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Effective Date: September 4, 2014 Rev. 1

SP-9888[®] GROUT AND SEALING COMPOUND

APPLICATION SPECIFICATION / STEEL SUBSTRATE

I. GENERAL

- 1.1 SP-9888[®] Grout and Sealing Compound is a solvent-free, no VOCs, 100% solids two-component epoxy / amine cured polymer manufactured and marketed by **Specialty Polymer Coatings, Inc.** (“SPC”), #101 - 20529 - 62nd Avenue, Langley, B.C., Canada, V3A 8R4, Telephone: (604) 514-9711, Fax: (604) 514-9722.
- 1.2 SP-9888[®] Grout and Sealing Compound is to be applied by SPC approved applicators.
- 1.3 This specification covers only application of the material by brush, roller, trowel, or gloved hand.
- 1.4 Mixing Ratio: 1 Part Base to 1 Part Hardener (pre-measured) by volume.
- 1.5 Mixed Colour: Grey.

II. PACKAGING

- 2.1
 1. Part “A” – Base: 1 Part of Base (pre-measured) by volume.
 2. Part “B” – Hardener: 1 Part of Hardener (pre-measured) by volume.



SP-9888[®] GROUT AND SEALING COMPOUND

APPLICATION SPECIFICATION / STEEL SUBSTRATE

III. MIXING INSTRUCTIONS

- 3.1 Pre-mix Part "A" (Base) slowly with a variable speed drill fitted with a mixing impeller. SPC mixing impellers assist in preventing the introduction of air into the coating and help to ensure a uniform mix.
- 3.2 Pour Part "B" (Hardener) into Part "A" (Base). The temperature of the coating components should be above 15°C (59°F) to enhance mixing. Care must be taken to ensure that only Base and Hardener with the same colour coded dots (shown on the container lids) are mixed together. The coloured dots on the container lids are also used to identify the kit sizes. Only mix Base and Hardener identified by the same kit size.
- 3.3 Begin mixing slowly. After the initial mix has been achieved, a spatula or mixing stick should be used to remove any raw resin from the side of the container.
- 3.4 Mix at a speed that ensures a uniform mix, but does not create a vortex in the liquid. Slow the mixer down at the surface of the liquid to prevent the introduction of air into the coating.
- 3.5 The ideal mixing and application temperature is between 20°C (68°F) and 35°C (95°F).
- 3.6 Mix for two (2) minutes at temperatures between 15°C (59°F) and 20°C (68°F), blending both parts to create one solid colour. If Part "A" (Base) is at a temperature between 20°C (68°F) and 35°C (95°F), mix for 30 seconds to one (1) minute. Do not attempt to mix and apply SP-9888[®] Grout and Sealing Compound if Part "A" (Base) is below 15°C (59°F).
- 3.7 Application may be done at this time by brushing, rolling, with a gloved hand or trowel. When coating pipe, do not remove application instruments from the bottom of the pipe. Always remove instruments on the up-stroke to prevent pulling material down and off the pipe bottom.

IV. POT LIFE

- 4.1 Workable pot life after mixing is 60 minutes at 25°C (77°F). Pot life will be extended at lower temperatures and shortened at higher temperatures.



