



Epodur 7765

Epoxy Mastic

Description

Epodur 7765 is an aluminum filled modified epoxy mastic that provides excellent corrosion protection over tightly adhered rust and hand tooled cleaned steel surfaces as per (SSPC SP 2 or SSPC SP 3) and is used where abrasive blasting is not permitted or not possible. Epodur 7765 is used as a touch-up primer for shop primed steel prior to field finishing. It may be top-coated with Epodur 7460 Acrylic Urethane Series or Epodur 7800 Acrylic Siloxane for extended corrosion protection and color fastness.

Recommended Uses

Excellent for use as a spot primer on tank exteriors prior to top coating and on structural steel, steel tanks, barges, refineries, petrochemical plants, power plants, railcars, pulp & paper mills and others as recommended.

Features

- Surface tolerant coating
- Excellent corrosion protection
- Single coat capability
- Outstanding wetting and adhesion properties
- Good chemical resistance
- VOC compliant
- Excellent flexibility
- Low moisture permeability
- Aluminum pigmentation

Not Recommended for

- Immersion in aromatic solvents
- immersion oxygenated solvents
- Chromic or nitric acids
- Concentrated mineral acids
- Bleaches or oxidizing agents
- Interior of portable water storage tanks

Recommend topcoats

Epodur 7460 High Solids Acrylic Urethane Series
Epodur 7800 Acrylic Siloxane Series

Performance Data

Abrasion resistance (ASTM D 4060 Taber Abrasion)	1000 cycles with 1 Kg load, CS 17 wheel, weight loss of 136 mg
Adhesion (ASTM D 4541)	4,407 pounds per square inch
Impact resistance (ASTM D2794)	Direct impact 160 inch pounds
Salt Spray (ASTM B 117)	1,000 hours, No blistering or rust showing

Chemical Resistance

Epodur 7765 is resistant to a wide range of chemicals in atmospheric exposures. The following is a guide to proper selection

Exposure	Immersion	Splash & Spillage	Fumes
Acidic	Not Recommended	Good	Good
Alkaline	Not Recommended	Excellent	Excellent
Solvents	Not Recommended	Good	Excellent
Salt Water	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

Surface Preparation

Remove all oil and grease from surfaces using Dampney 170 Cleaning Solvent or a commercial cleaner that does not leave a residue according to SSPC SP 1.

Steel: Abrasive blasting is preferred when possible as the performance is enhanced. Abrasive blast to SSPC SP 6 "Commercial Blast" to obtain a 1.5 to 3.0 mil profile.

Immersion: Abrasive blast to SSPC SP 10 "Near White Blast" to obtain a 1.5 to 3.0 mil profile

Mild Environments: Which do not permit abrasive blasting, hand tool clean per SSPC SP 2 "Hand Tool Cleaning", or SSPC SP 3 "Power Tool Cleaning" or "High Pressure Water Cleaning" per SSPC SP 12/NACE 5 WJ-4 is recommended.

Concrete: cure for 28 days or more at 75°F (24°C) and 50% RH, abrasive blast to remove laitance from oils and produce a surface roughness similar to medium

sandpaper. Surfacing may be required to fill holes in order to produce a sealed surface.

Mixing

Epodur 7765 has a one to one ratio. Power mix each component separately then mix 1 part B to 1 part A by volume of Epodur 7765 and power mix thoroughly. Use only explosion proof power mixing equipment

	<u>2 Gal Kit</u>	<u>10 Gal Kit</u>
Epodur 7765 A	1 gallon	5 gallon
Epodur 7765 B	1 gallon	5 gallon

Pot Life

Epodur 7765 has a 4 hour pot life at 75° (23.9°C) and less at higher temperatures.

Thinning

Thinning is not required, for most applications, if required Epodur 7765 may be thinned up to 1 pint per gallon, using Dampney 167 Thinner. Thinning is recommended for applications when the temperature is below 70°F (21°C). Use Dampney 167 Thinner when overcoating inorganic zinc primers as well as brush or roller applications. **Note:** Use of other thinners not approved by Dampney may hinder product performance and void product warranty.

Application

Apply by brush, roller, conventional Spray, or airless spray equipment.

Conventional Spray:

Spray gun	DeVilbiss MBC or JGC spray gun or Binks 18 or 62 spray guns
Air hose	5/16" (I.D.)
Fluid hose	3/8" (I.D.) minimum
Air cap	704
Fluid nozzle	.086"
Pressure pot	Doubled regulated
Pot pressure	10 - 15 lbs.
Atomizing Pressure	35 - 40 lbs.

Airless Spray Equipment:

Spray pump	Graco 30:1 Bulldog
Air to pump	90 to 100 lbs.
Spray tip	017" to 021"
Material hose	3/8" I.D. (minimum)
GPM output	3.0 (minimum)
Output	1800 – 2200 psi
Filter size	60 mesh

Brush & Roller:

Use a natural bristle brush and a medium nap roller with a solvent resistant fibers and core. Multiple coats may be required to obtain adequate hiding and recommended film thickness. Extra care should be taken to measure and hold film thickness when

Bulletin 7765

applied by brush or roller. Do not bridge irregularities, use a brush to work coating into surfaces.

