EpoSany® - 791 HS
Epoxy High Solids Primer and Finish

**SPECIFICATION DATA**

**Theoretical Solids Content By Volume:**
- EpoSany-791 HS Primer: 71% ± 2%
- EpoSany-791 HS Finish: 69% ± 2%

**Theoretical Coverage Rate per Gallon (1½ gallon kit):** *
- EpoSany-791 HS Primer: 42.6 m²/Lat. at 25 microns.
- EpoSany-791 HS Finish: 41.4 m²/Lat. at 25 microns.

**Mixing and application losses will vary and must be taken into consideration when estimating job requirements. Coverage will be lower over rough surfaces and at higher dry film thicknesses. Heavy applications over organic coatings may result in softening and/or solvent entrapment.**

**Temperature Resistance:** Not affected by steam cleaning. See specific exposure for temperature resistance.

**Recommended System:**
One coat of EpoSany-791 HS Primer at 5 mils (125 microns) DFT. Two coats of EpoSany-791 HS Finish at 5 mils (125 microns) DFT each. An alternate system in one or two coats of EpoSany 791 Finish over ZinCoat-400 HS (Inorganic Zinc Primers.)

**Color Standard in:**
- EpoSany-791 HS Primer: Brick Red only
- EpoSany-791 HS Finish: White(1004A1) and Gray (20002) and Gray (20003) are standard.
- Other colors are available on special order.

**Abrasion Resistance:**
- EpoSany-791 HS Primer: Very Good
- EpoSany-791 HS Finish: Very Good (Chalks-results in fading, most noticeable in dark colors)

**Flexibility:**
- EpoSany-791 HS Primer: Good
- EpoSany-791 HS Finish: EpoSany-791 HS Primer may be applied to properly prepared steel or concrete.

**Gloss:**
- Finish – Semi-Gloss

**Shelf Life:**
- Part A: 24 months when stored at 75 °F (25 °C)
- Part B: 24 months when stored at 75 °F (25 °C)

**Storage Conditions:**
- Store indoors.
- Temp.: 40 - 110 °F (4 - 43 °C)
- Humidity: 0 - 90%

**Topcoat Required:** The most recommended system is EpoSany 791 HS Primer with two coats of EpoSany 791 HS Finish. EpoSany 791 HS Primer may be topcoated with catalyzed epoxies, vinyl, modified phenolics, or other as recommended. Please consult the appropriate system guide, the particular job specification or your SanyChem Coatings Industrial Coatings Specialist for proper systems using this product.

**NOTE:** A mist coat of EpoSany-791 HS is required when applying material over inorganic zinc primers to minimize bubbling.

**COMPATIBILITY WITH OTHER COATINGS:**
- May be applied over ZinCoat-400 HS, or other as recommended.

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APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions, and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

Substrates & Surface Preparation

General:
Remove any oil or grease from surface to be coated with clean rags soaked in SolvenSany # 280 Thinner in accordance with SSPC-SP-1-62.

Steel: Abrasive blast to a white Metal Finish in accordance with SSPC-SP-5 to a degree of cleanliness in accordance with NACE # 1 to obtain a 1-2 mils (25-50 microns) blast profile.

Previously Painted Surfaces: Old coatings should be tested for lifting. If lifting occurs, remove them. Otherwise scrub sand glossy areas and aged epoxy coatings. Clean aged epoxy or urethane coatings with MetalCleaner # 100. Remove cracked occurs, remove them. Otherwise scuff sand glossy areas and aged epoxy coatings. Prime bare areas with a primer specified under New Surfaces.

Concrete: Do not coat concrete treated with hardening solutions unless test patch indicates satisfactory adhesion. Do not apply coating unless concrete has cured at least 28 days at 70 °F (21 °C) and 50 % R.H. or equivalent time. Apply to properly prepared concrete that was acid etched or thoroughly and uniform sweep sandblasted.

Mixing:
Mix part A separately, then add Part B in the following proportions and mix thoroughly: Do not mix partial kits.

1 ½ Gal. Kit. 7% Gal. Kit
1 gallon. 5 gallons 2% gallons

Solvent:
Mixing:
May be thinned up to 20% by volume with Solvensany # 280 Thinner.

Potlife:
2 hours minimum at 75 °F (24 °C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

Application Equipment

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. The following equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

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Spray Application

Spray
Use sufficient air volume for correct operation of equipment. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later. May be applied by hot spray (Temperature not to exceed 95 °F (35 °C)).

The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray
Use a 3/8” minimum I.D. material hose. Hold gun approximately 12-14 inches from the surface and at a right angle to the surface.

Mfr. & Gun Fluid Tip Air Cap.
DeVilbiss P-MBC or JGA E 704
Binks #18 or #62 66 63 PB
I.D. Approx. 0.070” I.D

Airless Spray
Use a 3/8” minimum I.D. material hose. Hold gun approximately 18-20 inches from the surfaces and at a right angle to the surface.

Mfr. & Gun Pump
DeVilbiss JGN-502 QFA-514 or QFA-519
Binks Model 700 Mercury 5C or BB-36 37:1
Graco 205-591 President 30:1 or BullDog 30:1

Use a 0.017” - 0.021” tip with 2100 – 2400 psi.
Filter: 60 mesh

Teflon packings are recommended and available from the pump manufacturer.

Dry Time

Surface Temp. Between Coats Final Cures
50° F (10 °C) 05 days 3 weeks
60° F (16 °C) 02 days 10 days
75° F (24 °C) 18 hours 7 days
90° F (32 °C) 12 hours 7 days

This time is based on the recommended dry film thickness per coat. Higher film thickness will lengthen cure times. Force curing at 150 °F (66 °C) is recommended for all Tank Lining Service after an initial period of 18 hours at 75 °F (24 °C).

Application Conditions

Material Surfaces Ambient Humidity
Normal 65 – 85 °F (18 – 29 °C) 65 – 85 °F (18 – 29 °C) 60 – 90 °F (16 – 32 °C) 65 %
Minimum 50 °F (10 °C) 50 °F (10 °C) 50 °F (10 °C) 0 %
Maximum 90 °F (32 °C) 140 °F (60 °C) 120 °F (43 °C) 85 %

Do not apply when the surface temperature is less than 5 °F or 3 °C above the dew point.

Cleanup & Safety

Brush: Recommended for touch-up only. Use natural bristle brush applying with full strokes. Avoid rebrushing. Two coats may be required for uniform hiding and film thickness.

Roller: Use medium to long nap-roller depending on surface. Thin up to 25% by volume with SolvenSany # 272 Thinner for proper flow-out. Two coats may be required for uniform hiding and film thickness.

For Industrial Use Only. Keep Away From Children. 1/2001

Caution
This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.