



SELECTION & SPECIFICATION DATA

Generic Type	Solvent free aromatic polyurethane, ASTM D16 Type V
Description	Polyclad 767 Fast-Set Plus is a high performance pipe coating specially designed for the protection of pipeline interiors. Typical applications are pipeline interiors for water transmission, wastewater treatment (municipal and industrial), and interior tank linings.
Features	<ul style="list-style-type: none"> • Fast curing rate increases throughput • Superior wetting properties result in better edge retention and excellent adhesion to steel • Mix ratio of 1:1 and user friendly application properties • Unlimited build with single multi-pass coats • Approved for potable water use • Self priming (120 mil maximum for potable water) • Meets AWWA C222
Color	0100 (Blue), 0700 (grey)
Finish	Gloss
Primer	None needed - direct to steel
Dry Film Thickness	20 - 120 mils (508 - 3048 microns) per coat
Solids Content	By Volume 100% +/- 1%
Theoretical Coverage Rate	1604 ft ² /gal at 1.0 mils (39.4 m ² /l at 25 microns) 80 ft ² /gal at 20.0 mils (2.0 m ² /l at 500 microns) 13 ft ² /gal at 120.0 mils (0.3 m ² /l at 3000 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : <0.04 lbs/gal (5 g/L)* *Calculated value
Limitations	Due to its aromatic composition Polyclad 767 Fast-Set Plus will tend to yellow or darken in exterior UV exposure. This will not affect performance.

SUBSTRATES & SURFACE PREPARATION

General	All surfaces must be clean, dry and free of oil, grease, loose mill scale, dirt, dust or other materials which would impair the bond of the coating to the substrate.
Steel	<ul style="list-style-type: none"> • Remove dirt/dust/grease/oil following SSPC-SP1 • Abrasive blast to SSPC-SP10 • Achieve a minimum 3.0 mil “angular” anchor profile • Ensure dust/smut from blasting operation does not interfere with adhesion • Apply Polyclad 767 Fast-Set Plus prior to any flash rusting or contamination fall-out

Polyclad 767 Fast-Set Plus

PRODUCT DATA SHEET



PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	System	Results
Abrasion Resistance ASTM D4060	Polyclad 767 Fast-Set Plus	58 mg loss
Adhesion to Steel ASTM D4541	Polyclad 767 Fast-Set Plus	Minimum 1500 psi
Cathodic Disbondment ASTM G-95	Polyclad 767 Fast-Set Plus	<8 mm
Dielectric Strength ASTM D149	Polyclad 767 Fast-Set Plus	>700 V/mil
Flexibility ASTM D522	Polyclad 767 Fast-Set Plus	PASS 3 inch
Hardness ASTM D2240 Shore D	Polyclad 767 Fast-Set Plus	> 70 Shore D
Impact Resistance ASTM G14	Polyclad 767 Fast-Set Plus	100 in-lbs
Water Absorption ASTM D570	Polyclad 767 Fast-Set Plus	<1.3%
Wet Adhesion ASTM D870	Polyclad 767 Fast-Set Plus	PASS

MIXING & THINNING

Mixing | General Mixing Guidelines: Power mix Part A & B separately until the pigments are dispersed in to a homogenous liquid. DO NOT BATCH MIX A & B.

Ratio | 1:1 by volume

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General) | Applicators must be knowledgeable with the proper safety guidelines, operation and maintenance of the spray equipment - pumps, hoses, heaters, spray gun.

Airless Spray | Use only heated plural component airless equipment.
Plural airless pump must have 1:1 ratio capability along with 1.25 gallons per minute with fluid pressure up to 3000 psi.
Paint system set up should transfer coatings from heated drums to the proportioners and maintain heated material to the spray tips.
Contact Carboline Technical Service for specifics.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	130°F (54°C)	45°F (7°C)	35°F (2°C)	0%
Maximum	150°F (66°C)	120°F (49°C)	120°F (49°C)	85%

Maximum recoat time is 2 hours. Abrade surface and wipe clean for application beyond maximum recoat window. Polyclad 767 Fast-Set Plus is ready for holiday testing when it reaches dry to handle state. Industry standards are for substrate temperatures to be 5 °F (3 °C) above the dew point.

Caution: This product in the liquid stage is moisture sensitive and needs to be protected from high humidity, dew and direct moisture contact until cured to a firm state. Application and/or curing in humidity above maximum, or exposure to moisture from rain or dew may result in a loss of gloss, micro bubbling, and/or blistering of the product.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Touch
75°F (24°C)	7 Minutes	75 Seconds

CLEANUP & SAFETY

Cleanup	Use Thinner 2 or 76. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation. Keep container closed when not in use.
Caution	This product does not contain flammable solvents, however, clean-up solvents that may be used do contain flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and rounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

TESTING / CERTIFICATION / LISTING

Potable Water Certifications	<p>Potable Water Use Limitations @ 75°F (24°C): <i>Meets drinking water criteria of NSF/ANSI/CAN 600</i> Max DFT: 120 mils (3048 microns) # Coats: 1 Tank Rating: >1,000 gal (3785.41 Liters) Pipe Rating: 12" or larger (30.48 cm) Valve Rating: 12" or larger (30.48 cm) Thinning: N/A 2 Day Cure Required before service Approved Colors: 0300 (Green), 0700 (Grey), 0100 (Blue)</p>
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PACKAGING, HANDLING & STORAGE

Shelf Life	<p>Part A or B: 12 months</p> <p>Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.</p>
Storage Temperature & Humidity	<p>40-110 °F (4-43 °C) 0-100% Relative Humidity</p>
Storage	<p>Store indoors and keep dry. Blanket all partial drums with nitrogen gas to prevent moisture contamination. Avoid freezing. Do not open until ready to use.</p>
Shipping Weight (Approximate)	<ul style="list-style-type: none"> • 10 gal unit: 101 lbs • 110 gal unit: 1,135 lbs • 528 gal unit: 5,207 lbs • Part A (ISO): Red color containers • Part B (Resin): White color containers
Flash Point (Setaflash)	<ul style="list-style-type: none"> • Part A: >350 °F (>176 °C) • Part B: 330 °F (165 °C)

Polyclad 767 Fast-Set Plus

PRODUCT DATA SHEET



WARRANTY

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