SP-9888[®] GROUT AND SEALING COMPOUND

APPLICATION SPECIFICATION / STEEL SUBSTRATE

V. SURFACE PREPARATION

- 5.1 All surfaces to be coated shall be abrasive blasted to NACE 2, SSPC SP-10 (Near White) cleanliness or equivalent. The resulting surface roughness profile shall be a minimum of 62.5 microns (2.5 mils) and a maximum of 125 microns (5.0 mils) peak to valley.
- 5.2 The underside and narrow edges of all angles, weld beads, pits and structural members must be blasted to the same surface condition as specified in Section 5.1. All surfaces must be cleaned of all blasting products, leaving no trapped particles or traces when blasting is completed.
- 5.3 All surfaces to be coated must be completely dry, free of moisture, soil, dust and abrasive material at the time the coating is applied. All weld spatters must be removed from the surface and rough welds must be ground smooth prior to coating.
- 5.4 Only that area that can be coated in a particular day shall be blast-cleaned. Blast-cleaning shall extend for at least 152 mm (6 in.) past the end of the coated area. Any area that is allowed to sit overnight must be returned to its original blast-cleaned condition. This requirement also applies to any blast-cleaned surface that has flash rusted as a result of exposure to water or moisture.
- 5.5 If the coating operation is past the maximum re-coat window [24 Hours at 25°C (77°F)], the edges of the area coated with SP-9888[®] Grout and Sealing Compound are to be feathered down to the steel substrate after the coating has cured and before resumption of coating.
- 5.6 Blasting adjacent to freshly coated steel shall not commence until the SP-9888[®] Grout and Sealing Compound has cured to a tack-free condition. All blasting onto existing SP-9888[®] Grout and Sealing Compound must be directed from the coated surface to the adjacent substrate rather than from the substrate onto the coating. The blasting should be initiated 150 mm (6 in.) onto the coating.
- 5.7 Prior to coating, all areas, including the floor, scaffolding, walkways and decks within 15 m (50 ft.) of the coating site, shall be swept or cleaned of abrasive products to prevent air blown contamination of the coating surface.
- 5.8 Wetting of the ground in the vicinity of the coating operation may be necessary on new construction sites with bare ground and where high winds may occur.



SP-9888[®] GROUT AND SEALING COMPOUND

APPLICATION SPECIFICATION / STEEL SUBSTRATE

VI. APPLICATION

- 6.1 Disposable tools such as brushes or short nap mohair rollers (available from SPC) should be used to apply SP-9888[®] Grout and Sealing Compound.
- 6.2 Application may also be done using a gloved hand. Consult with the glove manufacture to determine the proper glove type. Refer to Section VIII Safety Precautions.
- 6.3 A maximum Dry Film Thickness (DFT) of 13 mm (520 mils) can be applied to a vertical surface in a single application. Higher builds are possible on horizontal surfaces.
- 6.4 SP-9888[®] Grout and Sealing Compound can be applied directly to the prepared surface without the need for additional priming systems.
- 6.5 SP-9888[®] Grout and Sealing Compound must be applied to clean, dry surfaces only. Condensation, precipitation, water vapour or any other forms of contamination will **NOT** be acceptable on the blasted surface prior to coating. Surfaces subject to any of these conditions shall be cleaned with fresh water if necessary and re-blasted to return the surface to SSPC SP-10 Cleanliness as per Section V.
- 6.6 The acceptable substrate temperature range for application of SP-9888[®] Grout and Sealing Compound is 10°C (50°F) to 50°C (122°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature before proceeding with the coating operation.
- 6.7 Coating application can be performed in cold temperature conditions if the substrate is preheated. For some applications, post-heating may be required to achieve an adequate cure depending upon ambient temperature. The coating must not be allowed to freeze before an adequate cure is reached. Preheating and post-heating may also be utilized if an accelerated cure time is required.
- 6.8 SP-9888[®] Grout and Sealing Compound cures to a Touch Dry condition in two and a half (2.5) hours at 25°C (77°F) and to a Dry Hard condition in eight (8) hours at 25°C (77°F).



SP-9888[®] GROUT AND SEALING COMPOUND

APPLICATION SPECIFICATION / STEEL SUBSTRATE

VI. APPLICATION (cont.)

- 6.9 SP-9888[®] Grout and Sealing Compound can be over-coated without the need for an additional tie coat. Over-coating is best accomplished while the previous coat is still tacky. Should the over-coating interval exceed 24 hours at 25°C (77°F), the surface should be blast roughened prior to application of the topcoat.

VII. APPEARANCE OF FINISHED COATING

- 7.1 The finished coating shall be generally smooth and free of protuberances or holidays. All surfaces shall have the required minimum DFT. In general, the surface of the coating shall be no rougher than the base or substrate material. No drips, running, sagging or other discontinuities are acceptable.
- 7.2 The applicator shall exercise every reasonable precaution to assure proper application of the coating and satisfactory protection of the steel surface.

