



*Industrial and Marine
Coatings*

TILE-CLAD® HIGH SOLIDS

PART A B62Z
PART B B60VZ70

SERIES
HARDENER

PRODUCT INFORMATION

Revised 1/2000

PRODUCT DESCRIPTION		RECOMMENDED USES																																								
<p>TILE-CLAD HIGH SOLIDS is a VOC compliant, two-pack-age, epoxy-polyamide coating for use in industrial maintenance environments and high performance architectural applications.</p> <ul style="list-style-type: none"> • Chemical resistant • Dry film resists bacterial attack • Abrasion resistant • Suitable for use in USDA inspected facilities • Low VOC 		<p>For use over prepared substrates such as steel, galvanizing, and concrete in industrial environments.</p> <ul style="list-style-type: none"> • Laboratories • Masonry surfaces • Offshore structures • Storage tanks • Chemical processing equipment • Institutional & commercial wall coating • Structural & support steel • Institutional kitchens • Lavatories • Power plants • Schools • Marine applications 																																								
PRODUCT CHARACTERISTICS		PERFORMANCE CHARACTERISTICS																																								
<p>Finish: Gloss</p> <p>Color: Ultra White and a wide range of colors available, including safety colors</p> <p>Volume Solids: 56% ± 2%, mixed, may vary by color Ultra White</p> <p>Weight Solids: 70% ± 2%, mixed, may vary by color Ultra White</p> <p>VOC (EPA Method 24): Unreduced: 374 g/L; 3.12 lb/gal mixed Reduced 10%: 413 g/L; 3.44 lb/gal</p> <p>Mix Ratio: 1:1 by volume</p> <p>Recommended Spreading Rate per coat: Wet mils: 4.0 - 7.0 Dry mils: 2.5 - 4.0 Coverage: 225 - 359 sq ft/gal approximate</p> <p>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</p> <p>Drying Schedule @ 4.0 mils wet @ 50% RH:</p> <table border="1"> <thead> <tr> <th></th> <th>@ 55°F</th> <th>@ 77°F</th> <th>@ 110°F</th> </tr> </thead> <tbody> <tr> <td>To touch:</td> <td>3 hours</td> <td>1 hour</td> <td>20 minutes</td> </tr> <tr> <td>Tack free:</td> <td>6 hours</td> <td>2 hours</td> <td>30 minutes</td> </tr> <tr> <td>To recoat</td> <td></td> <td></td> <td></td> </tr> <tr> <td> minimum:</td> <td>6 hours</td> <td>2 hours</td> <td>30 minutes</td> </tr> <tr> <td> maximum:</td> <td>30 days</td> <td>30 days</td> <td>30 days</td> </tr> <tr> <td>To stack:</td> <td>18 hours</td> <td>16 hours</td> <td>3 hours</td> </tr> <tr> <td>To cure:</td> <td>21 days</td> <td>14 days</td> <td>7 days</td> </tr> <tr> <td>Pot life:</td> <td>4 hours</td> <td>4 hours</td> <td>2 hours</td> </tr> <tr> <td>Sweat-in-Time:</td> <td>1 hour</td> <td>30 minutes</td> <td>10 minutes</td> </tr> </tbody> </table> <p>If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened, at 77°F</p> <p>Flash Point: 64°F, PMCC, mixed</p> <p>Reducer/Clean Up: Reducer #54, R7K54</p>		@ 55°F	@ 77°F	@ 110°F	To touch:	3 hours	1 hour	20 minutes	Tack free:	6 hours	2 hours	30 minutes	To recoat				minimum:	6 hours	2 hours	30 minutes	maximum:	30 days	30 days	30 days	To stack:	18 hours	16 hours	3 hours	To cure:	21 days	14 days	7 days	Pot life:	4 hours	4 hours	2 hours	Sweat-in-Time:	1 hour	30 minutes	10 minutes	<p>System Tested: (unless otherwise indicated) Substrate: Steel Surface Preparation: SSPC-SP6 1 ct. Recoatable Epoxy Primer @ 4.0 - 6.0 mils dft 1 ct. Tile-Clad HS @ 3.0 mils dft</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 80 mg loss</p> <p>Adhesion: Method: ASTM D4541 Result: 1050 psi</p> <p>Corrosion Weathering: Method: ASTM D5894, 6 cycles, 2016 hours Result: Rating 10 per ASTM D610 for rusting Rating 10 per ASTM D714 for blistering</p> <p>Direct Impact Resistance: Method: ASTM D2794 Result: 95 in. lbs.</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 200°F</p> <p>Exterior Durability: Method: 1 year 45° South Result: Excellent, chalks</p> <p>Flexibility: Method: ASTM D522, 180° bend, 1/4" mandrel Result: Passes</p> <p>Moisture Condensation Resistance: Method: ASTM D4585, 100°F, 1000 hours Result: Passes, no blistering, rust, or delamination</p> <p>Pencil Hardness: Method: ASTM D3363 Result: F-H</p> <p>Salt Fog Resistance: Method: ASTM B117, 750 hours Result: Good—no cracking, softening or delamination. No more than 1/16" rust creepage at scribe.</p>	
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<p>Epoxy coatings may darken or yellow following application and curing. Provides performance comparable to products formulated to federal specification: TT-C-535B</p>																																										



