



TECHNICAL DATA

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FLEXSHIELD 4467 COAL TAR EPOXY

Product Description

A two component coal tar epoxy with exceedingly high moisture resistance. It may be applied directly to properly prepared surfaces or recommended primers and is formulated for areas subject to immersion.

Features

- Easily applied using airless spray.
- Excellent in immersion service.

Recommended Uses

- Interior of water tanks.
- Sewage plants
- Offshore platforms
- Buried tanks
- Piping

Typical Properties

Solids by Volume	75% ± 2
Volatile Organic Compounds	1.75 lb/gal (216 g/l)
Theoretical Coverage	1203 ft ² /gal @ 1 mil
Recommend DFT (per coat)	10 mils
Number of Coats	2 or more
Mix Ratio (by volume)	4 Base : 1 activator
Shelf Life @ 60-90°F (16-32°C)	Part A months Part B months
Color	Black

Ordering Information

Packaging:	1 gal & 5 gal kits
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APPLICATION INFORMATION FLEXSHIELD 4467

Surface Preparation

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

Steel - Immersion: 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.

Steel – Non-Immersion: Abrasive blast to a Commercial Blast in accordance with SSPC-SP 6 and obtain a 2-4 mil (50-100 μ) angular anchor pattern.

Other: Contact ITW Futura Coatings for recommendations.

Mixing

Using a power mixer thoroughly mix the base prior to the addition of the activator. While still mixing the base slowly add the activator and power mix thoroughly for about 3-4 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:

- 4 parts base to 1 parts activator

An induction time of 30 minutes @ 75°F is required after mixing.

Thinning

DO NOT THIN

Pot Life

Material Temperature	Time
75°F (24°C)	3 hours

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)	50°F (10°C)	100°F (38°C)
Ambient	75-90°F (24-32°C)	50°F (10°C)	100°F (38°C)
Humidity	30-50%	0%	85%

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

Application Equipment

Airless:

Pump Ratio	30:1 min	Tip Size	.020-.030"
Material Hose*	3/8" ID min 100' max	Tip Pressure psi	2600-3000

Brush (For small touch-up areas only): Use a high quality brush suitable for use with solvent based coatings.

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
Recoat (min)	4 hours
Recoat (max)	3 days
Full cure	7 days

- If the material has exceeded its maximum recoat time or full cure time contact ITW Futura Coatings for recommended recoating procedures.

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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