



# CHEMALINE # 250

## General Description:

CHEMALINE # 250 is a two-component amine adducts cured epoxy paints, especially formulated for chemically resistant tank linings and coatings.

## Major Uses:

Proven as a tank lining for sewage trenches, pipes and tanks, reservoir, grain silos and other applications subjected to corrosion and abrasion.

## Advantages:

- Excellent chemical resistance.
- Excellent adhesion.
- Equally efficient on concrete and metal
- Tough abrasion resistant film.
- Excellent immersion properties.
- Long maintenance – free life.
- Easy to apply.

## Characteristics and Physical Properties:

Colour	As per RAL Colour Card
Volume solids	100%
Specific weight	1.3 – 1.5 kg/L
Mixing ratio	2 : 1
Flash point	>65°C
Drying time @ 25°C	
Pot life	15 – 20 min.
Touch dry	6 hours
Hard dry	24 hours
Recoat	8 – 10 hours
Fully cured	7 days
Coverage	5 m <sup>2</sup> /L
DFT	200 microns
WFT	200 microns
Shelf life	12 months

## Chemical Resistance:

### Test Result as per ASTM D 1308

Water, de – ionized	Excellent
Sea Water	Excellent
Sodium Chloride, 20%	Very Good
Crude Oil	Excellent
Flash point	>65°C
Hydrochloric Acid, 10%	Very Good
Nitric Acid, 3%	Excellent
Acetic Acid, 10%	Good
Ethanol, 50%	Slightly soft
Xylene	Good
Citric Acid, 30%	Excellent

## Surface Preparation:

### Steel:

- Remove oil or grease from surface to be coated with Thinner or MAS degreaser in accordance with SSPC – SP 1.
- For mild environments Hand Tool or Power Tool Clean in accordance with SSPC – SP 2, SSPC – SP 3 or SSPC – SP 11 to produce rust – scale free surface.
- For more severe environments, abrasive blast to a Commercial Finish in accordance with SSPC – SP 6 and obtain a 1 ½ - 3 mil (40 – 75 micron) blast profile.
- For immersion service, abrasive blast to a Near White Metal Finish in accordance with SSPC – SP 10 and obtain a 1 ½ - 3 mil (40 – 75 micron) blast profile.

### Concrete:

Concrete and masonry surfaces should be clean, dry and free from loose debris and laitance. Apply 1 coat of multi etch solution, let it dry prior to the application of CHEMALINE # 250.

## Mixing and Application:

The content of each material should be thoroughly stirred particularly the base resin to disperse any possible settlement. Materials are supplied pre – weighed and the entire hardener should be mixed into the base material thoroughly until homogenous solution and uniform colour consistency is obtained.

Mechanical mixing using power drill with suitable flat paddle is preferred for 3–5 minutes. CHEMALINE # 250 can be applied by brush or roller.

The first coat should be firmly applied and scrubbed well into the surface ensuring a continuous and uniform thickness.

## Thinning:

For spray application may be thinned up to 13 oz./gal. with Thinner #135. For hot and windy conditions, or for brush and roller application, may be thinned up to 16 oz./gal. with Thinner # 135.

Use of thinners other than those supplied by MAS Paint may adversely affect product performance and void product warranty, whether express or implied.

## Application Conditions:

Do not apply or cure the material when the surface temperature is less than 3°C above the dew point.

Special thinning and application techniques may be required above or below normal conditions.

*The above information is given to the best of our knowledge based on laboratory test and practical experience. However, as the paint is often used under condition beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without prior notice.*

## MAS PAINTS & CHEMICAL INDUSTRY

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### **SPRAY:**

This is medium solids coatings and may require slight adjustments in spray techniques. Wet film thicknesses are easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, De Vilbiss and Graco.

### **CONVENTIONAL:**

Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.

### **AIRLESS:**

GPM Output	: 3.0 (min.)
Material Hose	: 3/8" I.D. (min.)
Tip Size	: 0.017 - 0.021
Output (psi)	: 2100-2300
Filter Size	: 60 mesh.

### **BRUSH OR ROLLER:**

Use medium bristle brush, or good quality short nap roller. Avoid excessive rebrushing and rerolling. Two to three coats may be required to obtain desired appearance, hiding and recommended DFT. For best results, tie – in within 10minutes at 24°C.

### **Drying Time:**

These times are based on 100 microns dry film thickness. Higher film thicknesses, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze or blush. Any haze or blush must be removed by water washing before recoating. During high humidity conditions, it is recommended that the application be done while temperatures are increasing. For best results over "damp" surfaces, apply by brush or roller.

### **Repairing and Overcoating:**

Areas, which have been previously coated with CHEMALINE # 250 and subsequently damaged, can be readily over coated. The existing coated surface must be well abraded, using sand blasting or wet applied abrasive paper, to ensure a good bond. Overcoating may then be carried out as for new work.

### **NOTE:**

Although CHEMALINE # 250 may be applied at temperatures down to 10°C, the curing time increases significantly in the lower ranges. For cold weather working, it is recommended that materials are stored in a heated building and only removed immediately before use. Accelerated heating methods must not be used.

### **Storage:**

Keep resins and hardeners in a cool, dry place, out of direct sunlight and protected from extreme temperatures. Shelf life is up to one year in a close container.

### **Cleaning of Tools:**

All tools should be cleaned with Wash Thinner or Epoxy Thinner # 135 as soon as possible.

### **Packing:**

Available in 4 lit. Set and 20 lit. Set.

### **Precautions:**

#### **Health and Safety:**

Some people are sensitive to epoxy resins so gloves and a barrier cream, Kerodex 71, Rozalex 9, Debba – Wet work or similar should be used when handling these products. If contact with resin occurs, it must be removed, before it hardens, with a resin removing cream such as Kerocleanse 22, and Rozalex 42. Follow by washing with soap and water. Do not use solvent.

The use of goggles is recommended but should accidental eye contamination occur, wash thoroughly with plenty of water and seek medical treatment immediately. Ensure good ventilation and do not smoke during use.

#### **Fire:**

CHEMALINE # 250 is not flammable. However, adequate ventilation when using primers and solvents. Do not smoke during use and do not use in the vicinity of a naked flame.

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