



Application Guidelines

Tank Cars – New & Repair

1227PT Gloss DTM Epoxy

1) Surface Preparation

- a. In accordance with SSPC-SP1, remove any grease and oil from the surface.
- b. In accordance with SSPC-SP10, abrasive blast to a minimum near white blast to obtain a 1.5-2.5 blast mil profile. Less severe service and repair cars can be prepared in accordance with SSPC-SP6.
- c. To reduce the risk of pinholes, any blast profile exceeding 2.5 mils should be coated with a thin dust coat followed by a second finish coat.

2) Coating Material

- a. Mix all containers thoroughly and check for uniformity.
- b. By volume, mix one part component A with one part component B. In cool temperatures (<60°F), allow for extra mixing time to prevent any film defects
- c. Spray applications does not require thinning, if necessary check with Love & Associates for an approved thinner.
 - i. Thinner in Plural Component equipment should be added in equal amounts to both component A & B prior to mixing them together. Heaters should be used to reach 100-140°F at the spray gun. Do not exceed 165°F.
 - ii. Manual Mixing – Mixed material should only be reduced with thinner to the recommended level. An induction time of 15 minutes for mixed material is recommended for maximum appearance and performance.
- d. Use of non-approved solvents could affect performance and void any warranty.
- e. Clean all spray equipment thoroughly and keep paint lines clear of contaminants.

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3) Spray Equipment

- a. Spray Equipment Suppliers – Devilbliss, Graco & Binks
- b. Airless Spray minimum spray equipment specifications:

Pump Ratio	45:1
Air Pressure Output	3000 PSI Minimum
GPM Output	3.0 Minimum
Fluid Hose Size	3/8” ID Minimum
Spray Tip Size	0.017” - 0.021”
Heater Temperature	200°F Minimum (If required)
Reducer	As Necessary

4) Substrate

- a. Metal Surface must be 5°F above the dew point to apply the coating. The metal surface temperature must be 50°F or greater.

5) Application

- a. Tack Coat
 - i. New Car Facilities – Only if needed.
 - ii. Repair Facilities – tack coat any difficult to coat areas, weld seams & pitted areas prior to the full application.
- b. Apply 6-8 mils dry per coat, do not exceed 12 mils dry per coat.
- c. Pot life is 6 hours at 75°F. Higher temperatures will reduce pot life.

6) Cure Times at 6-8 mils Dry Film Thickness

- a. Ambient – 75°F
 - i. Touch – 3-4 hours
 - ii. Handle – 6-7 hours
 - iii. Re-coat – 12 hours



- b. Force Cure
 - i. Allow 1 hour flash off at 75°F prior to moving the car into the oven. Adjust time as necessary for higher and lower ambient temperatures.
 - ii. Ramp up temperature 1-2°F per minute or slower
- c. Blistering may occur under the following situations
 - i. Less than required flash off time
 - ii. Higher than recommended dry film thickness
 - iii. Temperature increase is too fast
- d. Color & Gloss can be affected if exposed to moisture prior to final cure

7) Touch-Up Procedure

- a. Exam the cured finish for any defects; Sags, runs, pinholes, fisheyes, holidays, overspray and any low or high film thicknesses that may need to be repaired.
- b. Minor infrequent pinholes & holidays can be repaired by brushing and working paint into the voided areas to provide protection. Large and frequent pinholes and holidays must be sanded with fine sandpaper and cleaned thoroughly prior to re-coating.
- c. For sags and small runs noticed shortly after painting and the coating is still wet and flows, a brush may be used to dab and level out the sags/runs. Runs and sags in the cured film must be repaired using a scraper or sandpaper and re-sprayed or brushed.
- d. Overspray can be removed with very fine sandpaper. Be sure not to sand too deep and keep the full coating intact. Sanded areas can be touched up by brush or spray.
- e. Low film thickness can be corrected by spraying or brushing another coat depending on the size and location.
- f. High film thickness can be sanded or blasted followed by a touch up spray or brush.
- g. Use Love & Associates recommended reducer for all touch ups and repairs.
- h. After any corrections or re-works, inspect again for continuous films and proper film thickness.

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8) Cleaning

- a. Clean all equipment with MEK if possible. Mixed material will harden in lines and equipment if left over night. On plural component equipment, be sure to flush from the mixing head through the delivery hose and guns.

9) Storage

- a. Close all containers tightly
- b. Do not store outside
- c. Do not store above 100°F
- d. Rotate stock
- e. Do not use past shelf life – 1 year from the date of manufactured when stored properly

Information contained herein is to the best of our knowledge believed to be true and accurate at the date of issuance. Should the owner's specification differ from these procedures, contact your Love & Associates representative to assure our coating will perform to owner's guidelines. Special shop conditions may exist that demand specific and unique application requirements.