



**Industrial
&
Marine
Coatings**

TILE-CLAD® HIGH SOLIDS

4.30A

PART A B62Z
PART B B60VZ70
PART B B60VZ75

SERIES
GLOSS HARDENER
EG-SHEL HARDENER

APPLICATION BULLETIN

Revised 5/05

SURFACE PREPARATION	APPLICATION CONDITIONS
<p>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.</p> <p>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/NACE 3, 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. Primer Required.</p> <p>Aluminum Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer Required.</p> <p>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.</p> <p>Concrete and Masonry For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI 03732, CSP 1-3. Surfaces must be clean, dry, sound and offer sufficient profile to achieve adequate adhesion. 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.</p> <p>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.</p>	<p>Temperature: 55°F minimum, 110°F maximum (air, surface, and material) At least 5°F above dew point</p> <p>Relative humidity: 85% maximum</p>
	<h4 data-bbox="963 775 1190 802">APPLICATION EQUIPMENT</h4> <p>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 compliant with existing VOC regulations and compatible with the existing environmental and application conditions.</p> <p>Reducer/Clean Up Reducer #54, R7K54, R6K25</p> <p>Airless Spray</p> <p>Pressure 2400 psi Hose 3/8" ID Tip019" Filter 60 mesh Reduction R7K54 as needed up to 10% by volume</p> <p>Conventional Spray</p> <p>Gun Binks 95 Fluid Nozzle 66 Air Nozzle 69 PB Atomization Pressure ... 60 psi Fluid Pressure 20 psi Reduction R7K54 as needed up to 10% by volume</p> <p>Brush</p> <p>Brush Nylon/Polyester or Natural Bristle Reduction R6K25 as needed up to 10% by volume</p> <p>Roller</p> <p>Cover 1/4"-3/8" woven with phenolic core Reduction R6K25 as needed up to 10% by volume</p> <p>If specific application equipment is not listed above, equivalent equipment may be substituted.</p>



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APPLICATION PROCEDURES	PERFORMANCE TIPS																																								
<p>Surface preparation must be completed as indicated.</p> <p>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.</p> <p>If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.</p> <p>Apply paint at the recommended film thickness and spreading rate as indicated below:</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>Application of coating below minimum or above maximum recommended spreading rate may adversely affect coating performance.</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>Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.</p> <p>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.</p> <p>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.</p> <p>Excessive reduction of material can affect film build, appearance, and adhesion.</p> <p>Do not apply the material beyond recommended pot life.</p> <p>Do not mix previously catalyzed material with new.</p> <p>In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer #54, R7K54.</p> <p>Quik-Kick Epoxy Accelerator is acceptable for use. See data page 4.99 for details.</p> <p>Refer to Product Information sheet for additional performance characteristics and properties.</p>
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<p>Clean spills and splatters immediately with Reducer #54, R7K54. Clean tools immediately after use with Reducer #54, R7K54. Follow manufacturer's safety recommendations when using any solvent.</p>	<p>Refer to the MSDS sheet before use.</p> <p>Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.</p>																																								
DISCLAIMER	WARRANTY																																								
<p>The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.</p>	<p>The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.</p>																																								