



AquataPoxy AquataPrime

DESCRIPTION

AquataPoxy® AquataPrime is a two component, flexible, blast-hold polyamide epoxy primer. Designed with an extended recoat window and certified safe for potable water when topcoated with AquataPoxy A-6 SuperFlex.

TYPICAL USES

Use as a blast-hold primer for new and existing iron and steel under immersion grade epoxies such as AquataPoxy SuperFlex series. Use where corrosion and water resistance is needed, including:

- Potable water structures
- Tanks, reservoirs and basins
- Water mains, distribution and transmission lines

COLOR

The Part A Resin is an opaque brown; the Part B Curing Agent is white. When mixed the product is off-white.

SOLIDS BY VOLUME

As supplied: 100% solids (VOC's: 0.0 lb per gallon)
With Maximum Thinner: 81.5% solids by volume (88.4% by weight) giving Volatile Organic Compounds: 1.4 lb/gal

FILM THICKNESS

Dry film thickness (DFT) or wet film thickness (WFT) may be calculated with this formula: $DFT = WFT \times \% \text{ solids} / 100$
A maximum of 10 mils WFT (8 mils DFT) per coat is recommended to prevent sagging. Typical WFT when used as a blast-hold primer on metal is 5-6 mils.

ANSI/NSF 61 maximum dry film thickness is 8 mils for pipes $\geq 48''$ and for tanks $\geq 5,000$ gallons.

COVERAGE

When applied at 81.5% solids by volume, coverage is 320 square feet per gallon at 5 mils WFT, providing 4.1 mils DFT. Actual surface coverage will depend on substrate roughness. Good painting practices suggest application of two coats for quality assurance. A wet film thickness gauge may be used to determine actual coating coverage.

APPLICATION

Apply with brush, roller, airless or air-assisted spray or other suitable method. For best results, apply this product when the air, material and substrate are at least 5°F above the dew point temperature.

COMPONENTS AND MIX RATIO

Part A Resin:Part B Curing Agent mix ratio is 1:1 by volume

THINNING

Thin only with Thinner 3 (Part C); suggested maximum thinner level of 81.5% solids by volume is achieved by adding 1.8 pints Thinner 3 per gallon of AquataPrime. Unmixed material should not be heated above 150°F.

POWER MIXING

Mix full kits only. Individually power mix both Part A and Part B containers prior to combining Part A with Part B in a clean disposable pail. Use a heavy-duty drill with a Hanson plunge mixer and mix at 500-700 rpm for three minutes. Dilute by adding Part C (Thinner 3) while mixing another minute. Scrape the sides and bottom while transferring to a clean pail and continue mixing at least another minute before application. Properly mixed material will be a uniform color and texture.

CLEAN UP

To clean tools, use acetone, MEK or xylene. To clean skin, wash immediately and thoroughly with soap and water. Refer to the Material Safety Data Sheet for additional information on health and safety.

POT LIFE

The pot life is 30 minutes for one gallon at 72°F. The working life varies depending on the amount and temperature of epoxy mixed and the ambient temperature.

CURE TIME

Thin film set time varies with substrate temperature and application thickness. Generally, when applied at 5 mils WFT, the coating will be set-to-touch in 10 hours at 72°F and tack-free in about 18 hours. Minimum cure-time before application of top coat is 18 hours at 72°F. Cure-time before potable water service is 3 days after application of A-6 SuperFlex.

RECOAT TIME

This product may be recoated as soon as it becomes tack-free. When applying multiple coats, do not allow more than 7 days at 72°F substrate temperature to pass between coats, higher temperatures will shorten this window. Before recoating; inspect, clean and dry surface thoroughly to remove all contamination, including amine blush or condensation. If the recoat time is missed, clean and abrade surfaces prior to recoating.

SUBSTRATE TEMPERATURE

Minimum recommended substrate temperature: 40°F
Maximum recommended substrate temperature: 120°F

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TEMPERATURE RESISTANCE

Maximum recommended dry temperature: 200°F. Wet temperature resistance depends on chemical concentration and exposure time.

SURFACE PREPARATION

Prior to coating, the substrate must be prepared in a manner that provides a uniform, clean, sound, neutralized surface suitable for the specified coating. The substrate must be free of all contaminants, such as oil, grease, rust, scale or deposits. In general, coating performance is proportional to the degree of surface preparation.

STEEL surfaces may require “Solvent Cleaning” (SSPC-SP 1) to remove oil, grease and other soluble contaminants. Chemical contaminants may be removed according to SSPC-SP 12/NACE No. 5. Identification of the contaminants along with their concentrations may be obtained from laboratory and field tests as described in SSPC-TU 4 “Field Methods for Retrieval and Analysis of Soluble Salts on Substrates”. Surfaces to be coated should then be prepared according to SSPC-SP 5/NACE No.1 “White Blast Cleaning” for immersion service or SSPC-SP 10/NACE No. 2 “Near White Blast Cleaning” for all other service. In certain situations, an alternate procedure may be to use high (>5,000 psi) or ultrahigh (>10,000 psi) pressure water cleaning or water cleaning with sand injection and an approved rust inhibitor. The resulting anchor profile shall be 2.5-5.0 mils and be relative to the coating thickness specified.

AVAILABLE PACKAGES

Available in 1 gallon kits and 5 gallon kits. Kits are supplied in the correct proportions of A, B & C; these three components must be mixed together before use. This product is available through Raven Certified Applicators.

SHELF LIFE AND STORAGE

Product shelf life is 1 year from purchase date in original unopened containers, stored in a sheltered area between 60°F and 80°F (15°C and 27°C).

SAFETY

Consult the Material Safety Data Sheet for this product concerning health and safety information before using. Strictly follow all notices on the Material Safety Data Sheet and container label. If you do not fully understand the notices and procedures provided on the MSDS or if you cannot strictly comply with them, do not use this product. Actual safety measures are dependent on application methods and work environment. Contact RLS to obtain a copy of the Material Safety Data Sheet at 800-324-2810.

CERTIFICATIONS

Potable Water: This product is certified to the requirements of ANSI/NSF 61 - Drinking Water System Components when topcoated with AquataPoxy A-6 SuperFlex.

AWWA: This product meets the physical and performance requirements of ANSI/AWWA C 210, “Liquid Epoxy Coating Systems for the Interior and Exterior of Steel Water Pipelines”.

TYPICAL PROPERTIES⁽¹⁾

DESCRIPTION	METHOD	RESULT
Salt Fog Resistance, rusting	ASTM B 117, 168 hours	2 pinholes
Flexibility	ASTM D 522, 180° bend, 1/8” mandrel	Passes
Hardness, Shore D	ASTM D 2240	80
Direct Impact Resistance	ASTM D 2794	79 in. lbs.
Adhesion, Steel (SSPC-SP 5)	ASTM D 4541	>1,500 psi

(1) Typical properties are to be considered as representative of current production and should not be construed as specifications.

Warranty and Disclaimer: Raven Lining Systems, Inc. (“Raven”) warrants its products to be free of manufacturing defects in accord with applicable Raven quality control procedures and that they meet the formulation standards of Raven. To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. If, within one year from purchase, any product is proven defective, Raven, at its sole option, will either replace the defective product or refund the purchase price. This warranty is void if the product is used contrary to Raven’s written directions.

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