

CORCHEM® 239 FIRE TUBE COATING SPRAY APPLICATION EQUIPMENT GUIDE

MIXING	Material is supplied in containers as a pre-measured kit. Complete units should be stored, mixed and applied in accordance with Technical Bulletin.
MIX RATIO	1:3 – 1 part Component A (amine) to 3 parts Component B (epoxy)
WORKING POT LIFE	>4 hours at 70°F (mixed 1-gallon kit), approximately 60 minutes at 70°F (mixed 5-gallon kit) <u>Pot life is significantly shorter for higher temperatures and larger quantities and longer for lower temperatures or smaller quantities.</u> NOTE: Always flush equipment before reaching the end of the working pot life time to avoid material setting up in the equipment. Typically, C239 should be flushed every 45 minutes initially. Time between flushing varies based on site conditions and mixed quantity.
AIRLESS SPRAY (PLURAL COMPONENT)	Not Suitable
AIRLESS SPRAY (HOT POT)	Suitable – Graco or equal Airless Pump 30:1 including outlet filter with 60 mesh screen; 3/8" I.D. or larger high pressure solvent resistant fluid line; Silver plus or equivalent spray gun with .013" to .017" RAC spray tip; 1/2" I.D. or larger air supply line; and continuous air source capable of supplying 80 to 100 cfm @ 80 to 100 psi to the pump
AIR SPRAY (PRESSURE POT)	Suitable – Binks or equal Pressure pot with mechanical agitator, dual air regulators with air gauges, and oil/moisture separators; Spray Gun – Binks 2100 gun with 66 fluid tip, 563 needle, and 6650 or 665K air cap -or- DeVilbiss JGA or MBC with E setup and 704 air cap; 1/2" I.D. or larger air supply line; and continuous air source capable of supplying 20 cfm or more per nozzle and 60 psi to the pressure pot. Regulate pressure as required for proper application. Proportionally adjust pressure higher for smaller hose diameter and/or longer hose length and adjust pressure lower for larger hose diameter and/or shorter hose length. Select tip angles and orifice diameters according to application needs.
BRUSH	Suitable – Short haired, natural bristle brush can be used for the touch-up of small areas or for stripe coating of welds and edges.
THINNER	Do not thin
CLEANER	CORCHEM® 4 thinner or MEK
WORK STOPPAGES	Do not allow mixed material to remain in pump, pot, hoses, gun and/or tip. Thoroughly flush these with CORCHEM® 4 thinner or MEK.
CLEAN UP	Flush and clean all equipment immediately after use with CORCHEM® 4 thinner or MEK. Disassemble and manually clean filter screen, gun fluid nozzle, gun air cap or RAC tip and airless pump or pressure pot as needed. Frequency should depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus material and empty containers should be disposed to comply with the requirements of environmental protection and waste disposal legislation and any regional, local authority requirements.

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