American TC-7 Epoxy Caulk

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	A Process Seam Sealing System for Exterior Leaking of Rivets and Smoothing of Seams in Storage Tanks.
Description	A two component system by which 100% solids, epoxy material is machine spray applied to the exterior seams and rivets on storage tanks. It is formulated for flexibility and adhesion to fight against weeps and leaks. The system can also be applied to prevent rusting between spot welded areas, corners, and otherwise hard to coat areas preventing unsightly rust streaking. Normally 2 – 3 men can completely seal the rivets and seams in a 120’ x 40’ diameter storage tank in 3 – 4 days.
Features	• 100% solids • Prevents rusting between spot welding areas, corners and other hard to coat areas • Formulated for flexibility and adhesion
Color	Blue (0100)
Dry Film Thickness	62 mils (1575 microns) single coat Minimum
Solids Content	By Volume 99% +/- 1%
Theoretical Coverage Rate	1588 ft²/gal at 1.0 mils (39.0 m²/l at 25 microns) 26 ft²/gal at 62.0 mils (0.6 m²/l at 1550 microns) Allow for loss in mixing and application.
VOC Values	**As Supplied** : 0 Calculated
Dry Temp. Resistance	Continuous: 250°F (121°C)
Limitations	American Coatings does not recommend the following conditions without written agreements or prior consent. • When applied to rivet and seams it must be overcoated with a chemical resistant coating. • Polyester or vinyl esters applied over AmericanTC-7 Epoxy Caulk • Overcoating with inorganic zinc rich primers • Application to tanks operating over 225°F (107°C).
Temperature Resistance (Immersion)	190°F (88°C)
Topcoats	Alkyds, Epoxies, Polyurethane (Inorganic Zinc is not recommended)

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SUBSTRATES & SURFACE PREPARATION

Steel	Sandblast 2 to 3 inches each side of the steel rivet or seam area. A SSPC-SP10-63 (Near White Metal Blast) cleaning is required as outlined in the Surface Preparations Specification, of the Steel Structures Painting Council, 40C Fifth Avenue, Pittsburgh, PA 15213. Steel surfaces must be dry and free of all mill scale, oil, grease, paint, and any other foreign matter. Use dry sand of a maximum particle size no larger that that passing through a 16 mesh screen, U.S. Sieve Series, and air of 100 psi pressure through a 3/8" diameter nozzle. Steel grit or slag, may also be used provided the anchor pattern is of a jagged irregular profile. **Note:** Smooth river sands or steel shot are not recommended. Blast no further distance than what can be coated with this product at the end of each day's work. No priming is allowed, for exterior rivets this product obtains maximum adhesion over a sand blasted steel surface.

MIXING & THINNING

Thinning	**DO NOT THIN**
Ratio	2:1
Pot Life	Mixed: 30-45 minutes at 77°F (25°C)

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

General	Airless Proportioning Pump with inline blender

APPLICATION PROCEDURES

Application	**For Maximum Performance**: The end user should empty or lower the product level of the tank below the rivet areas to be sealed. This provides for maximum sealing of the rivets and seams. For sealing rivets from the interior of the tank be sure to topcoat extending 2 – 3 inches to either side and including the caulked area with 2 coats of recommended epoxy at 4 – 6 mils per coat. This will prohibit undercutting corrosion. This product is not recommended for application to rivet and seams on converted riveted tanks in which sheets have been added by welding. Rivets and seams should be completely caulked on the entire tank shell before painting according to this specification. After sealing the tank with American TC-7 Epoxy Caulk, all seam sealed areas should be brush blasted in order to receive the tank primer coat. Alkyds, epoxies, polyurethanes, etc. may be applied over this product in this way. Do not topcoat with any inorganic type coating. See your Carboline Representative for hot patch epoxy materials when the tank must be caulked while full or at the same level of the product.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Final Cure	Maximum Recoat Time
77°F (25°C)	2.5 Hours	6 Days	30 Days

Allow 5 – 7 days at 70F before returning the tank to service. Minimum time would be 3 days at 90°F (32°C). The degree of cure can be checked with a Shore Durometer Hardness Tester (Model Type D). The cured coating should read greater than 70. If a Rockwill Hardness Tester (M Scale) is used the reading should be greater than 105.

CLEANUP & SAFETY

Cleanup	Clean all equipment with Thinner 76.
Safety	If adequate ventilation and protective clothing is used, epoxy resin and hardeners may be handled with little difficulty.

PACKAGING, HANDLING & STORAGE

Shelf Life	1 year
Shipping Weight (Approximate)	Part A: Fives: 50 lbs (22.6 kg) Part B: Fives: 50 lbs (22.6 kg)
Flash Point (Setaflash)	Part A: 200°F (93°C) Part B: 200°F (93°C)

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.