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PRODUCT DATA SHEET

SP-6888[®]

DESCRIPTION: **SP-6888[®]** is a range of surface coatings based on “State of the Art” epoxy chemistry. **SP-6888[®]** is similar to SP-2888[®] R.G. with the benefit of being a pure 100% epoxy. The cathodic disbonding resistance of **SP-6888[®]** is excellent at temperatures up to 80°C (176°F). **SP-6888[®]** is available in Brush Grade and Spray Grade. **SP-6888[®]** is also available in Cartridges for coating repairs.

ADVANTAGES:

- 100% Solids - No VOCs.
- High build single coat application.
- Isocyanate free.
- Excellent resistance to high temperature cathodic disbonding at temperatures up to 80°C (176°F)
- Excellent adhesion to grit blasted steel surfaces, Fusion Bond Epoxy, liquid epoxy, and urethane coatings.

USES:

- Coating of pipe, valves and fittings.
- Rehabilitation of existing pipelines.
- Girth weld coatings.
- Tank linings.

APPLICATION:

- Spray Grade: Graco Hydra-Cat (Tip Size: .019 - .031)
- Brush Grade: Brush or Roller
- Cartridge: Manual Dispenser

CLEANING MATERIALS:

- SP-100 Equipment Wash
- SP-110 Tool Cleaner
- SP-120 Internal Storage Lubricant



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- SURFACE PREPARATION:**
- (Steel Substrate)
- **Cleanliness** : Near White
 - **Standards** : NACE 2, Sa 2½ (Swedish Scale, ISO 8501-1)
: SSPC SP-10 (Steel Structures Painting Council)
 - **Profile** : 62.5 microns minimum to 125 microns maximum
(2.5 mils to 5.0 mils)

RECOMMENDED FILM THICKNESS:

- **Pipelines:** **Wet:** 0.50 mm minimum to 1.25 mm maximum (20 mils to 50 mils)
Dry: 0.50 mm minimum to 1.25 mm maximum (20 mils to 50 mils)
- **Tank Lining:** 0.75 to 1.50 mm (30 to 60 mils) *
1.25 to 1.75 mm (50 to 70 mils) – Tank bottom and
1.8 to 2.4 m (6 to 8 ft.) up the tank wall. *

* Dependent on application, consult your SPC Representative.

- RE-COAT INTERVAL:**
- @ 25°C (77°F) - Maximum: 2 Hours
@ 100°C (212°F) - Maximum: 15 Minutes
- Sweep blasting of the surface is required if the maximum re-coat interval is exceeded. Small areas ≤ 316 sq. cm. (≤ 49 sq. in.) may be sanded using a medium grit (80-100) carborundum cloth. All dust from the sanding or blast roughening must be removed from the surface prior to the application of the coating.

- MIXING RATIO:**
- Brush Grade & Spray Grade, By Volume: 3 Parts Base to 1 Part Hardener.
 - Cartridge, By Volume: 2 Parts Base to 1 Part Hardener.

HANDLING PROPERTIES:

Pot Life [100 gm mass @ 25°C (77°F)].....	12 minutes
Dry Time (ASTM D-1640) [0.75 mm (30 mils) coating thickness @ 25°C (77°F)]	
Tack Free Time.....	90 minutes
Dry Hard Time	2.5 hours



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HANDLING PROPERTIES (cont.):

Ambient Temperature -25°C to 100°C (-13°F to 212°F)

Substrate Temperature..... The acceptable substrate (metal surface) temperature range for the application of SP-6888[®] is 10°C (50°F) to 100°C (212°F). Preheating of the substrate is required if the surface to be coated is below 10°C (50°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature before proceeding with the coating operation. Refer to the attached Curing Table.

Storage / Shelf Life Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 40°C (104°F). Keep the lids sealed. The Shelf Life is a maximum of 24 months in unopened containers.

