

# Protective & Marine Coatings

# SHER-GLASS FF GLASS FLAKE REINFORCED EPOXY

PART A  
PART B  
PART B

B62-525  
B62V525  
B62V526

SERIES  
STANDARD HARDENER  
LOW TEMP HARDENER

Revised: March 6, 2014

## APPLICATION BULLETIN

4.37

### SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

#### Iron & Steel (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Ultra High Pressure Water Jetting for Steel per SSPC-SP12/NACE 5, WJ-4 (with existing profile) or SSPC-SP3 Power Tool Clean or SSPC-SP2 Hand Tool Clean. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Coat any bare steel the same day as it is cleaned or before flash rusting occurs.

#### Iron & Steel, Immersion Service:

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10 or SSPC-SP12/NACE 2. For SSPC-SP10, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). For SSPC-SP12/NACE 2, all surfaces to be coated shall be cleaned in accordance with WJ-2/SC-2 standards. Pre-existing profile should be approximately 2 mils (50 microns). Light rust bloom is allowed. Remove all weld spatter and round all sharp edges. Prime any bare steel the same day as it is cleaned.

**Note:** If blast cleaning with steel media is used, an appropriate amount of steel grit blast media may be incorporated into the work mix to render a dense, angular 2.0-3.0 mil (50-75 micron) surface profile. This method may result in improved adhesion and performance.

### APPLICATION CONDITIONS

Temperature:		
Standard Hardener:	Air & Material Surface	55°F (13°C) minimum 120°F (49°C) maximum
Low Temp Hardener:	Air & Material Surface	40°F (4.5°C) minimum 120°F (49°C) maximum
At least 5°F (2.8°C) above dew point.		
Relative humidity:		85% maximum
Do not use low temperature hardener above 80°F (27°C)		

### APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

#### Reducer/Clean Up

Reducer ..... R2K4  
Use of any other solvent than xylene, R2K4 may affect the performance or compliance of this product for its intended service

#### Airless Spray

Pump.....	45:1 minimum
Pressure.....	3600 psi minimum
Hose.....	3/8" ID
Tip.....	0.031" - 0.041"
Filter.....	none
Reduction.....	as needed up to 10% by volume

#### Conventional Spray

Gun.....	Binks 95
Fluid Nozzle.....	66
Air Nozzle.....	68 PB
Atomization Pressure.....	80 psi
Fluid Pressure.....	30 psi
Reduction.....	as needed up to 10% by volume

Keep pressure pot at level of applicator to avoid blocking of fluid line due to weight of material. Blow back coating in fluid line at intermittent shutdowns, but continue agitation at pressure pot.

#### Brush

Brush.....	Nylon/Polyester Natural Bristle
Reduction.....	not recommended

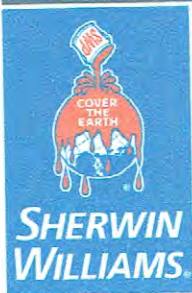
#### Roller

Cover.....	3/8"-1/2" woven with solvent resistant core
Reduction.....	not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

### Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sp 3	Sp 3	SP 5	1
Near White Metal	Sp 2.5	Sp 2.5	SP 10	2
Commercial Blast	Sp 2	Sp 2	SP 6	3
Brush-Off Blast	Sp 1	Sp 1	SP 7	4
Hand Tool Cleaning	St 2	St 2	SP 2	-
Pitted & Rusted	St 2	St 2	SP 2	-
Rusted	St 3	St 3	SP 3	-
Power Tool Cleaning	St 3	St 3	SP 3	-
Pitted & Rusted	St 3	St 3	SP 3	-



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### APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine 4 parts by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation at slow speeds. Allow the material to sweat-in as indicated. Prior to use, pour through a 30-60-mesh screen and re-stir before using.

If reducer solvent is used, add only after components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	10.0 (250)	26.0 (625)
Dry mils (microns)	8.0 (200)	20.0 (500)
~Coverage sq ft/gal (m <sup>2</sup> /L)	61 (1.5)	152 (3.7)

Theoretical coverage sq ft/gal (m<sup>2</sup>/L) @ 1 mil / 25 microns dft

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

#### Drying Schedule @ 15.0 mils wet (375 microns):

With B62V525 @ 55°F/13°C @ 77°F/25°C @ 120°F/49°C

To touch: 7 hours 4 hours 80 minutes  
To handle: 9 hours 4.5 hours 90 minutes

To recoat:  
minimum: 48 hours 18 hours 4 hours  
maximum: 60 days 60 days 45 days

To cure: 14 days 7 days 3 days

Heat Cure: 8 hours @ ambient, then 16 hours @ 140°F (60°C)

If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.

Pot Life: 4 hours 2 hours 30 minutes

Sweat-in-time: 30 minutes 15 minutes none

#### Drying Schedule @ 15.0 mils wet (375 microns):

With B62V526\* @ 40°F/4.5°C @ 77°F/25°C

To touch: 24 hours 2 hours  
To handle: 48 hours 2.5 hours

To recoat:  
minimum: 48 hours 8 hours  
maximum: 30 days 14 days

To cure: 10 days 5 days

Heat Cure: 8 hours @ ambient, then 16 hours @ 140°F (60°C)

If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.

Pot Life: 2 hours 30 minutes

Sweat-in-Time: 10 minutes none

\*Do not use Sher-Glass Low Temp Hardener above 80°F (27°C)

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

### PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance and adhesion.

Excessive film build, poor ventilation, and cool temperatures may cause solvent entrapment and premature coating failure.

**For Immersion Service:** (if required) Holiday test in accordance with ASTM D5162 for steel, or ASTM D4787 for concrete.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

Do not use the Low Temp Hardener above 80°F (27°C)

Refer to Product Information sheet for additional performance characteristics and properties.

### CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with R2K4, or R7K100. Clean tools immediately after use with R2K4, or R7K100. Follow manufacturer's safety recommendations when using any solvent.

### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.