

CORCHEM[®] 283 SOLVENTLESS ENVIRONMENTAL FINISH

GENERIC	A diglycidyl ether of bisphenol-A resin reacted with a unique modified multiple ring cycloaliphatic amine adduct activator. The polymer structure is extremely tough with excellent chemical resistance and is reinforced with laminar flake pigments.
DESCRIPTION	Exceptionally attractive ceramic-like high build epoxy mastic designed to provide penetration, wetting and sealing of substrates and surfaces that will be exposed to severe chemical and physical environments. It is formulated to be extremely adhesive, hard, impact and abrasion resistant. The cured film conforms to United States Department of Agriculture requirements for coatings in incidental contact with food.
USE	Steel and concrete storage vessels and reservoirs, railcars, tank trucks, mechanical machinery, piping and processing equipment, containment walls and floors. Provides a high degree of protection against moisture, corrosive fumes, and chemical contact. Intended for use in both field and shop operations. The principle use is for corrosion and abrasion problem areas such as industrial facilities and architectural structures. Suggested as a heavy-duty, general purpose, decorative protective lining or finish. Self-priming to steel, concrete, most substrates and poorly prepared surfaces or may be used in combination with primers such as CORCHEM [®] 94, 97, 235, 254, 260, 262, MCTHANE [™] 55, 150 and many other CORCHEM [®] products.
SERVICE LIMITATIONS	Temperature resistance up to 250°F (dry) and up to 200°F (wet) depending upon the individual exposure. CONTACT CORCHEM [®] FOR SPECIFIC RECOMMENDATIONS BEFORE PROCEEDING for immersion service and exposure to corrosive chemicals, elevated temperatures and/or pressures, or use with cathodic protection systems. Avoid sudden depressurization of lining. NOTE: Exterior insulation of tanks, vessels and processing equipment is recommended to prevent "cold wall effect" if interior lining is subject to elevated temperatures.
COLORS	White (other colors available).
FINISH	High Gloss. Finish may vary due to texture and porosity of substrate.
CAUTION!	Subject to color change (yellowing, darkening, etc.) Chalking will occur with extended exposure to sunlight.
VOLUME SOLIDS	100% (may vary depending on color selected).
DRY COVERAGE	Theoretical (no loss): 1600 sq. ft. per gallon for one mil (.001). Allow for application loss and surface irregularities when computing irregularities.
DRY FILM THICKNESS	Up to 25 mils per coat if thinner is added. Up to 60 mils coat if no thinner added. Multiple applications are recommended and may be necessary to achieve the specified or desired film thickness or due to variations in design configurations, application equipment, temperature and other factors.

COMPONENTS Two. By volume 1 to 1 (Base:Activator).

POT LIFE < 1hour @ 70°F (one gallon mixed quantity). Pot life is significantly shorter for higher temperatures or larger quantities and longer for lower temperatures or smaller quantities.

VOC CONTENT 0 gms/l or 0.0 lbs/gal. Conforms: to United States National Volatile Organic Compound Emission Standards.

THINNER CORCHEM® 4. Thin only as required for proper application. Do not exceed applicable volatile organic compound (VOC) regulations. Thinner added:

05% - 41 gms/lit or 0.34 lbs/gal	10% - 79 gms/lit or 0.66 lbs/gal
15% - 113 gms/lit or 0.94 lbs/gal	20% - 145 gms/lit or 1.21 lbs/gal

APPLICATION METHODS Air or airless spray (heaters and plural component equipment not required), roller, squeegee, brush (small areas), "chopped" and "hand lay-up" method.

TEMPERATURES Apply at 35°F to 125°F (Air and Surfaces) and 5°F above the dew point. Sudden and/or substantial temperature change during curing process or in-service conditions can cause film defects.

CURING TIME Recoat 2-48 Hours @ 70°F (refer to RECOAT AND REPAIR Section if coating reaches complete cure and hardness or if subjected to extended exposure to sunlight). Final cure for immersion is 2 days @ 70°F. Curing time is significantly shorter for higher temperatures or lower thickness and longer for lower temperatures or higher thickness. Curing time is affected by the method of application; quantity of thinner (if used); the amount of ventilation and air circulation; relative humidity; etc.

NOTICE! Heat curing may be used to increase drying speed and resistance properties. Contact CORCHEM® for instructions and heat cure times.

PACKAGING 2 gallon and 10 gallon kits. 50 gallons drum (packaged multiple of two).

SHELF LIFE 1 year from shipment date protected between 40°F and 100°F.

