: High quality natural bristle brush

Roller: High quality 3/8" nap roller cover with a solvent resistant core.

Thinning: Thin up to 7% with 97-725 as needed for application. Any solvent addition may be made after the two components have been blended.

Permissible temperatures during application:

Material:	50 to 90°F	10 to 32°C
Ambient:	50 to 90°F	10 to 32°C
Substrate:	50 to 90°F	10 to 32°C

SAFETY

Proper safety procedures should be followed at all times while handling this product. Explosion-proof equipment must be used when coating with these materials in confined areas. Keep containers closed and away from heat, sparks, and flames when not in use. **USE WITH ADEQUATE VENTILATION. KEEP OUT OF REACH OF CHILDREN.** Read all label and Material Safety Data Sheet for important health/safety information prior to use. MSDS are available through our website www.ppghcp.com or by calling 1-800-441-9695.

PPGAF believes the technical data presented is currently accurate; however, no guarantee of accuracy, comprehensiveness, or performance is given or implied. Improvements in coatings technology may cause future technical data to vary from what is in this bulletin. For complete, up-to-date technical information, visit our web site or call 1-800-441-9695.



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