

## Surface Preparation

Proper surface preparation is critical to the long-term performance of this product. The exact requirements for surface preparation vary with the severity of the application, expected service life, and the initial substrate conditions.

All sharp edges and welds shall be ground smooth or to a 3 mm (120 mil) radius before abrasive blasting. Optimum preparation will provide a surface thoroughly cleaned of all contaminants and roughened to an angular profile between 75-125 µm (3-5 mil). This is normally achieved by initial cleaning and degreasing and then abrasive blasting to a cleanliness of *White Metal (Sa 3/SP5)* or *Near White Metal (Sa 2.5/SP10)*, followed by removal of residual abrasive blast residues from the surface to be coated.

## Mixing

To facilitate mixing and application, material temperatures should be between 21°- 35°C (70°-95°F). Each kit is packaged to the proper mix ratio. If further proportioning is required, the kit should be divided according to the mix ratios:

Mix Ratio	By Weight	Volume
A : B	1.9 : 1	2.0 : 1

Prior to mixing ARC S4+(E), pre-mix Part B to suspend any settled reinforcements. When mixing by hand, add Part B to Part A. Mix until product is uniform in color and consistency, with no streaks. Power mixing should be accomplished with a variable speed, high torque, and low speed mixer with a non-air entraining mix blade such as a "Jiffy" blade. Do not mix more product than can be applied within the stated working time.

## Working Time – Minutes

	16°C	25°C	32°C	This chart defines the practical working time of ARC S4+(E), starting from when mixing begins.
	60°F	77°F	90°F	
16 liters	25 min.	20 min.	15 min.	

## Application

ARC S4+(E) may be applied by spray system, brush, or roller using a lint free short nap roller such as mohair. When applying ARC S4+(E) the following conditions should be observed: Film thickness range per coat should be from: 375 µm (15 mil) to 500 µm (20 mil). ARC S4+(E) is normally applied in a minimum of two coats in alternate colors. Application temperature range should be between 16°C (60°F) - 35°C (100°F). ARC S4+(E) may be spray applied by airless spray equipment without solvent dilution; consult ARC Technical Bulletin 006 for equipment guidelines. If using 1125 ml cartridge preheat cartridge to 60°C (140°F) prior to inserting in SULZER MIXPAC® gun. Adjust atomizing and feed air as required to achieve desired spray pattern.

When spraying, apply initial pass at 75 -125 µm (3-5 mil). Build successive passes to achieve the first coat recommended thickness. Vertical or overhead applications may result in reduced film thickness. To compensate additional coats may be required.

Multiple coat applications of ARC S4+(E) may be accomplished, without additional surface preparation, as long as the film is free of contamination and has not cured beyond the stage stated as Overcoat End in the Curing Schedule chart below. If this period is exceeded, light abrasive blasting or sanding is required to be followed by removal of any abrasive residues. Prior to its light load cure state, ARC S4+(E) may be overcoated with any of the ARC epoxy materials with the exception of ARC vinyl ester based coatings.

Thickness	Unit size	Coverage
375 µm (15 mil)	1125 ml Cartridge	3.00 m <sup>2</sup> (32.30 ft <sup>2</sup> )
	16 liters	42.70 m <sup>2</sup> (459.30 ft <sup>2</sup> )

## Curing Schedule

	16°C	25°C	32°C	Full chemical properties can be achieved rapidly by force curing. To force cure, first allow the material to become tack free, then heat to 65°C (150°F) for a minimum of 12 hours. Curing at elevated temperatures improves the chemical and thermal resistance of ARC S4+(E).
	60°F	77°F	90°F	
<b>Tack Free</b>	10 hrs.	8 hrs.	5 hrs.	
<b>Light Load</b>	24 hrs.	18 hrs.	13 hrs.	
<b>Overcoat End</b>	28 hrs.	21 hrs.	15 hrs.	
<b>Full Load</b>	52 hrs.	44 hrs.	38 hrs.	
<b>Full Chemical</b>	300 hrs.	250 hrs.	200 hrs.	

## Clean Up

Use commercial solvents (Acetone, Xylene, Alcohol, Methyl Ethyl Ketone) to clean tools immediately after use. Once cured, the material would have to be abraded off.

## Safety

Before using any products, review the appropriate Safety Data Sheet (SDS) or Safety Sheet for your area. Follow standard confined space entry and work procedures, if appropriate.

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