DOT/FLASH POINT Non-Flammable Liquid Classification.

PERFORMANCE DATA Contact CORCHEM® for desired information.

SURFACE PREPARATION Round off sharp edges and rough welds. Burrs and weld spatter should be completely removed. Surfaces must be clean, dry and free of any dirt, chalk, grease, oils, salts, and deleterious materials before application is performed. Vacuum the topside of all horizontal and sloped surfaces. Fill pitted steel by troweling CORCHEM® 263 FILLER SURFACER over pits leaving them flush with surface. Repair perforations in steel by patching or plugging with $\geq 3/16$ inch steel using full fillet welds on large perforations and CORCHEM® 263 FILLER SURFACER as bonding adhesive on small perforations. Grind top edges of patches to a round contour.

CARBON STEEL Immersion Service: SSPC-SP-10 (Near-White Blast Cleaning). Severe Atmospheric Exposures: SSPC-SP-6 (Commercial Blast Cleaning). Mild Atmospheric Exposures: SSPC-SP-3 (Power Tool Cleaning) or SSPC-SP-2 (Hand Tool Cleaning). Metal surfaces should have an anchor profile of two mils (.002) or more. If metal substrate has "cavities" or "indentations" apply primer application coat and back roll to completely wet and thoroughly penetrate surface to ensure all voids and irregularities are filled. For Chime Area apply sufficient CORCHEM® 263 FILLER SURFACER to obtain a smooth radius of 1.5 inches (or make grout by mixing 4 parts clean, dry 100 mesh silica sand with 1 part CORCHEM® 263 FILLER SURFACER). Premix base grout and activator in small quantities and hand apply with trowel.

NON-FERROUS METALS	SSPC-SP-7 (Brush-Off Blast Cleaning). Coatings applied to these surfaces may not achieve the same degree of adhesion and toughness.
WELDING	Welding should precede coating. If already coated, follow instructions in U.S.A. Standard Z49.1 Safety in Welding and Cutting.
EXISTING COATINGS	Surfaces must be clean, dry and free of any dirt, chalk, grease, oils, salts, and deleterious materials before application is performed. <u>Perform a test patch to check adhesion and compatibility.</u> If necessary, abrade the surface sufficiently to provide a profile adequate to ensure a mechanical bond. The use of CORCHEM® 11 ADHESION PROMOTER may be desired.
CONCRETE AND MASONRY	Concrete and masonry to cure at least 28 days. Surface and substrate must be dry. Clean and open surfaces by dry abrasive "brush-off" blast. All concrete laitance should be removed. "Blow" holes and cavities should be opened in order to properly fill and seal. Level protrusions and repair cavities, voids, and cracks. Apply primer application coat and back roll to completely wet and thoroughly penetrate surface to ensure that all irregularities are filled and sealed.
APPLICATION MIXING	All equipment should be cleaned and flushed with CORCHEM® 4 THINNER. Add Component A into Component B. Do not vary proportions. Power stir, until completely mixed and continue agitation during application. Strain only if required for proper application. Do not allow catalyzed material to stand in equipment after use! Clean immediately with CORCHEM® 4 THINNER or Methyl Ethyl Ketone (MEK).
APPLY	In an even wet coat. Ensure seams and irregularities are completely covered. Application below minimum or above maximum suggested dry film thickness ranges might adversely affect performance. Use of a thin or "mist" coat prior to regular application may be needed to reduce pinholing and/or blistering over a rough/porous type primer or substrate.
HAND LAY-UP METHOD	Use two or more layers of polyester felt or glass mat or other suitable fiber reinforcement. Adjoining layers must overlap by at least 3 inches. Apply a heavy coat of CORCHEM® 283 SOLVENTLESS ENVIRONMENTAL FINISH at a rate of 30 square feet per gallon by roller or spray. Lay sections of fiber reinforcement into wet coating and work in thoroughly with ribbed metal roller to fully wet the fiber reinforcement and remove air bubbles. Minimum film thickness should be 50 mils (.050). Apply a topcoat by spray or roller to a minimum film thickness of 10 mils (.010). Total minimum dry film thickness for the complete laminate system is 60 mils (.060). Ensure all seams and irregularities are completely covered.
RECOAT AND REPAIR	If material has reached complete cure and hardness, or if subjected to extended exposure to sunlight, uniformly abrade the surface and feather the edges. The surface must be roughened sufficiently to provide a profile adequate to ensure a mechanical bond.
INSPECTION	Check for desired dry film thickness and for pinholes, holidays, bare areas, etc. before placing in operating service. Use 2500 voltage spark detector for thick film laminates on conductive substrates.
AIRLESS SPRAY	Graco or equal. Pump ratio 68:1 or higher, 206-718 gun with fluid tip of .019" or larger orifice size with Reverse-A-Clean tip, 3/8" I.D. or larger high-pressure solvent resistant fluid line, 1/2" I.D. or larger air supply line. Continuous air source capable of 80 to 100 psi inbound pressure at pump.