Application Conditions

Material	Surface	Ambient
Minimum	50°F (9.9°C)	50°F (9.9°C)
Maximum	90°C (32.1°C)	110°F (43°C)

Special thinning and application procedures are required outside these temperatures. Surface temperatures should be 5°F (3°C) above the dew point to prevent condensation.

Storage

Store in a cool dry place with temperatures between 50°F to 100°F (9.9°C to 37.7°C). Keep container closed when not in use

Clean Up

Thoroughly flush spray equipment and hoses after use with Dampney 167 Thinner. Dismantle spray equipment and clean parts, brushes and rollers with Dampney 167 Thinner.

Precautionary Information

Warning Flammable Liquid and Vapor. Keep away from sparks and flame. Vapors may cause flash fire. Do not breathe vapors or spray mist. Avoid contact with eyes, skin, and clothing. Use with adequate ventilation during mixing and application. Wear an appropriate, properly fitted organic vapor cartridge type respirator (NOISH approved) during and after application unless air monitoring demonstrates vapor/mist levels are below applicable levels. Follow respirator manufacture's directions for respirator use. Wash thoroughly after handling. Wear protective, chemical safety goggles and impervious protective clothing. Use skin cream. In confined spaces it is required to use a positive pressure supplied-air respirator (NIOSH approved). Use explosion-proof lights and electrical equipment. Wear conductive and non-sparking footwear. Make certain all electrical equipment is grounded. Observe all safety precautions and follow procedures described in OSHA regulations.

See Material Safety Data Sheets (MSDS) for complete precautionary and disposal information.

If instructions and warnings cannot be strictly followed. Do not use this product.

Technical Data

Characteristics	Epodur 7765				
Generic Type	Epoxy Mastic				
Color*	Aluminum				
Finish	Matte				
Number of components	Two				
Mixing ratio by volume	1 to 1 ratio (1 part A : 1 part B)				
Percent Solids by volume (mixed)	80 ± 1%				
Weight per gallon (mixed)	14 lbs./gal (1.67 kg/l)				
Dampney 167 thinner	7.1 lbs/gal (.85 kg/l)				
Temperature resistance					
Continuous	250°F (121°C)				
Intermittent	300°F (149°C)				
Dry film thickness per coat	4 to 6 mils (101.6 to 152.4 microns)				
Wet film thickness per coat	5 to 9 mils (127 to 228.6 microns)				
Theoretical coverage per gallon*	1,283 mil sq. ft./gal (31.49 sq m./l at 25.4 microns).				
Application Temperature	Material	Surface	Ambient		
Ambient air	50-110°F	50-110°F	50-110°F		
Substrate	50-110°F	50-110°F	50-110°F		
Coating material	50-90°F	50-110°F	50-110°F		
Humidity	85%	85%	85%		
Drying time at temperature	50°F	60°F	70°F	80°F	90°F
To touch	20hrs.	10hrs.	5hrs.	3hrs.	2hrs.
To handle	48hrs.	24hrs	12hrs.	6hrs	3hrs.
To recoat	5 days	3 days	30 hrs.	24 hrs	18 hrs
To ship	7 days	7 days	7 days	7 days	7 days
Finial cure/immersion service	10 days	5 days	3 days	2 days	1 day
Maximum recoat time	120 days		69 days		30 days
Pot life	6 hrs.		4 hrs.		2 hrs.
Flash point (Base Part A)	60°F (15.6°C)				
(Activator Part B)	60°F (15.6°C)				
(Dampney 167 Thinner)	60°F (15.6°C)				
VOC (Volatile Organic Content)					
Unthinned	0.8 lbs/gal (100gms /liter)				
Thinned with Dampney 167 thinner at 1 pint per gallon	0.8 lbs/gal (100gms/loter)				
Shelf Life	1 year				

* Color: this coating contains metallic pigments that will cause variations in the finish color from container to container, batch to batch, and is affected by weather conditions at the time of application and application techniques.

Warranty

Dampney protective coating products are expressly warranted to meet applicable technical and quality specifications. The technical data contained herein are accurate at the date of issuance but are subject to change without prior notification. No warranty of current accuracy is hereby given or implied. User must contact Dampney to verify correctness before ordering. Dampney assumes no responsibility for coverage, performance or injuries resulting from handling or use and LIABILITY, IF ANY, SHALL BE LIMITED TO PRODUCT REPLACEMENT. In no Event will Dampney be responsible for consequential damages, except insofar as mandated by law. Dampney DISCLAIMS ALL OTHER WARRANTIES OF MECHANABILITY AND FITNESS FOR A PARTICULAR PURPOSE.