

## PRODUCT DATASHEET

**8518**

REV 4/2013

**GENERIC TYPE:** AMINE CURED 100% SOLIDS EPOXY TOPCOAT

**DESCRIPTION AND RECOMMENDED USES:** 8518 is a solvent free, ceramic filled high functionality epoxy Novolac coating suitable for immersion and non-immersion service, particularly in aggressive acid and alkali environments with elevated temperatures and/or abrasion. 8518 produces a tough, chemical resistant coating on ferrous and non-ferrous metals and concrete. Use of Reactive Flexibilizing agents gives excellent flexibility without sacrificing chemical & temperature resistance making 8518 ideal for large tank walls & floors without needing fiberglass mat. As a low viscosity epoxy Novolac 8518 is suitable for hand or spray application at up to 80 mils per coat.

### FOR INDUSTRIAL USE ONLY

### SPECIFICATION DATA

**TEMPERATURE:** Immersion service  
Max. 265°F (130°C); Spike to 400°F (204°C) (3 Hrs).  
Recommended force cure 120°F @ 8 hrs.

**CHEMICAL RESISTANCE:**

Water: Excellent  
Alkalies: Excellent  
Inorganic Acids: Excellent  
Organic Acids: Excellent  
Organic Solvents: Excellent

**ABRASION:** Very Good

**FILM THICKNESS:** 20 -80 mils (.51-2.04 mm)/coat

Splash: 2 coats, Immersion: 2-3 coats

**Flexibility:** Very Good  
Excellent with Polyester Mat; 1.5 oz/ft<sup>2</sup> (.5 KG/M<sup>2</sup>)

**APPLICATIONS:** Aggressive Chemical Tank Linings and Secondary Containment Areas, FGD; Ducts, Mix Zones, I.D. Fans, Scrubbers. Excellent when force cure is not available.

**SOLIDS BY VOLUME:** 100%

**VISCOSITY:** 40,000-65,000 cps

**POT LIFE:** 25 MIN/KG @ 72°F

**MIX RATIO:** 1:1 by Volume (Base:Activator)  
100 gm: 116 gm by weight

**COLOR:** Gray

**SHELF LIFE:** 5 Years at 55-95°F (13-35°C)

**COVERAGE:** 35 SF @ 20 mils / KG

**WEIGHT PER GALLON:** 10.2 lbs (4.62 KG)

**ORDER INFORMATION:** To place orders and/or obtain pricing information contact:

ARCOR Epoxy Inc  
PO Box 273  
So. Dennis MA 02660  
Tel: 800-878-9593 / Fax: 888-878-9593

Manufacturer makes no warranty either expressed or implied including warranties of merchantability or fitness for a particular purpose for this product. Under no circumstances will the manufacturer be liable for incidental, consequential or other damages, breach of warranty, strict liability, or any other theory arising out of use of this product.

# APPLICATION SHEET

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**SEE MATERIAL SAFETY DATA SHEET BEFORE HANDLING THIS PRODUCT**

**SURFACE PREPARATION:**

Steel surfaces are to be abrasive blasted with chloride free abrasive. Exterior applications to SSPC SP-10 Near White metal finish. Immersion applications to SSPC SP-5 White metal 3 to 5 mil profile. Grind flat all burrs, weld seams, radius sharp edges.

Concrete surfaces should be degreased if oil and grease contamination is present. Degreased surface shall be high pressure washed, acid etched and high pressure washed again so surface is clean and free of all grease, oils and surface laitance. Existing coatings should be abrasive blasted to clean concrete.

**MIXING:**

Thoroughly mix Activator into Base with mixing stick or drill with low speed mixing blade scraping sides and bottom of container or mixing board. Mix by Volume 1 parts Base to 1 part Activator. Or by weight 100 grams base to 116 grams activator. Mix thoroughly to produce an even colored and streak-free material.

**THINNING:** Never thin.

**APPLICATION:**

Brush: medium to stiff bristle of sufficient quality that bristles do not pull out and stick in coating. Trim or tape to <1" nap.

Roller: good quality 1/8" nap.

Plural Spray: .029-.035 tip, 3,500-4,500 PSI, Heat to 150°F Base, 100°F Activator. Use 30 mesh screens. Heated hose @ 120-140°F.

Airless Spray: .029-.035 tip, 4,000-4,500 PSI(45:1). Use only with in-line heater at 120° to 140°F.(Caution: Short Pot-Life)

Conventional Spray: Not Recommended.

All spray equipment should employ traps to prevent water and oil from contaminating coating and 30 mesh screens to prevent particulate contamination.

**APPLICATION TEMPERATURE:**

Material: Keep between 55 to 95°F(17 to 35°C). Substrate: Keep between 45 to 105°F(7 to 40°C). The difference in temperature of the substrate and the material should never exceed 10°F(5°C). Substrate shall be a minimum of 5°F(3°C) above dew point. Do not apply if relative humidity exceeds 90%. If necessary heat metal prior to surface preparation using electric heater or heat lamp. Never use gas, oil or kerosene heaters as they will leave a greasy residue on metal surface. For best results keep all material in warm area overnight(75°F+, 24°C) for ease of mixing. If necessary base component of material can be heated by microwave for 30-45 seconds for a 1 KG Base unit or by warm water bath. Heat activator by warm water bath only. If necessary let material cool before application.

**OVERCOAT/CURE TIME:** By brush, roller or squeegee recoat while material is still soft, but tack-free, between 6-14 hours at 77°F(25°C). If overcoat window is exceeded abrade surface with course sandpaper, grinder or brush blast. By spray application recoat between 2-14 hours at 77°F. Full cure before immersion 72 hours at 77°F. Add 30 hours additional cure time for each 10°F below 77°F. Subtract 12 hours of cure time for each 10°F above 77°F. Force Cure with heat for best performance for 4 hours at 200°F(93°C), 12 hours at 150°F( 66°C).

**CLEAN UP:** Clean tools immediately after use with M.E.K. or similar. Isopropyl Alcohol can be used in solvent restricted areas.

**WARNING:** Base contains epoxy resin. Activator contains alkaline amines, a strong sensitizer. May cause skin irritation, sensitization or other allergic responses. Use with good ventilation, particularly if heated or sprayed. Prevent all contact with skin or eyes. Wear protective clothing, goggles, gloves or barrier creams. Keep containers closed when not in use. Wash thoroughly after handling. In case of skin contact immediately wash with soap and water. In case of eye contact, flush with water for 15 minutes. If irritation persists seek medical attention.