

PRODUCT PROFILE

DESCRIPTION

COMBAT 250 is the economical solution to most industrial corrosion problems on metal surfaces. Combat 250 is a rugged two component epoxy coating that withstands aggressive chemical attack in applications up to 250° F. COMBAT 250 is available in a variety of colors including blue gray, light gray and red. Combat 250 is self-priming and provides exceptional wear characteristics and will flex with normal vibration and expansion. Combat 250 is ideally suited for applications that require coating to come in contact with chemical solution such as holding tanks, cooling towers, and slurry transport.

COMBAT 250 is non-hazardous, non-corrosive and emits no foul vapor during installation. COMBAT 250 can be applied by roller, brush or sprat and sets with 100% solids meaning there is no volume shrinkage after applied. Combat 250 is the workhorse of industrial; coatings that will solve most of your metal protection needs.

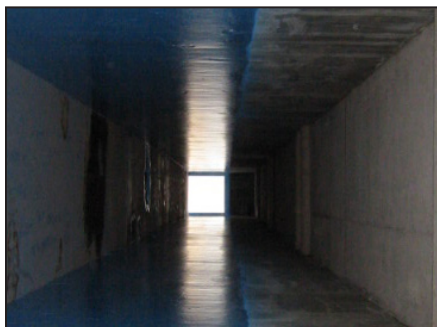
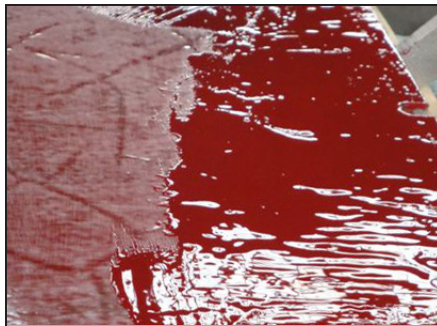
- 100% Solids, No VOCs
- Excellent immersion resistance

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	White, Dark Gray, Blue, Red
Container Size	1.25 gallon pails and drums
Coverage per gallon (Theoretical)	160 sq. ft. @10 mils thickness
Flash Point	> 250°F (121°C)
Pull-Off Adhesion Test ASTM D 4541	>2500 psi
Recommended Thickness	2 or 3 coats @ 8–20 mils each, max vertical 12 mils
Specific Gravity	Resin: 1.48 Hardener: 0.97
Volatile Organic Compounds (VOC)	0 grams/liter
Weight per gallon	10.86 lbs + - .20

POT LIFE

40°F (4°C)	8 hours 30 minutes
75°F (24°C)	45 minutes
92°F (33°C)	35 minutes

Note: Do not keep the blended coating in the original container unless immediate use is planned. Otherwise, exothermic 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

ENVIRONMENT	MAX TEMPERATURES
Dry Service	-30°F to 250°F (121°C)
Spill/Splash	200°F (93°C)
Immersion Service*	170°F (76.7°C)

** Water Immersion — 190°F (90°C) — Atlas test cell for 60 days, unaffected*

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	60 feet
Tip Size	0.023-0.029

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 requirements 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 maximum
Light Loading	2 days
Immersion (Aqueous) Service	3 days
Full or Chemical Service	7 days