



CORPORATE HEAD OFFICE

Specialty Polymer Coatings, Inc.
#100 5350 – 272nd Street, Langley, BC V4W 1S3, Canada
Tel: (604) 514-9711 • Fax: (604) 514-9722

U.S.A. HEAD OFFICE

Specialty Polymer Coatings USA, Inc.
22503 FM521, Angleton, TX 77515, USA
Tel: (281) 595-3530 • Fax: (281) 595-3717

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SP-2888[®] R.G. SPRAYABLE CARTRIDGE APPLICATION SPECIFICATION
STEEL SUBSTRATE – 1000 ml

I. GENERAL

- 1.1 SP-2888[®] R.G. Sprayable Cartridge coating is a 100% solids, epoxy-urethane, manufactured and marketed by **Specialty Polymer Coatings, Inc. (“SPC”)**, #100 – 5350 – 272nd Street, Langley, B.C., Canada, V4W 1S3, Telephone: (604) 514-9711, Fax: (604) 514-9722.
- 1.2 SP-2888[®] R.G. Sprayable Cartridge coatings are to be applied by SPC approved applicators.
- 1.3 This specification is applicable to the use of SP-2888[®] R.G. Sprayable Cartridge coating with a static mixer and a pneumatic dispenser.
- 1.4 Mixing Ratio: 3 Parts Base to 1 Part Hardener (pre-measured) by volume.
- 1.5 Colour Before Mixing: Base: White.
Hardener: Blue.
- 1.6 Mixed Colour: Light Blue.

II. PACKAGING

- 2.1 SP-2888[®] R.G. Sprayable Cartridge: 1000 ml consisting of 750 ml Base and 250 ml Hardener.
- 2.2 Pneumatic Dispenser.
- 2.3 Static Mixer.



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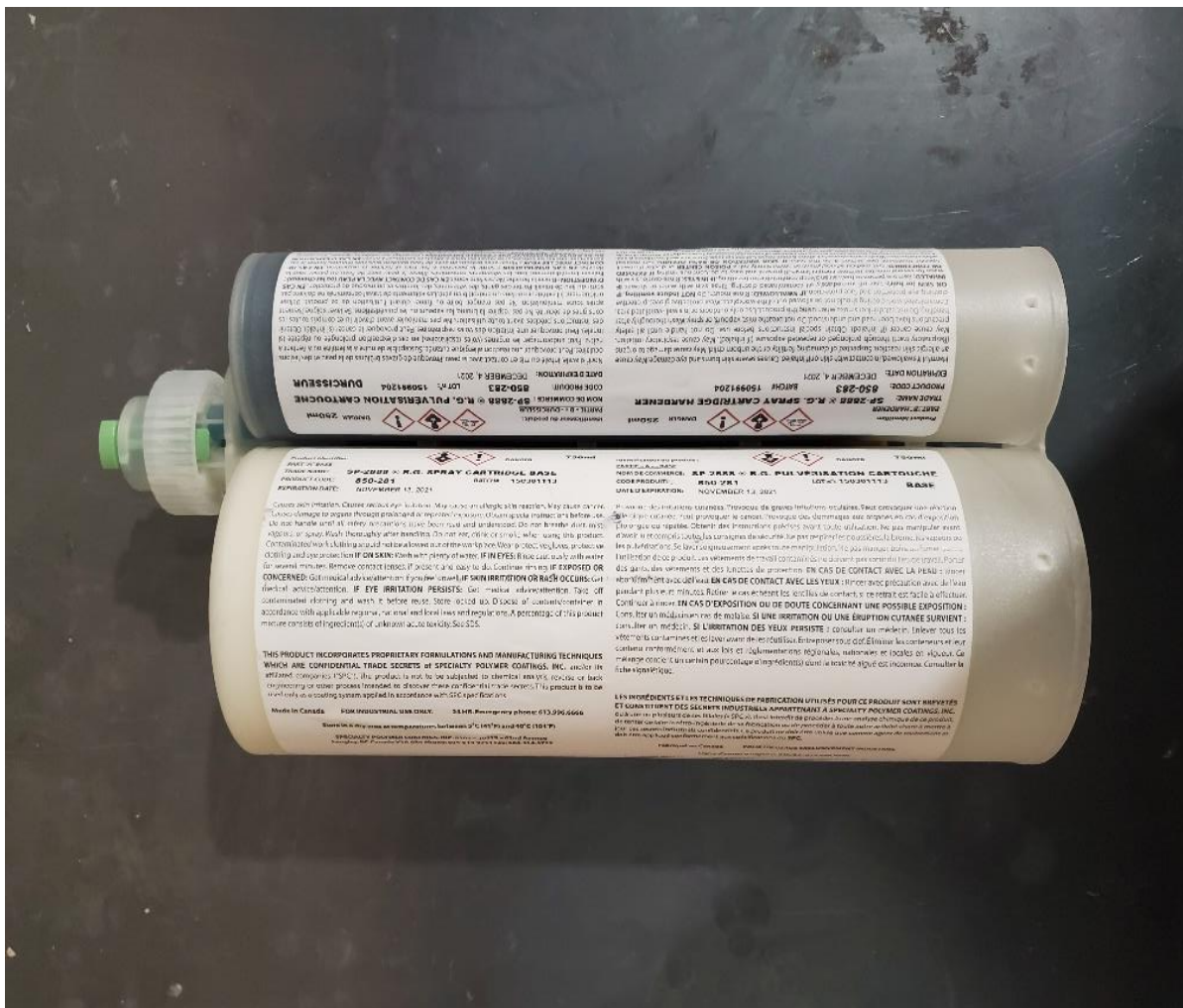
III. EQUIPMENT

