



TECHNICAL DATA

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CR 5000 GLASS FLAKE FILLED EPOXY

Product Description

A high performance, high density, glass flake filled epoxy to seal and protect new or repaired surfaces from cavitation, erosion and wear.

Features

- Low viscosity achieves 100% contact with surface.
- Easily applied using a brush, roller or squeegee.
- Excellent chemical resistance to concentrated acids.

Recommended Uses

- Protect pump casings, impeller blades, gate valves, water boxes and fan blades.
- Rebuild heat exchangers, tube sheets and other circulating water equipment.
- As a topcoat on repaired surfaces to provide an exceptionally smooth surface.

Chemical Resistance

Sodium Hypochlorite 5%	E	Sodium Hydroxide 50%	E
Trisodium Phosphate	E	Aluminum Sulfate 5%	E
Sulfuric Acid 10%	VG	Ferric Chloride	E
Sulfuric Acid 50%	VG	Acetic Acid 10%	U
Hydrochloric Acid 10%	VG	Water	E
Nitric Acid 10%	F	Saturated Salt Solution	VG
Nitric Acid 40%	F	Leaded Gasoline	VG
Phosphoric Acid 10%	F	Mineral Spirits	VG
Phosphoric Acid 40%	F	Propylene Glycol	VG
Sodium Hydroxide 10%	E	ASTM #3 Oil	VG

E = Excellent VG = Very Good U = Unsatisfactory

- 7 day room temperature cure, 30 day immersion @ 75°F.

Typical Properties

Solids by Volume	100%
Volatile Organic Compounds	0.0 lb/gal (0 g/l)
Theoretical Coverage	1604 ft ² /gal @ 1 mil
Recommend DFT	30 mils
Number of Coats	2 or more
Mix Ratio (by volume)	1 Hardener : 3 Resin
Mixed Viscosity	10000 cps
Shelf Life @ 60-90°F (16-32°C)	Part A months Part B months
Temperature Resistance	140°F (dry)
Color	White

Specification Data

Adhesive Tensile Shear ASTM D 1002	2000 psi
Cured Hardness ASTM D 2240	87 Shore D
Dielectric Strength ASTM D 149	382 volts/mil

Ordering Information

Packaging:	1 gal kit
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APPLICATION INFORMATION

CR 5000

Surface Preparation

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

Preferred: Abrasive blast to a White Metal Blast in accordance with SSPC-SP 5 and obtain a 2-4 mil (50-100 μ) angular anchor pattern.

Note: For equipment that has been handling sea water or other salt solutions a test for chloride contamination should be performed prior to application. If chlorides are present at 40 ppm or greater the substrate shall be re-cleaned until the chlorides are less than 40 ppm.

Mixing

Material is formulated to be easily brush or roll onto prepared surfaces using a short bristle brush or roller.

Add 1 part hardener to 3 parts resin and power mix thoroughly for about 4 minutes or until a uniform consistency is achieved, being careful to mix material from bottom and sides of the container.

It is strongly recommended that only full kits be mixed. If less than full kits use the following ratio by volume:

- 1 part hardener to 3 parts resin

Thinning

DO NOT THIN

Pot Life

Material Temperature	Time
75°F (24°C)	45 minutes

Application Conditions

	Normal	Minimum	Maximum
Material	75-90°F (24-32°C)	55°F (13°C)	90°F (32°C)
Surface	75-90°F (24-32°C)	55°F (13°C)	90°F (32°C)
Ambient	75-90°F (24-32°C)	55°F (10°C)	90°F (32°C)
Humidity	30-50%	0%	85%

- Surface temperature must be 5°F (3°C) above the dew point.

Application

For best results material should be kept and applied at room temperature.

Material should be applied by brush or roller in a minimum of 2 coats to achieved desired thickness.

For spray application contact ITW Futura Coatings.

Use MEK or similar solvent for clean up.

Cure Time

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

Surface Temperature

75°F

Working Time	45 minutes
Tack Free	6 hours
Recoat (min)	8 hours
Recoat (max)	16 hours
Functional Cure	20 hours
Full cure	36 hours
Chemical Exposure	6 days

- If the material has exceeded its maximum recoat time or full cure time contact ITW Futura Coatings for recommended recoating procedures.
- Curing can be accelerated by using heat after the coating has been allowed to harden under ambient conditions. At 150°F material will cure in 4 hours.
- Holiday testing per NACE RP0188-99 should be conducted for all coatings going into immersion service. Use a setting of 100 volts/mil. All pinholes must be marked and repaired.

Safety Information

- Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information.
- Do not apply material in enclosed areas without adequate air exchange and ventilation.
- All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods.
- Wear protective clothing, gloves and eye protection.
- Breathing fumes or contact with the skin may cause severe allergic reactions.
- **This product is intended for industrial use by properly trained professional applicators only.**

Storage Conditions

- Coatings need to be protected from moisture contamination. Store drums and pails in a dry location at 55-90°F (13-32°C).
- Materials **must** be kept above 55°F (13°C).

ITW FUTURA COATINGS, 1685 GALT INDUSTRIAL BLVD., ST LOUIS, MO, (314) 733-1110

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