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PRODUCT INFORMATION

RECOMMENDED SYSTEMS

Steel, epoxy primer:

- 1 ct. Recoatable Epoxy Primer @ 4.0 - 6.0 mils dft/ct
- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Steel, universal primer:

- 1 ct. Kem Bond HS @ 2.0 - 5.0 mils dft/ct
- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Steel, epoxy mastic primer:

- 1 ct. Epoxy Mastic Aluminum II @ 4.0 - 6.0 mils dft/ct
- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Aluminum:

- 1 ct. DTM Wash Primer @ 0.7 - 1.3 mils dft/ct
- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Concrete Block:

- 1 ct. Heavy Duty Block Filler @ 10.0 - 18.0 mils dft/ct
- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Galvanized Metal:

- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Poured Concrete/Tilt-Up Concrete (including floors):

- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

Wood, including floors:

- 1-2 cts. Tile-Clad High Solids @ 2.5 - 4.0 mils dft/ct

SURFACE PREPARATION

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.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

- * Iron & Steel: SSPC-SP2
- Aluminum: SSPC-SP1
- Galvanizing: SSPC-SP1
- Concrete & Masonry: SSPC-SP13/NACE 6
- Wood, interior: Clean, smooth, dust free

* Primer required

COLOR AVAILABILITY/TINTING

Tint with Blend-A-Color Toner at 200% strength into Part A. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

Color: Ultra White and a wide range of colors possible, including safety colors

APPLICATION CONDITIONS

- Temperature: 55°F minimum, 110°F maximum (air, surface, and material)
At least 5°F above dew point
- Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

- Packaging:
Parts A & B: 1 and 5 gallon containers
- Weight per gallon: 10.78 ± 0.2 lb
mixed, may vary by color

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.

The systems listed above are representative of the product's use. Other systems may be appropriate.



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APPLICATION BULLETIN

Revised 1/2000

SURFACE PREPARATION

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

Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.

Aluminum

Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F. Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with ArmorSeal Crack Filler.

Wood

Surface must be clean, dry and sound. Remove any oils and dirt from the surface using a degreasing solvent or strong detergent. Sand to remove any loose or deteriorated surface wood and to obtain a proper surface profile. Prime with recommended primer and paint as soon as possible. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped or sanded and spot primed before full coat of primer is applied. All nail holes or small openings must be properly caulked.

APPLICATION CONDITIONS

Temperature: 55°F minimum, 110°F maximum
(air, surface, and material)
At least 5°F above dew point

Relative humidity: 85% maximum

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 compatible with the existing environmental and application conditions.

Reducer/Clean Up Reducer #54, R7K54

Airless Spray

Pressure 2400 psi
Hose 3/8" ID
Tip019"
Filter 60 mesh
Reduction as needed up to 10% by volume

Conventional Spray

Gun Binks 95
Fluid Nozzle 66
Air Nozzle 69 PB
Atomization Pressure ... 60 psi
Fluid Pressure 20 psi
Reduction as needed up to 10% by volume

Brush

Brush Nylon/Polyester or Natural Bristle
Reduction not recommended

Roller

Cover 1/4"-3/8" " woven with phenolic core
Reduction not recommended

If specific application equipment is listed above, equivalent equipment may be substituted.



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APPLICATION BULLETIN

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with power agitation. Make certain no pigment remains on the bottom of the cans. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated. Re-stir before using.

If reducer solvent is used, add only after both 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:

Wet mils: 4.0 - 7.0
Dry mils: 2.5 - 4.0
Coverage: 225 - 359 sq ft/gal approximate

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

Drying Schedule @ 4.0 mils wet @ 50% RH:

	@ 55°F	@ 77°F	@ 110°F
To touch:	3 hours	1 hour	20 minutes
Tack free:	6 hours	2 hours	30 minutes
To recoat:			
minimum:	6 hours	2 hours	30 minutes
maximum:	30 days	30 days	30 days
To stack:	18 hours	16 hours	3 hours
To cure:	21 days	14 days	7 days
Pot life:	4 hours	4 hours	2 hours
Sweat-in-Time:	1 hour	30 minutes	10 minutes

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

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

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer #54, R7K54.

Quik-Kick Epoxy Accelerator is acceptable for use. See data page 4.99 for details.

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

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer #54, R7K54. Clean tools immediately after use with Reducer #54, R7K54. Follow manufacturer's safety recommendations when using any solvent.

SAFETY PRECAUTIONS

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