- 3.1 1,000-watt 12-volt inverter units located on trucks, generators or approved power source capable of running spray cartridge heating method chosen.
- 3.2 750 – 1000-watt microwave heating units, warming oven or hot water bath heating source. Infrared laser thermometers shall be used to determine coating preheat temperatures after preheating.
- 3.3 1000 ml SP-2888[®] R.G. Sprayable Cartridges.
- 3.4 Sulzer Pneumatic Dispenser.
- 3.5 1 x static mixer per cartridge ordered. We highly recommend ordering 2 mixers per cartridge to utilize partial cartridges.
- 3.6 Air supply requirements are 50 CFM per pneumatic dispenser, with delivery pressure regulated to maximum of 100 PSI per pneumatic dispenser.

SP-2888® R.G. SPRAYABLE CARTRIDGE APPLICATION SPECIFICATION / STEEL SUBSTRATE

IV. PROCEDURE TO PREPARE CARTIDGE

4.1 Place the SP-2888® R.G. Sprayable Cartridge in the microwave, warming oven or hot water bath and preheat.



PHOTOGRAPH #1

SP-2888[®] R.G. SPRAYABLE CARTRIDGE APPLICATION SPECIFICATION / STEEL SUBSTRATE

IV. PROCEDURE TO PREPARE CARTIDGE (cont.)

- 4.2 Using an Infrared Laser Thermometer, measure the temperature of the preheated SP-2888[®] R.G. Sprayable Cartridge from all sides. Temperature readings should range from 60°C to 75°C (140°F to 167°F).
- 4.3 Once the SP-2888[®] R.G. Sprayable Cartridge has achieved the target preheat temperature window, unscrew the retaining cap and attach the static mixing tube.



PHOTOGRAPH #2

SP-2888[®] R.G. SPRAYABLE CARTRIDGE APPLICATION SPECIFICATION / STEEL SUBSTRATE

IV. PROCEDURE TO PREPARE CARTIDGE (cont.)

- 4.4 Insert the preheated SP-2888[®] R.G. Sprayable Cartridge tube with attached static mixing tube into the SPC pneumatic dispenser.
- 4.5 Attach airline to air input valve and adjust the air pressure, starting from 0 psi not exceeding 100 psi.