VIII. SAFETY PRECAUTIONS

- 8.1 The contractor will provide accessible, safe and secure work areas.
- 8.2 SP-9888[®] Grout and Sealing Compound is **HARMFUL IF ABSORBED THROUGH SKIN, INHALED OR SWALLOWED**. It is a skin and eye irritant. Personal protective equipment is required. Refer to the **Material Safety Data Sheets**.
- 8.2.1 Chemical resistant gloves with a long cuff that will overlap the clothing sleeves should be worn when handling this product. The glove / clothing overlaps should be sealed by tape. Check with the glove manufacturer to determine the proper glove type.



SP-9888[®] GROUT AND SEALING COMPOUND

APPLICATION SPECIFICATION / STEEL SUBSTRATE

VIII. **SAFETY PRECAUTIONS** (cont.)

- 8.2.2 Wear an appropriate, properly fitted vapour respirator (NIOSH / OSHA approved) during application where vapour / mist are likely to be encountered, e.g. confined spaces and during winter construction or when the substrate is preheated. For outdoor application and areas with adequate ventilation, the use of a respirator is normally not required. Follow the respirator manufacturer's recommendations. Wear a dust respirator for any activity such as sanding or grinding of cured coating.
- 8.2.3 Wear splash proof chemical safety goggles and / or face shield.
- 8.2.4 Wear impervious boots.
- 8.2.5 Long-sleeved clothing is to be worn over regular clothing to cover all exposed areas of arms, legs or torso during mixing and application of the coating. Breathable clothing, such as cotton or disposable coveralls, is recommended.
- 8.2.6 Emergency eyewash and a shower should be in close proximity, where possible. A barrier cream may be used, in conjunction with the stated protective measures, as an additional safeguard against skin contact.
- 8.3 Keep the containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with Federal, Provincial, and Municipal regulations in Canada and Federal, State, and County regulations in the United States of America.
- 8.4 No open flames, smoking or welding will be allowed in the immediate vicinity during the coating application.
- 8.5 All personnel on the application crew shall be informed of regulations regarding smoking, auto traffic restrictions, the meaning of warning bells, horns and whistles, fire warnings and restricted areas. Members of the coating crew shall maintain good personal hygiene and wash thoroughly after exposure to the coating application, particularly before eating or going on breaks.



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APPLICATION SPECIFICATION / STEEL SUBSTRATE

IX. MATERIALS

- 9.1 SP-9888[®] Grout and Sealing Compound containers must be sealed prior to use.
- 9.2 **NO** amount of SP-9888[®] Grout and Sealing Compound shall be given, sold or exchanged without the express written consent of SPC.
- 9.3 The acceptable shipping and storage temperature range for SP-9888[®] Grout and Sealing Compound is between 5°C (41°F) to 40°C (104°F).
- 9.4 Store SP-9888[®] Grout and Sealing Compound in a cool, dry, well-ventilated area. Keep the container lids sealed when not in use. The Shelf Life of SP-9888[®] Grout and Sealing Compound is a maximum of 24 months from the date of manufacture if the materials are in unopened containers.

X. SUBSTRATE TYPES

- 10.1 This specification is applicable to standard steels.
- 10.2 Exotic metals, stainless steel or other special types of steel or alloys may require different consideration as to surface preparation and SPC formulations. Notification of the use of such metals must be made to SPC.

XI. CLEANING

- 11.1 If cleaning is necessary, the following materials can be used:
 - Use SP-100 Equipment Wash to clean uncured material on spatulas.
 - Use SP-110 Tool Cleaner to clean cured material on objects such as putty knives or mixing blades.
 - Brushes and rollers must be disposed of after use. **DO NOT** attempt to clean and re-use.



SP-9888® GROUT AND SEALING COMPOUND
APPLICATION SPECIFICATION / STEEL SUBSTRATE

XII. INSURANCE

- 12.1 The contractor will provide all necessary insurance to protect itself and its employees during the application of SP-9888® Grout and Sealing Compound.
- 12.2 SPC will provide all necessary coverage to protect SPC employees on site.

XIII. DISPOSAL

- 13.1 Dispose of empty Base and Hardener containers according to Federal, Provincial, and Municipal regulations in Canada and Federal, State, and County regulations in the United States of America. Allow all mixed material to complete gel prior to disposal.

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