

PRODUCT PROFILE**DESCRIPTION**

COMBAT 250-D is a modified version of Combat 250, the workhorse of the COMBAT line of industrial coatings. COMBAT 250-D is specifically formulated with the addition of alumina to enhance abrasion characteristics for tough applications where coatings come in contact with abrasive slurry and dust. COMBAT 250-D withstands abrasion with less than 24 mg loss on ASTM –D-4060 at temperatures up to 250° F. Combat 250-D cures with a dark gray color. Combat 250 is self-priming and will flex with normal vibration and expansion.

COMBAT 250 is non-hazardous, non-corrosive and emits no foul vapor during installation. COMBAT 250 can be applied by roller, brush or spray and sets with 100% solids meaning there is no volume shrinkage after applied.

- 100% Solids, No VOCs
- Long term wear protection
- Excellent abrasion resistance

**CHEMICAL
RESISTANCE**

- | | | |
|-------------------------------|---------------------------|-------------------------------|
| • Acetic Acid 10% | • Mineral Spirits | • Sulfuric Acid 75% |
| • Ammonium Hydroxide 25% | • Potassium Hydroxide 50% | • Sewage |
| • Brine Water | • Crude Oil | • Alkalis |
| • Copper Sulfate | • Caster Oil | • Fresh and non-potable Water |
| • Diesel Fuel | • Ethylene Glycol | • Ethanol |
| • Gasoline | • Sodium Chloride | |
| • Hydrochloric Acid up to 30% | • Sodium Hydroxide 50% | |

**PREPARATION
SP5 FINISH**

Metal surfaces must be prepared by thoroughly cleaning and roughening to gain maximum adhesion. Sweat oily chemical soaked items and then grit blast a very rough 2-4 mil profile into the surface. (NACE 1 / SSPC-SP-5)



PHYSICAL PROPERTIES

Color	Dark Gray
Container Size	1, 2 and 5 gallons
Coverage per gallon (Theoretical)	160 sq. ft. @ 10 mils thickness
Flash Point	> 250°F (121°C)
Pull-Off Adhesion Test ASTM D 4541	Minimum adhesion is 2550 psi
Tabor Abrasion ASTM D 4060	>24 mg (CS 17 Wheel Cycles: 1KG load)
Recommended Thickness	2 coats @ 8-12 mils each
Specific Gravity	Resin: 1.48 Hardener: 1.02
Volatile Organic Compounds (VOC)	0 grams/liter
Weight per gallon	14.50 lbs

POT LIFE

40°F (4°C)	8 hours 30 minutes
75°F (24°C)	2 hours 30 minutes
92°F (33°C)	55 minutes

Note: Do not keep the blended coating in the original container unless immediate use is planned. Otherwise, exotherm—heat created during the curing process—will considerably shorten the pot life. Pour the coating into a rolling tray or large aluminum-basting pan. Try to keep the depth of the coating in the tray below 3/8".

SERVICE TEMPERATURE

<u>ENVIRONMENT</u>	<u>MAX TEMPERATURES</u>
Dry Service	250°F (104°C)
Spill/Splash	200°F (82.2°C)
Immersion Service*	170°F (76.7°C)

** Immersion with solvents, mineral acids, or alkalines, or if over 150°F contact factory*

PUMP SPECIFICATIONS

Pump Ratio	56:1 or greater
Minimum Output	5600 psi
Product Hose: Min. - Optimum I.D.	0.375 - 0.5 inch
Max. Length	50 feet

MULTIPLE COATS

Second and subsequent coats must be applied before the previous coat has completely cross-linked. If additional coats are needed after re-coat window, brush blast before applying the next coat. Small areas may be abraded by sanding or wire brushing.

The same requirement applies when overlapping the seams of adjacent coating sections to create a continuous protective film. If the coating surface to be overlapped at the seam cannot be brush blasted, use a non-impact means as power brushing or sanding to create a mechanical profile.

CURE TIME (AT 70°F OR 21°C)

Re-coat Window	24 hours
Light Loading	2 days
Immersion (Aqueous) Service	3 days
Full or Chemical Service	7 days