GENERAL	Regulate pressure as required for proper application. Proportionally adjust pressure higher for smaller hose diameter and/or longer hose length and adjust pressure lower for larger hose diameter and/or shorter hose length. Select tip angles and orifice diameters according to application needs.
BRUSH	Short hair or natural bristle.
ROLLER	Short nap synthetic covers for back rolling. Ribbed metal roller for hand lay-up application.
CLOTHING	Wear protective garments, shoes, goggles, and filter masks. Use protective barrier creams on exposed skin areas.
TANKS & VESSELS	If thinner is added to this product use explosion-proof lighting and electrical equipment, non-sparking tools, clothes and shoes. Ground all structures and equipment. Use procedures that prevent static electrical sparks. Wear properly fitted appropriate NIOSH/MSHA approved fresh air respirator such as MSA or equal with 1/4" I.D. or larger air supply line connected directly to proper air source during and after application unless air monitoring demonstrates vapor/mist levels are within safe limits. Use suction type exhaust fans and blowers with sufficient cfm capacity to keep solvent vapors below 20% of the explosive limit. CAUTION! Air circulation and exhausting of solvent vapors must be continued until the coatings have fully cured to insure that no potential for fire, explosion or health hazard remains.

SAFETY INFORMATION

THIS PRODUCT CONTAINS EPOXY RESINS AND AMINE COMPOUNDS. DO NOT USE IF YOU HAVE HAD A REACTION TO THESE MATERIALS. WARNING! VAPOR HARMFUL! CAUSES SEVERE EYE AND SKIN BURNS. MAY CAUSE SKIN SENSITIZATION OR OTHER ALLERGIC RESPONSES. HARMFUL OR FATAL IF SWALLOWED!

Use only with adequate ventilation. Prevent breathing of vapor or spray mists. Wear a properly fitted appropriate respirator during application and until all vapors and spray mists are gone. Prevent contact with eyes and skin. Do not take internally. Keep closures tight and upright to prevent leakage. Keep container closed when not in use. In case of spillage, absorb and dispose of in accordance with local applicable regulations. **FIRST AID:** In case of skin contact, wash thoroughly with soap and water; for eyes, flush immediately with plenty of water for 15 minutes and call a physician. Remove and wash contaminated clothing before reuse. (Discard contaminated shoes). If inhaled, remove to fresh air. If breathing difficulty persists or occurs later, consult a physician and have label and MSDS information available. If swallowed, **CALL A PHYSICIAN IMMEDIATELY. DO NOT INDUCE VOMITING.**

IN CONFINED SPACES AND TANKS OBEY SPECIAL SAFETY AND EQUIPMENT INSTRUCTIONS!

FOR INDUSTRIAL USE BY PROFESSIONAL APPLICATORS ONLY. NOT INTENDED FOR SALE TO THE GENERAL PUBLIC. This product should not be sold or delivered to any person under 18 years of age. KEEP OUT OF THE REACH OF CHILDREN! IF, FOR ANY REASON, ADDITIONAL PRODUCT AND SAFETY INFORMATION, INSTRUCTIONS OR EXPLANATIONS ARE NEEDED, CONTACT CORCHEM® IMMEDIATELY!

LIMITED WARRANTY

WARRANTY & LIMITATION OF SELLER'S LIABILITY: CORCHEM® CORPORATION warrants only that its coatings represented herein meet the formulation standards of CORCHEM® CORPORATION.

THE ABOVE WARRANTY SHALL BE IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTIONS ON THE FACE HEREOF.

The buyer's sole and exclusive remedy against CORCHEM CORPORATION shall be for replacement of this product, in the event a defective condition of the product should be found to exist. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER. The sole purpose of this exclusive remedy shall be to provide buyer with replacement of the product if any defect in materials is found to exist. This exclusive remedy shall not be deemed to have failed its essential purpose so long as CORCHEM® CORPORATION is willing and able to replace the defective materials.

Technical and application information is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and CORCHEM® CORPORATION makes no claim these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.

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