



AMERICAN COATINGS

RX SERIES RECOATABLE EPOXY PRIMER

66 % volume solids, epoxy primer for use over hand cleaned, water blasted, or sandblasted surfaces.

GENERAL FEATURES

- EXCELLENT CORROSION PROTECTION
- INDEFINITE RECOATABILITY
- FAST CURE
- CURES AT LOW TEMPERATURE
- CAN BE USED WITH A VARIETY OF TOPCOATS

DESCRIPTION

Although optimum performance is achieved over sandblasted surfaces this coating is surface tolerant. It may be applied over marginally prepared steel surfaces where it is not possible to abrasive blast. It may be applied over old and aged coating systems that have been hand-prepared, and are free of oil, contaminants and loose paint flakes. This coating is infinitely recoatable and can be topcoated with alkyds, epoxies or polyurethanes. It offers excellent corrosion protection in moderate to severe conditions

USES

American RX Series Epoxy can be overcoated with epoxies, polyurethanes, alkyds, or acrylics. The RX series can be used on structural steel, tank exteriors, hulls, decks, bulkheads and offshore structures. RX Series can be applied over slightly rusty or damp surfaces. It is an excellent choice as a primer for drilling rigs.

NOTE: RX has indefinite recoatability; however, follow good paint practices by removing dirt, chalk, and other foreign matter before topcoating.

PRODUCT COLORS

- RX 22Red Oxide
- RX 64.....Gray
- RX 97..... Beige

PHYSICAL DATA

Finish -----Eggshell
 Color -----red oxide, beige, gray
 Applied Over ----- Steel, Aluminum
 Components ----- Two
 Cure ----- Catalytic 4:1w/ RX Cat
 VOC ----- 2.51 lbs./gallon

Volume Solids ± 2% -----66 %

Recommended Film Thickness

Wet ----- 9 – 12 mils
 Dry ----- 6 – 8 mils
 Number of Coats ----- One
 Application Method -----Airless or Conventional Spray,
 Brush or Roller

Thinning Required----- 0 – 10%

Dry Times @ 50% RH

	77 F	40 F
TOUCH	1 HR	2 HR
TACK FREE	4 HR	10 HR
TOP COAT	10 HR	48 HR

Induction Time-----None

*Theoretical Coverage at:

Recommended Thickness----- 176 – 132 sq. ft/gal

Temperature Limit

Immersed ---- Consult American Coatings Representative
 Atmospheric ----- 200° F

Miscellaneous Properties

Shelf Life ----- 1 year
 Pot Life – Mixed @ 77° F-----2 - 3 hours
 Mixed @ 90° F ----- 1 hours

CAUTION: ELEVATED TEMPERATURES
DRAMATICALLY REDUCE POT LIFE

SURFACE PREPARATION

Commercial Blast (SSPC - SP6/NACE 3) preferred.
 When blasting unavailable power tool or hand clean. Surfaces should be free of dust, dirt, oils, moisture and other contaminants.

* Coverage's are theoretical and do not make provision for spray losses



AMERICAN COATINGS

PERFORMANCE DATA

TEST (ASTM)	RESULTS
HARDNESS (ASTM D-3363)	HB
WEIGHT (ASTM D-1200)	AVG 10.5 pounds/gallon
IMPACT (ASTM G-14)	20 inch pounds direct 10 inch pounds reverse
SOLVENT RESISTANCE (ASTM D-5402)	200 + after 7 days
TAPE ADHESION (ASTM D-33359 A / B)	5A and 5B
PULL OFF ADHESION (ASTM D - 4541)	1000+ psi (Elcometer)
SPECULAR GLOSS (ASTM D-523)	25 units at 60 degrees
SAG RESISTANCE (ASTM D-4400)	16 mils minimum
OIL IMMERSION D (ASTM D-1308)	Passes 1000 Hours
SALT FOG RESISTANCE (ASTM B-117)	Passes 1000 Hours

APPLICATION METHOD

Airless spray preferred, but can be brushed, rolled, or sprayed with conventional equipment.

MIXING

Thoroughly mix Part A before adding Part B, then mix Part A and Part B thoroughly together at a 1:1 ratio taking care to get good color consistency. Induction time is not required. Product should be used immediately

CLEAN-UP AND THINNING

Clean all equipment immediately with TH 315 thinner. If thinning is necessary thin with TH 760 or TH770 thinner.

SPRAY EQUIPMENT

FOR AIRLESS SPRAY

Pump Ratio ----- 33:1
Air Supply (in) ----- 75 – 80 psi

Hose Diameter (ID) -----3/8"
Hose Length ----- 100'
Hose Length -----(in elevated temperature)----- 50'
Tip Size ----- .017 - .025
Atomization Pressure ----- 2,475

DISCLAIMER

The facts stated and the recommendations and suggestions herein are based upon experiments and supplier information believed to be reliable. No guarantee is made of their accuracy, however, and American Coatings ASSUMES NO LIABILITY FOR PRODUCT FAILURE OTHER THAN TO SUPPLY REPLACEMENT MATERIAL FOR PRODUCTS SHOWN TO BE DEFECTIVE WHEN DELIVERED OR TO REFUND THE PURCHASE PRICE. Except as stated, THERE ARE NO WARRANTIES, EITHER EXPRESSED OR IMPLIED, OF MERCHANTABILITY, FITNESS OR OTHERWISE. AMERICAN COATINGS SHALL NOT BE LIABLE FOR SPECIAL, INCIDENTAL AND CONSEQUENTIAL DAMAGES. No tatement contained herein shall be construed as an inducement to infringe existing patents or as an endorsement of specific manufacturers.

FOR CONVENTIONAL SPRAY

Spray Pot with Dual Regulated Air Gauges for Pot Pressure and Atomization Air

Air Supply (in) ----- 100 psi
Material Hose (ID) -----1/2"
Material Hose Length ----- 50'
Air Hose (ID) ----- 5/16"
Air Atomization ----- 40 – 60 psi
Fluid Pressure (psi) ----- 10 –25 psi
Fluid Tip Orifice Size (in) ----- .070" – 80"

SAFETY INFORMATION

FOR PROFESSIONAL USE ONLY! WARNING! FLAMMABLE!

Keep away from sparks or flame. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after applications unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

SHIPPING DATA

Proper Shipping Name ----- Paint Liquid
Hazard Class----- Part A: Flammable Liquid
Part B: Flammable Liquid

Flash Pt. °F SETA -----60° F Part A
80° F Part B

UN 1263 ----- 1263

PACKAGING

Shipping Wt. PART A PART B
Ones 11.3 lbs. Ones 8.41 lbs.
Fives 59.0 lbs. Fives ? lbs.



AMERICAN COATINGS