



Marine AC 80 Epoxy Anticorrosive

Product description:

A surface tolerant, two part pure epoxy anticorrosive primer.

Intended use:

Epoxy anticorrosive coating for use on the entire vessel: Underwater, topside, deck, house, water ballast tank, cofferdam, voids, cargo holds and internal spaces.

Product Info:

Color	Various
Finish / sheen	Low sheen
Curing agent	Standard cure
Volume solids	80% ±2%
Mix ratio	4:1 (4 parts base to 1 part curing agent)
Typical film thickness	5.0 – 7.0 mils DFT
Theo coverage	258 square feet per gallon @ 5 mils DFT
Flash point	>100 degree F
Induction time	30 minutes

Dry Times

	50F	75F	90F
Touch dry	7 hr	4 hr	1 hr
Hard dry	30 hr	10 hr	5 hr
Pot life	7 hr	4 hr	2 hr

Over coating Time

	40F	50F	75F	90F
	Min / Max	Min / Max	Min / Max	Min / Max
Marine AC 80	24 hr / 3 mo	18 hr / 2.5	12 hr / 2 mo	8 hr / 1 mo

Note: Antifouling must be applied over MARINE AC 80 when tacky. Do not allow anticorrosive to dry hard.

Regulatory Data

VOC 160 grams per liter or 100 grams per kg

Surface Preparation:

Surface must be clean, dry and free of all contamination. High pressure fresh water washes to remove all soluble contaminants and foreign matter. Clean any oil or grease in accordance with SSPC-SP1 Solvent Cleaning. Salt level must be below 10µg/cm² before painting.

New builds: Blast all shop primers to SSPC-SP10 Near White Blast (Sa2½). Remove weld spatter. Grind weld seams. Round all sharp edges. Blast all damaged areas and weld seams to SSPC-SP10 Near White Blast (Sa2½).

Major refurbishment: Near White Metal Blast SSPC-SP10 Near White Blast (Sa2½) is recommended. Commercial Blast SSPC-SP6 (Sa2) is acceptable in many areas, consult Blue Water for recommendations. If oxidation has occurs between blasting and painting, reblasting is required.

Maintenance and Repair: High pressure water wash using 3000 psi minimum to remove all contamination. Commercial Blast SSPC-SP6 (Sa2) bare steel or damaged areas. Repair any defect revealed after the blast. If oxidation has occurs between blasting and painting, reblasting is required.

Recoating: Within recoat times wash surface to remove all contaminants and overcoat.

Application data:

Application: Apply by airless spray. Application by brush or roller will require multiple coats. . Strain material with a 60 mesh screen. Apply 6.2 mils wet to yield 5 mils dry film thickness.

Mixing: Two part paint must be mixed before application. Power mix each part before mixing together. Always mix full containers to insure proper mix ratio of 4:1. Induction time is 30 minutes. Use within pot life

Thinning: Paint is supplied at spray viscosity. If thinning is necessary, add 5% of thinner by volume. Use THINNER 973 for external applications and THINNER 976 for internal applications

Airless Spray: Airless spray is recommended.

- Pump size is 30:1 or greater
- Tip size is 19 - 27 thou.
- Output fluid pressure at spray tip 3000 psi
- Hose size is 3/8" ID
- Filter is 60 mesh
- Use water separator in line
- Conventional Spray: Conventional spray is not recommended.

Brush: Brush use is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.

Roller: Roller use is recommended for small areas only. Multiple coats may be required to achieve specified film thickness. Use 3/8" medium nap roller cover.

Cleaner: THINNER 973

Cleanup: Flush all equipment with THINNER 973. Filter material prior to use. Flush spray equipment during heavy use. Do not exceed pot life of paint. Dispose of paint cans in accordance with local regulations. Do not re-seal containers of mixed paint. Close lid thoroughly for storage.

Safety: Refer to Material Safety Data Sheet (MSDS) for this product. The MSDS will provide all necessary data on health hazards, conditions to avoid, proper storage, disposal information, hazardous ingredients and health related characteristics.

Limitations:

Performance of the product is dependent upon the specified film thickness being achieved. Over coating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Apply in good weather. Temperature of the surface to be coated must be at least 5°F above the dew point. Bring paint to 75°F prior to mixing and application. Store unused paint in a closed pail. Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

Unit size:

- **Five gallon kit:** Base contains 4 gallons in a 5 gallon pail. Reactor contains 1 gallon in a 1 gallon can. Weight is 70 pounds.
- **One gallon kit:** Base contains 0.8 gallons in a 1 gallon can. Reactor contains 0.8 quarts in a 1 quart can. Weight is 14 pounds.

Shelf life: 12 months from the date of manufacture when stored in a protected location at 40-100°F

Office:

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Note: Data sheet information is not intended to be exhaustive. Use of this product for any purpose other than as specified without written confirmation from Blue Water does so at their own risk. Factors outside of Blue Water control may affect the performance of this product. Blue Water does not accept any liability for the performance of this product or any loss or damage caused by the use of this product. Information in this data sheet is subject to change. User is responsible for securing the most updated data sheet prior to use of this product. All product names mentioned in this data sheet are trademarked by Blue Water Marine.