



AMERICAN COATINGS

TC-12 EPOXY TANK CAULK

A Hand Applied Seam Sealing System for Exterior Leaking of Rivets and Smoothing of Seams in Storage Tanks.

GENERAL FEATURES

- 100% SOLIDS
- PREVENTS RUSTING BETWEEN SPOT WELDING AREAS, CORNERS, AND OTHER HARD TO COAT AREAS
- FORMULATED FOR FLEXIBILITY AND ADHESION

DESCRIPTION

American's TC 12 Seam Sealing Caulk is a 100% solids, epoxy material that is hand applied to the exterior seams and rivets on storage tanks. The system can also be applied to prevent rusting between spot welded areas, corners, and otherwise hard to coat areas preventing unsightly rust streaking. Tank Caulk 12 (TC-12) is the trade name for this 100% solids epoxy material.

On larger jobs using the machine applied version of this products (TC 7) 2 – 3 men can completely seal the rivets and seams in a 120' x 40' diameter storage tank in 3 – 4 days.

PRODUCTS

| | |
|--------|-------------------------|
| TC-12A | Epoxy Resin (2:1 ratio) |
| TC-12B | Catalyst |

SAFETY INFORMATION

American Coatings TC-12 is a 100% volume solids epoxy. If adequate ventilation and protective clothing is used, epoxy resin and hardeners may be handled with little difficulty.

PHYSICAL DATA

Color

| | | |
|------------------|-------|----------------------------|
| TC- 12 A Resin | ----- | White |
| TC-12 B Catalyst | ----- | Dark Blue |
| Mixed | ----- | Baby Blue |
| Applied Over | ----- | Sandblasted steel surfaces |
| Components | ----- | Two |
| Cure | ----- | Catalytic 2:1 |

Volume Solids ± 2% -----100%

Recommended Dry Film

| | | |
|---------------------------------|-------|-----------------|
| Thickness | ----- | 62 mils minimum |
| Number of Coats | ----- | One |
| ¹ Application Method | ----- | hand applied |

Thinning Required----- DO NOT THIN

Dry Time @ 77°F and 50% RH:

| | | |
|------------|-------|--|
| Touch | ----- | 2 – 3 hours |
| Final Cure | ----- | 5 – 7 days |
| Topcoat | ----- | Alkyds, Epoxies, Polyurethane (Inorganic Zinc is not recommended) |

²Theoretical Coverage at:

Recommended Thickness----- 25 sq. ft/gal

Temperature Limit

| | | |
|-------------|-------|---------|
| Immersed | ----- | 190° F |
| Atmospheric | ----- | 250 ° F |

Miscellaneous Properties

| | | |
|--------------------------|-------|-----------------|
| Shelf Life | ----- | 1 year |
| Pot Life – Mixed @ 77 °F | ----- | 30 – 45 minutes |

¹ Machine applied TC-7 is available if a proportioning pump is available

² Coverages are theoretical and do not make provision for spray losses



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SURFACE PREPARATION

Sandblast 2 to 3 inches each side of the steel rivet or seam area. A SSPC-SP5-63 (White Metal Blast) cleaning is required as outlined in the Surface Preparations Specification, of the Steel Structures Painting Council, 40C Fifth Avenue, Pittsburgh, PA 15213. Steel surfaces must be dry and free of all mill scale, oil, grease, paint, and any other foreign matter.

Use dry sand of a maximum particle size no larger than that passing through a 16 mesh screen, U.S. Sieve Series, and air of 100 psi pressure through a 3/8" diameter nozzle. Steel grit or slag, may also be used provided the anchor pattern is of a jagged irregular profile.

Note: Smooth river sands or steel shot are not recommended.

Blast no further distance than what can be coated with American Coatings TC-12 at the end of each day's work. No priming is allowed, for exterior rivets TC-12 obtains maximum adhesion over a sand blasted steel surface.

APPLICATION INFORMATION

Apply TC-12 to a thickness of at least 62 mils.

Materials: The TC-12 material is formulated for flexibility and adhesion to win in the battle against weeps and leaks.

See your American Coatings Representative for hot patch epoxy materials when the tank must be caulked while full or at the same level of the product.

APPLICATION METHOD

Hand Applied

MIXING

Mix 2 parts of Part A to 1 part of Part B.

CLEAN-UP AND THINNING

Clean all equipment with TH 315 thinner.

FINAL CURE

Allow 5 – 7 days at 70° F before returning the tank to service. Minimum time would be 3 days at 90° F. The degree of cure can be checked with a Shore Durometer Hardness Tester (Model Type D). The cured coating should read greater than 70. If a Rockwell Hardness Tester (M Scale) is used the reading should be greater than 105.

MAXIMUM PERFORMANCE

The end user should empty or lower the product level of the tank below the rivet areas to be sealed. This provides for maximum sealing of the rivets and seams.

For sealing rivets from the interior of the tank be sure to topcoat extending 2 – 3 inches to either side and including the caulked area with 2 coats of EP Series Epoxy Phenolic at 4 – 6 mils per coat. This will prohibit undercutting corrosion.

American Coatings TC-12 is not recommended for application to rivet and seams on converted riveted tanks in which sheets have been added by welding. Rivets and seams should be completely caulked on the entire tank shell before painting according to this specification. After sealing the tank with TC-12 all seam sealed areas should be brush blasted in order to receive the tank primer coat. Alkyds, epoxies, polyurethanes, etc. may be applied over the TC-12 seam sealer in this way. Do not topcoat TC-12 with any inorganic type coating.

WARRANTY

TC-12 seam sealer is formulated and provided in accordance to said specifications.

Workmanship and application is the responsibility of qualified and approved contractors.

American Coatings does not recommend the following conditions without written agreements or prior consent.

- 1) Interior tank application to rivet and seams unless overcasted with a chemical resistant coating.
- 2) Polyester or vinyl esters applied over American Coatings TC-7 or TC-12.
- 3) Application of American Coatings TC-7 or TC12 to bolted tanks.
- 4) Overcoating American Coatings TC-7 or TC12 with inorganic zinc rich primers.
- 5) Exterior or interior application of American Coatings TC-7 or TC12 to rivet and seams of riveted tanks with welded sheets. Also cone roof tanks that have been converted to external floaters.
- 6) Application to tanks operating over 225° F.

SHIPPING DATA

Proper Shipping Name ----- Paint Liquid
Hazard Class----- Combustible Liquid
Flash Pt. °F SETA ----- 200° F Part A
200° F Part B

PACKAGING

| | | |
|---------------------|----------------|------------------------|
| <u>Shipping Wt.</u> | <u>PART A</u> | <u>PART B</u> |
| | Fives: 50 lbs. | Fives: 50 lbs. Approx. |



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DISCLAIMER

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revised 10/06