LIQUID PROPERTIES

BASE

HARDENER

Appearance.....	Red Viscous Liquid.	Clear Amber Liquid.
Solids Content (%)	100	100
Specific Gravity (ASTM D-1475)...	1.68 ± 0.03	1.06 ± 0.02
Specific Gravity (ASTM D-1475)...	Base & Hardener Mixed:	1.52 ± 0.03
Coverage (Theoretical).....	Base & Hardener Mixed:	1604 (ft ² /U.S. Gallon/mil) 39.0 (m ² /Litre/25 microns)

PHYSICAL / MECHANICAL / ELECTRICAL PROPERTIES:

Adhesion to Steel:

Dry Adhesion (Pull-off Strength) (PSI) (ASTM D-4541-95-A4) (Self-Alignment Adhesion Tester, Type IV) [25°C (77°F)].....	>4000
Wet Adhesion (Hot Water Soak) (CSA-Z245.20-06, Clause 12.14, 120 Days) [75°C ± 3°C (167°F ± 5°F)]	Rating #1



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PHYSICAL / MECHANICAL / ELECTRICAL PROPERTIES (cont.)

Cathodic Disbonding Test, System 1A (mm) [CSA-Z245.20-06, Clause 12.8, 28 Days @ 80°C (176°F)].....	7.66
Dielectric Strength (volt/10 ⁻³ in) (ASTM D-149)	400
Dielectric Constant (60 cycles) (ASTM D-150)	4.2
Flexibility (° PPD) (CSA-Z245.20-06, Clause 12.11) [23°C (73.4°F)].....	1.58
Flexibility (° PPD) (CSA-Z245.20-06, Clause 12.11) [0°C (32°F)].....	1.00
Flexibility (° PPD) (CSA-Z245.20-06, Clause 12.11) [-30°C (-22°F)].....	0.50
Hardness (Shore D) (ASTM D-2240-91) [25°C (77°F)]	86
Impact (Joules) (CSA-Z245.20-06, Clause 12.12) [25°C (77°F)]	2.5
Impact (Joules) (CSA-Z245.20-06, Clause 12.12) [0°C (32°F)]	2.7
Impact (Joules) (CSA-Z245.20-06, Clause 12.12) [-30°C (-22°F)]	2.3
Water Vapour Permeability (perm-in) (ASTM D-1434)	< 0.003
Water Absorption (% , 24h, r.t.) (ASTM D-570)	0.1

SAFETY: Read the Material Safety Data Sheets before use.












NOTE: All epoxy coatings will change colour, lose gloss and chalk on exterior exposure.
However, the protective properties of the material will not be affected.

REFER TO COLOUR CHART AT END OF PRODUCT DATA SHEET.



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SPECIALTY POLYMER COATINGS, INC. (SPC) BRUSH GRADE COATING KITS <u>COLOUR CHART</u> Match Base & Hardener Based on Colour Coded Dots Below			
<u>SIZE</u>	<u>COLOUR</u>	<u>VOLUME</u>	
		<u>BASE</u>	<u>HARDENER</u>
0.50 Litres	PINK 	0.3750 Litres	0.1250 Litres
0.75 Litres	FL GREEN 	0.5625 Litres	0.1875 Litres
0.90 Litres	FL YELLOW 	0.6750 Litres	0.2250 Litres
1.00 Litres	RED 	0.7500 Litres	0.2500 Litres
1.25 Litres	PURPLE 	0.9375 Litres	0.3125 Litres
1.50 Litres	YELLOW 	1.1250 Litres	0.3750 Litres
1.75 Litres	ORANGE 	1.3125 Litres	0.4375 Litres
2.00 Litres	BLACK 	1.5000 Litres	0.5000 Litres
2.25 Litres	BLUE 	1.6875 Litres	0.5625 Litres
2.50 Litres	GREEN 	1.8750 Litres	0.6250 Litres
2.75 Litres	WHITE 	2.0600 Litres	0.6900 Litres
	Note: FL = Fluorescent		

EFFECTIVE DATE: May 12, 2008

SPC / Product Data Sheet SP-6888