

PRODUCT DATA SHEET: C3 152 Epoxy Primer
C3 152 Series
Recoatable Epoxy Primer



Product Description:

C3 152 Series is a High Solids, HAPs Free, two component epoxy primer designed for use on steel and other non-ferrous metal substrates. This product has excellent application properties and forms a tough, durable, anti-corrosive film at ambient temperatures as low as 40°F (+5°C). This epoxy primer is specifically formulated to allow unlimited re-coat interval with itself, other epoxy topcoats, polyurethanes or a variety of other solvent-based coatings without the need to abrasive blast the surface to achieve inter-coat adhesion.

Features and Advantages:

- ✓ HAPs Free.
- ✓ Very Low VOC < 0.8 lbs./gal (< 96 g/liter).
- ✓ Excellent adhesion to steel, galvanized and non-ferrous metals.
- ✓ Excellent water resistance and corrosion resistance.
- ✓ Excellent flexibility and impact resistance.
- ✓ Surface Tolerant; application and cure not affected by moisture.
- ✓ Air dries and cures at temperatures as low as 40°F (5°C).
- ✓ May be recoated with a variety of solvent-borne coatings with no maximum time interval.

Recommended Uses:

C3 152 Series is formulated for a variety of uses including the protection of oilfield equipment, steel storage tanks, valves and pipes, machinery refurbishing, trailer primer, OEM, and marine and freshwater vessel operations.

Product Data:

Coating Type:	High Solids Epoxy
VOC:	<0.8 lbs. /gal (95.8 g/L)
HAPs:	0.0 lbs. /gal (None)
Volume Solids:	82.0 % (+/- 2%)
Weight Solids:	91.0 % (+/- 2%)
Reducer:	Shearthin 900/970
Density:	12.55 +/-0.3 lbs. /gal (mixed)
Mixing Ratio	
By Volume:	1 Part A (Activator) to 4 Parts B (Base)

Film Thickness:

3-5 mils Dry Film Thickness
75-125 microns DFT
3.6-6 mils Wet Film Thickness
92-152 microns WFT

Coverage: 1347 sq. ft. / gallon @ 1 mil DFT

269 to 449 sq. ft. /gallon (@ 3-5 mils DFT)

Mixing: Thoroughly mix Part B Base separately for 3-5 minutes until uniform to re-disperse any pigments or solids that may have settled during shipment.

Add 1 part of component A = Activator to 4 parts of component B = Base by volume and mix thoroughly for 3-5 minutes until uniform. This is a two component product and it will not dry or cure without the proper combination and amount of Part A and Part B.

Reduction: Reducer is not normally required, but if desired add 3-5% by volume of **SHEARTHIN 900 or 970** to lower viscosity. Only add reducer after combining Part A with Part B and inducting for at least 10 minutes.

Application: For best results apply in good weather or in areas protected from exterior environmental conditions. Air and substrate temperatures must be at least 35°F(2°) or higher and should be 5°F(3°C) above the dew point and should remain steady or rising during the application and drying period. The standard application method is by spray; conventional, airless, or air-assisted airless spray. Small or difficult to reach areas may be coated using brush or roller application.

Conventional spray – Separate air and fluid regulators are recommended. Use DeVilbiss MBC gun; 704 air cap; F tip and needle or DeVilbiss JGA gun; 765 air cap; E tip and needle, or equal. Atomization air pressure 60-75 psi. Fluid pot pressure should be approximately 8-10 psi or as needed to deliver 12-16 fluid ounces per minute application rate.

Airless Spray – Use a 30:1 ratio or higher Graco air driven fluid pump; Graco Silver Plus gun with 0.017" – 0.019" orifice reverse-clean tips or equal. Fluid pressure should be 2,000 – 2,600 psi or as needed to eliminate "fingering".

Brush and Roller – Use only natural bristle brushes. Use 3/8" nap, phenolic or solvent resistant core, rollers. Apply in a manner to avoid excessive back brushing or back rolling over previously painted areas.

Dry Times and Cure Schedule: – Dry times @ 77°F (25°C) 50% Relative Humidity and 3-5 mils DFT

To Touch: 3-4 Hours

To Handle: 6-7 Hours

To Recoat: 4 Hours

Full Cure: 5-7 Days

Overcoat Interval: Minimum 4 hours- No Maximum

Note: Dry times vary depending on temperature, humidity, film build and air movement.

Pot Life: 4-5 Hours @ 77°F (25°C) 50% RH

Note: Pot Life may be significantly shortened (< 30 minutes) at higher temperatures (95°F+). Lower temperatures will increase Pot Life and Dry Times.

Note: Shearwater's Chemical Cure Accelerator, **C3 Speed 815** is available for this product to speed cure under low temperature conditions. Consult with your **C3** representative for proper use.

Surface Preparation: For best results, substrate should be clean, dry and free of contaminates. Remove all grease or oil from surface prior to abrasive blasting. For Environmental Zone I A&B exposure, prepare substrate to preferred SSPC-SP6/NACE 3 Commercial Blast Cleaning Standard; profile 1-2 mils (25-50 µm). For marine or immersion service, prepare the substrate to SSPC-SP-10/NACE 2 Near-White Blast Cleaning.

Clean up: Clean equipment with **C3 Thinner 950 or 970** as soon as possible after application. Use hand cleaners (Goop etc.) or soap and water to remove any material from hands or skin. The use of hand and skin lotions is recommended after skin clean-up.

Packaging: This product is a two component material formulated to a **1A to 4B** volume mixing ratio.

1.25 Gallon Kit Full Quart of Part A = Activator
Full Gallon of Part B = Base

5 Gallon Kit Full Gallon of Part A = Activator
4 Gallons of Part B = Base in 5 gal pail

Shelf Life: 24 months (stored in unopened containers at 77°F)

Health and Safety:

Keep out of reach of children. Use with adequate ventilation.

This product contains flammable liquids. Keep away from heat, sparks or open flames. If applied in enclosed areas, provide proper air circulation to maintain exposure to solvents below the permissible levels (see MSDS) or provide air supplied respirators or air supplied hoods to prevent exposure.

Avoid prolonged contact with skin and avoid exposure to spray vapors or mists. Use protective barrier cream on exposed skin to prevent contact. Persons who are hypersensitive to epoxy coatings should avoid direct contact with this product.

Follow the manufacturer's instructions on the proper use and maintenance of spray equipment. High pressure airless spray equipment can inject coatings into the skin and may cause serious injury.

Follow all local, state and federal regulations for the proper handling and disposal of all paint, and paint related waste generated from the use of this product.

Use fiberglass or fire resistant filters for spray booth operations. Follow OSHA regulation 1910.107 (CFR 29) pertaining to spray finishing. Dispose of used filters according to OSHA 1910.107(b) (5) (ii) to prevent spontaneous combustion of waste materials.

Information on spray paint regulations and proper disposal may be obtained at www.osha.gov.

Read and understand the Safety Data Sheet (SDS) before using this product.

Disclaimer: Information presented in this Product Data Sheet is believed to be true and accurate and is generated or obtained from accurate and reliable sources. Information is provided here only as a guide to proper product use. However, since Shearwater Products has no direct control over the transport, storage or application of this product, no guarantee of accuracy, completeness, fit-for-use, or ultimate performance of this product is given or implied. Consult with your Shearwater Technical Representative for your specific product application and use.

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