



CORPORATE HEAD OFFICE  
Specialty Polymer Coatings  
#104, 20529 - 62nd Avenue, Langley, BC, CANADA V3A 8R4  
Tel: (604) 514-9711 • Fax: (604) 514-9722

U.S.A. HEAD OFFICE  
Specialty Polymer Coatings USA, Inc  
22503 FM521, Angleton Texas, 77515, USA  
Tel: (281) 595-3530 • Fax: (281) 595-3717

---

## PRODUCT DATA SHEET

## SP-6889 EPOXY COATING

---

- DESCRIPTION:** SP-6889 is a 100% solids, two-component all weather cure epoxy coating for the marine, offshore and industrial environments.
- ADVANTAGES:**
- Superior corrosion resistance.
  - Superior water resistance, fresh or salt water.
  - Good adhesion to marginally prepared surface.
  - Single coat application to mil thickness normally requiring two to three coats.
  - Application by conventional or plural component Airless Spray equipment.
- USES:**
- Lining for ballast tanks and penstocks.
  - Corrosion resistance coating for structural steel, storage tanks, and equipment in refineries, pulp and paper mills and chemical plants.
- APPLICATION:**
- Airless Spray: Graco 45:1 or 56:1 or equivalent is required. A reversible tip (0.21 or greater) is recommended. A 1/2" I.D. hose (no longer than 100 ft.) fitted with a 3/8" I.D. (10 ft.) whip hose is recommended.
  - For badly pitted steel surfaces, the spray-roll-spray technique is recommended. Spray a thin initial coat, then using a short nap roller, work the material into the bottom of pitted areas to ensure complete wetting of the surface. Then spray the rolled areas with coating to the specified thickness.
  - Plural Component Airless Spray can also be used. Contact your SPC Representative for detailed application instructions using this method.
- CLEANING MATERIALS:**
- SP-100 Equipment Wash
  - SP-110 Tool Cleaner
- RECOMMENDED DRY FILM THICKNESS:**
- Immersion Service: 14-16 mils in one or two coats depending on client's specification.
  - Non-immersion Services: As per client's specifications.



---

## PRODUCT DATA SHEET

## SP-6889 EPOXY COATING

---

### **SURFACE**

#### **PREPARATION:**

(Steel Substrate)

- Cleanliness: The surface to be treated shall be dry and free of grease, oil, dust, abrasive material or any other contaminants. Remove grease and oil with a suitable detergent. Remove salts and other contaminants by high-pressure fresh water cleaning.
- Immersion Service: Abrasive Blast to SSPC SP-10 (Near White).
- Non-immersion Service: Abrasive Blast to SSPC SP-6 (Commercial Blast) or to SSPC SP-2 or SSPC SP-3 where blasting is not possible.

#### **RE-COAT INTERVAL:**

- 25°C (77°F) - Minimum: 8 Hours  
- Maximum: 4 Days
- Sweep blasting of the surface is required to ensure inter-coat adhesion if the maximum re-coat interval is exceeded. Small areas  $\leq 316$  sq. cm. ( $\leq 49$  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 re-coat application.

#### **MIXING RATIO:**

- By Volume: 2 Parts Base to 1 Part Hardener.

#### **PRIMER COAT:**

- None – SP-6889 is self-priming.

#### **HANDLING PROPERTIES:**

Pot Life [25°C (77°F)].....	75 minutes
Dry Time [ASTM D-1640 @ 25°C (77°F)]:	
Touch Dry Time .....	6 Hours
Dry Hard Time .....	10 Hours
Full Cure .....	4 Days



---

## PRODUCT DATA SHEET

## SP-6889 EPOXY COATING

---

### HANDLING PROPERTIES (cont.):

Minimum Application Temperature.....	10°C (50°F)
Minimum Coating Temperature.....	20°C (68°F)
Ideal Temperature Range for Surface and Coating....	15-25°C (59-77°F)
	<ul style="list-style-type: none"><li>• Product is capable of curing down to 5°C (41°F) but the dry time will be extended.</li></ul>
Substrate Temperature.....	The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature to avoid condensation before proceeding with the coating application.
Relative Humidity .....	<ul style="list-style-type: none"><li>• Maximum 80%</li><li>• Preferable: 40-60%</li></ul>
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:

Appearance.....	Light Blue.
Volume Solids Content (%) .....	100
Coverage (Theoretical).....	Base & Hardener Mixed: 108 ft <sup>2</sup> /U.S. Gallon – 15 mils 2.6 m <sup>2</sup> /Litre - 375 microns

**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.

**EFFECTIVE DATE:** September 26, 2005