



PorterTuf™ 2000 HB Coal Tar Epoxy

2000

PorterTuf 2000 HB Coal Tar Epoxy is a two component polyamide cured, coal tar epoxy for use on properly prepared steel and masonry surfaces. It offers excellent chemical and abrasion resistance in severe industrial, marine and process environments subject to acids, alkalis and salts.

USED FOR	FEATURES
<ul style="list-style-type: none"> Water/Wastewater Treatment Fresh/ Salt Water Immersion Buried Pipe/ Piling 	<ul style="list-style-type: none"> Chemical Resistance Water/ Salt Resistance Abrasion Resistance

RECOMMENDED SYSTEMS

PorterTuf 2000 HB Coal Tar Epoxy is recommended for a variety of severe chemical and immersion exposures. It is typically used directly to properly prepared steel or masonry. It can also be used in combination with PorterGlaze™ 4300 Epoxy Primer.

SURFACE	TYPICAL SYSTEM
Steel:	Two coats PorterTuf 2000 HB Coal Tar Epoxy
Concrete:	One coat of PorterTuf 2000 HB Coal Tar Epoxy thinned up to 50%, plus one or two coats of PorterTuf 2000 HB Coal Tar Epoxy

LIMITATIONS

Apply in good weather when air and surface temperatures are 50°F (10°C) and rising. Surface temperature must be at least 5°F above the dew point. Dew or rain on product while uncured may cause surface to blush and brown and may impair its cure and intercoat adhesion.

TECHNICAL DATA

Product Type:	Polyamide cured Coal Tar Epoxy		
Base/Color:	Black	PART A PC2032A	PART B PC2046B
Mix ratio:	4:1 (2 component)		
Induction (Sweat-in) period:	15 minutes		
Pot Life (50% RH):	60°F 6 hours	80°F 2 hours	100°F 1 hour
Gloss, 60°:	Semi-Gloss (varies)		
Percent Solids:			
Weight:	81% ± 2%		
Volume:	77% ± 2%		
Weight/Gallon:	10.6 lbs. (mixed)		
Viscosity (mixed):			
Thinner:	STEEL: Thinning is not normally recommended. When necessary, first mix Part B with Part A, stir mechanically for 5 minutes then add no more than 1 quart of Porter T-5 Xylene Thinner (5133) per 5 gallons of mixed material.		
	CONCRETE: Follow the same procedure as above but add up to 50% Porter T-5 Xylene Thinner (5133) to provide good penetration and use as a prime coat. Subsequent coats should not require thinning.		
Clean-Up:	Porter T-5 Xylene Thinner (5133).		
Recommended Film Thickness*:			
Wet:	10.5 mils, per coat		
Dry:	8 mils, per coat		
<i>*Note: Product can be applied up to 21 wet mils (16 dry mils) in a single coat when required if applied during the first two hours of pot life.</i>			
Spread Rate (Theoretical):	154 sq. ft./ gal. @ 8 mils dry		
Dry Times @ 50% R.H. and 77°F:			
To Tack Free:	8 - 10 hours		
To Recoat:	Minimum:	When Firm Maximum: 16 hours	
Full Service:	Immersion:	72 hrs.	
	Abrasion Service:	7-10 days	
<small>(Expect longer dry times at lower temperatures and higher relative humidity.)</small>			
Flash Point:	Part A:	87°F (30°C)	
	Part B:	64°F (251°C)	
	Mixed:	86°F (30°C)	
Conforms to Specifications:	Corps of Engineers Formula C-200a; SSPC-16 and DOD 23236, Type 1, Class 2; AWWA C210-92		

Note: This product is not formulated with lead or mercury containing materials.

REGULATORY DATA

VOC for Mixed Material (theoretical):
As supplied: 1.95 lb/gal (235 g/l)
When thinned to maximum: 5.23 lb/gal (627 g/l)

SURFACE PREPARATION

STEEL: Paint only clean dry surfaces. Prepare surface in accordance with SSPC-SP 10 "Near White Metal Blast Cleaning". Use proper type of abrasive to achieve a profile depth of 2 - 4 mils. Coat within 8 hours or before rust contamination occurs.

CONCRETE: New concrete must age 30 days. Surface shall be clean, dry and free of curing compounds, oil, grease or other contaminants. Sweep blast clean to provide an etched surface for proper adhesion. Remove dust before coating. Prime coat with PorterTuf 2000 HB Coal Tar Epoxy thinned up to 50% with Porter T-5 Xylene Thinner (5133).

PREVIOUSLY PAINTED (Coal Tar) SURFACES: Paint only clean, dry, surfaces. Lightly sweep blast at low pressure to provide etched surface for proper adhesion. Avoid fracturing the old coating film when sweep blasting. Remove dust before coating. Test for compatibility by applying a test patch. Allow to cure and check for wrinkling, lifting, or loss of adhesion.

INSTRUCTIONS FOR USE

Tinting: Do not tint.

Mixing: Product is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Stir each component separately, then add Part B to Part A and stir mechanically for 5 minutes.

Thinning: STEEL: Thinning is not normally recommended. When necessary, first mix Part B with Part A, stir mechanically for 5 minutes, allow the mixed material to sweat-in for 15 minutes, then add no more than 1 quart of Porter T-5 Xylene Thinner (5133) per 5 gallons of mixed material.

CONCRETE: Follow the same procedure as above but add up to 2 quarts/gallon of Porter T-5 Xylene Thinner (5133) as required to provide good penetration of the prime coat into the concrete. Subsequent coats should not require thinning.

Clean-up: Clean tools and spray equipment immediately after use with Porter Xylene Thinner No. 5133.

Application:

Conditions: Temperature Range: 50°F (10°C) minimum (air, surface, paint) (Optimum paint temperature 70-80°F)

Dew Point: Surface temperature must be at least 5°F above the dew point.

Relative Humidity: Maximum 85%

Equipment: Brushes: Use stiff bristle brushes.

Rollers: Use rug-type roller covers.

Airless Spray: Binks B8DX, 38:1 ratio pump, mounted on ram with follower, 1M mastic gun, .031-.036" tip

Conventional Spray: Binks B4F 2 ½ : 1 ratio at 12 GPM. Tank: Double regulated bottom outlet tank with follower plate. Oil and water extractor. Gun: Binks Model 18, 67 Fluid Nozzle (.086), 67 PD Air Nozzle. Hose: Minimum ¾" ID solvent resistant.

Directions: Steel: Typically applied in a two coat application directly to properly prepared steel at 8-10 mils dry per coat, 16 - 20 mils total. Follow mixing and thinning guidelines above. Can also be applied at 16 mils dry (21 mils wet) in one coat for certain end uses.

Concrete: Prime with this product thinned up to 50% with Porter T-5 Xylene Thinner (5133). (NOTE: Add thinner to mixed material.) Finish with two coats at 8 - 10 mils per coat. Follow mixing and thinning guidelines above.

PRECAUTIONS

Prior to using this product, the user is specifically directed to obtain and read the current Material Safety Data Sheet and Label for this product. If, after reading these documents, you do not understand them, do not use this product. KEEP OUT OF REACH OF CHILDREN.

SHIPPING

Freight Classification: PAINT

Packaging: PART A: 6-Gallon Pail ; **PART B:** 1-Gallon Can (Makes 5 gallons total when mixed.), packed 4 gallons/carton

Shipping Weights: PART A: 47.4 lb/6-gal pail; **PART B:** 8.5 lb/1-gal can (34.8 lb/carton)



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