



PERMAGARD 253 LOW VOC COAL TAR EPOXY

DESCRIPTION	PermaGard 253 Low VOC is a rapid drying/quick curing, self-priming coal tar epoxy suitable for all environments. PermaGard 253 Low VOC exhibits excellent adhesion and abrasion resistance to properly prepared surfaces. The accelerated drying and curing characteristics make it ideal for applications where a fast drying product is required such as low temperature applications or quick turnarounds. Addition of glass flake gives PermaGard 253 Low VOC increased abrasion, chemical, and immersion resistance.				
FIELD OF APPLICATION	PermaGard 253 Low VOC is ideal as a primer/finish coat in aggressive industrial and marine environments. Product applications include: <table><tr><td>1. Marine structural steel</td><td>3. Sewage treatment plants</td></tr><tr><td>2. Pipelines, refineries, chemical plants</td><td>4. Concrete surfaces</td></tr></table>	1. Marine structural steel	3. Sewage treatment plants	2. Pipelines, refineries, chemical plants	4. Concrete surfaces
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SERVICE CONDITIONS	PermaGard 253 will withstand 180°F (82°C) continuous dry heat and 150°F (66°C) continuous immersion. It has excellent resistance to fresh water and salt water.				

TECHNICAL DATA

TYPE	Coal tar epoxy
VOLUME SOLIDS	63%
V.O.C.	As Supplied: 2.79 lb/gal (336 g/l) Thinned 10%: 3.20 lb/gal (385 g/l)
DENSITY	12.0 lbs/gal (1.44 kg/l)
COVERAGE (Theoretical)	1010 sq ft/gal at 1 mil dry (1.6mils wet) 24.8 sq m/l at 25 microns dry (40 microns wet) 126 sq ft/gal at 8 mils dry (12.7 mils wet) 3.11 sq m/l at 200 microns dry (317 microns wet)

NOTE: When figuring practical coverage, allow for application losses, surface irregularities, any solvent addition, etc.

RECOMMENDED DRY FILM THICKNESS PER COAT	8.0 - 15.0 mils (200 - 375 microns)
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Manufacturers of Quality Paints and Protective Coatings
Esgard, Inc. 515 Debonnaire Road Scott, Louisiana 70583 U.S.A.
(337)234-6327 Fax (337) 234-0113 1-800-888-2511

www.esgard.com



DRY TIME (HOURS) @ 5 MILS DFT 65% R.H	Set To Touch	To Handle	Recoat	Topcoat	Immersion Service (Final Cure)
20°F (-7°C)	8	16	10	12	28 Days
40°F (4°C)	4	8	5	6	21 Days
60°F (16°C)	3	7	4	5	14 Days
80°F (27°C)	2	5	2	3	7 Days
100°F (38°C)	1	3	1	2	5 Days

SURFACE PREPARATION

Thoroughly clean any oil or grease contaminated areas with Esgard Surface Conditioner or a detergent wash followed by a fresh water rinse and allow drying in accordance with SSPC-SP1-82. All surfaces should be cleaned free of all dirt, rust, and other surface contaminants. All surfaces should be prepared to the following norms: SSPC-SP10-82 near white blast or better with 2.0 to 3.0 mil (50 – 75 micron) anchor profile.

APPLICATION

Mix – Power mix Part A and B separately, then mix 1:1 by volume A:B. Allow to stand for 15 minutes to thoroughly mix and ingest.

Thin - Thin only as needed up to 10% (typically 5%) by volume to obtain proper consistency. For all spraying, brushing, and rolling use the following:

Above 80°F (27°C)	Esgard Thinner 106
Below 80°F (27°C)	Esgard Thinner 103

NOTE: The use of non-specified thinners may affect application characteristics and product performance.

Spray - Use suitable conventional or airless spray equipment. Flush equipment with Thinner 103 or 106 before use. The following has been found adequate:

Conventional - Pressure pot should have an oil/water trap, double regulators, and minimum 3/8" I.D. fluid and air hose. Gun should be a DeVilbiss with a D tip and #64 air cap, or Binks with a #68 set up.

Airless - Use Graco Bulldog 30:1 or equal with Teflon packing with minimum 3/8" I.D. fluid hose. Gun should have a fluid tip size .021 - .025. Fluid tip pressure should be 2300 - 2600 p.s.i.

Brush – For touch up only. Apply PermaGard 253 with a clean quality paint brush.



Roll – For touch up only. Apply PermaGard 253 with a quality medium nap roller with woven pile and phenolic core. A solvent resistant foam roller provides an excellent finish.

Note: Two coats may be necessary to obtain proper film thickness because brushing and rolling tend to push material thinner than required.

POT LIFE	<u>TEMPERATURE</u>	<u>HOURS</u>
	77°F (25°C)	6
	90°F (32°C)	3
	100°F (38°C)	2

CLEAN UP Esgard Thinner 103 or 106. For personal cleanup, use soap and water.

APPLICATION / SERVICE LIMITATIONS	Temperature and Humidity:		
		<u>MIN</u>	<u>MAX</u>
	Application (Ambient)	20°F (-7°C)	110°F (43°C)
	Application (Material)	20°F (-7°C)	100°F (38°C)
	Surface	20°F (-7°C)	145°F (63°C)
	Humidity	0%	90%
	Service		
	<u>Non-Immersion Dry</u>		
	Continuous	–	180°F (82°C)
	Intermittent	–	250°F (121°C)
	<u>Immersion</u>		
Continuous	–	150°F (66°C)	
Storage	45°F (7°C)	100°F (38°C)	

DO NOT APPLY when the surface temperature is less than 5°F (3°C) above the dew point.

ORDERING INFORMATION

CONTACT # 1-800-888-2511

SHIPPING WEIGHT		<u>1 GAL KIT</u>	<u>5 GAL KIT</u>
	PermaGard 253	13.0 lb (5.9 kg)	63.0 lb (28.6 kg)
		<u>1 GAL</u>	<u>5 GAL</u>
	Thinner 103	8.5 lb (3.9 kg)	42.0 lb (19.10 kg)
	Thinner 106	8.5 lb (3.9 kg)	42.0 lb (19.10 kg)

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FLASH POINT

PermaGard 253 – Part A	45°F (7°C)
PermaGard 253 – Part B	45°F (7°C)
Thinner 103	45°F (7°C)
Thinner 106	105°F (41°C)

COLORS

Black

SHELF LIFE

Eighteen (18) months from date of shipment.

CAUTION

FOR INDUSTRIAL USE ONLY! FLAMMABLE! Contains petroleum distillates.
DO NOT USE NEAR HEAT, SPARKS, OR FLAMES. Close container after use.

SAFETY

Refer to Material Safety Data Sheet supplied with each order.

FIRST AID

Refer to Material Safety Data Sheet supplied with each order.