PHOTOGRAPH #3



SP-2888[®] R.G. SPRAYABLE CARTRIDGE APPLICATION SPECIFICATION / STEEL SUBSTRATE

V. APPLICATION

- 5.1 On the dispenser, turn the dispense rate valve to zero “0”, which is counter clockwise and change the brass pinion valve to the forward motion or the dispense mode.
- 5.2 Initial flow of material should be dispensed away from the substrate to be coated until an adequate spray fan has been achieved. Adjusting the dispense rate and air pressure may be required.
- 5.3 Once the cartridge system has an adequate fan, begin applying material onto the substrate to be coated.
- 5.4 Considering the high delivery capacity of this system, it is easy to deliver more product than can be diffused from the spray tip. Once you have achieved optimal atomization, application on the substrate shall commence utilizing a 50% overlap per pass.
- 5.5 In sub-zero temperatures, the cartridge can lose heat near the end of the dispense cycle. If this occurs, recap the cartridge and re-heat to 60°C to 75 °C (140°F to 167 °F) to dispense the remaining product.
- 5.6 During dispensing, should the product flow cease, do not increase the dispense rate. If this occurs, the static mixer may have hardened, therefore, remove the mixer and replace it with a new one.

VI. SAFETY PRECAUTIONS

- 6.1 The Contractor will provide safe and secure access to work areas.
- 6.2 SP-2888[®] R.G. Sprayable Cartridge coating is **HARMFUL IF ABSORBED THROUGH SKIN, INHALED OR SWALLOWED**. It is a skin and eye irritant. Personal protective equipment is required. Refer to the **Safety Data Sheets**.
 - 6.2.1 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.
 - 6.2.2 Wear an appropriate, properly fitted vapour respirator (NIOSH/OSHA approved) during application where vapour/mist are likely to be encountered and follow the respirator Manufacturer’s recommendations for cartridge types. Wear a dust respirator for any activity such as sanding or grinding of cured coating.



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VI. **SAFETY PRECAUTIONS** (cont.)

- 6.2.3 Wear splash proof chemical safety goggles and/or face shield.
 - 6.2.4 Wear impervious boots.
 - 6.2.5 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.
 - 6.2.6 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.
- 6.3 Keep the tubes sealed 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.
- 6.4 No open flames, smoking or welding shall be allowed in the immediate vicinity during the coating application

VII. **MATERIALS**

- 7.1 SP-2888[®] R.G. Sprayable Cartridge coating tubes must be sealed prior to use.
- 7.2 **NO** amount of SP-2888[®] R.G. Sprayable Cartridge coating shall be given, sold or exchanged without the express written consent of SPC.
- 7.3 The acceptable shipping and storage temperature range for SP-2888[®] R.G. Sprayable Cartridge coating is between 5°C (41°F) to 50°C (122°F).
- 7.4 Store SP-2888[®] R.G. Sprayable Cartridge coating in a cool, dry, well-ventilated area. Keep the tubes sealed when not in use. The Shelf Life of SP-2888[®] R.G. Sprayable Cartridge coating is a maximum of 24 months from the date of manufacture if the materials are in unopened tubes.



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VIII. SUBSTRATE TYPES

- 8.1 This specification is applicable to standard steels.
- 8.2 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.

IX. INSURANCE

- 9.1 The Contractor will provide all necessary insurance to protect itself and its employees during the application of SP-2888[®] R.G. Sprayable Cartridge coating.
- 9.2 SPC will provide all necessary coverage to protect SPC employees on site.

X. DISPOSAL

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

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Langley, BC, CANADA V4W 1S3
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Fax: (604) 514-9722

USA Head Office

22503 FM 521
Angleton, TX USA 77515
Phone: (281) 595-3530
Fax: (281) 595-3717

www.spc-net.com