

ENGARD

ENGARD 490 EPOXY PUTTY

ENGARD 490 Epoxy Putty is a high solids epoxy putty catalyzed by a unique activator intended to provide protection for exposed surfaces in severe chemical and physical environments. It is designed to provide an exceptional high build dry film thickness per applied coat. ENGARD 490 Epoxy Putty features superior void and pit filling without sagging, pinholing or mudcracking. It is formulated to have outstanding adhesion and excellent curing under adverse conditions of low temperature and high humidity. This putty is extremely hard, tough, abrasion and chemical resistant. It is self-priming on most surfaces and may be used in combination with many ENGARD products.

STANDARD DATA

COLORS:	Gray	APPLICATION METHODS:	Putty Knife or Trowel
FINISH:	Medium Gloss		
VOLUME SOLIDS:	100%	DRY TIME @ 70F:	Topcoat 2-24 Hours Final Cure - 5 Days (See Suggested Application Procedures, Section 8.)
WEIGHT SOLIDS:	100%		
VOC CONTENT:	0 gms/l 0.0 lbs/gal	COVERAGE:	Dry film spreading rate per gallon:
COMPONENTS:	Two		
POT LIFE @ 70F:	1/2 Hour	Theoretical (no loss)	1600 sqft @ 1 mil 231 cu.in./gallon
THINNER:	ENGARD 43	Practical (20% loss)	1280 sqft @ 1 mil 185 cu.in./gallon
THINNER RATIO:	Thin only if required for proper application.	MIXING RATIO:	Mix complete pre-measured packaged kits. By volume 1 part Component A to 3 parts Component B.
SHELF LIFE @ 70F:	One year from date of shipment.		
DOT/FLASH POINT CLASSIFICATION:	COMBUSTIBLE		

490-030188-1/8



USAGE

ENGARD 490 Epoxy Putty may be considered as a protective filler for voids and pits in concrete and steel storage tanks, piping and processing equipment handling fresh and salt water, sweet and sour crude oil, diesel fuel, greases, lubrication materials, vegetable oils, salts, detergents, alkalies and many other chemicals. ENGARD 490 Epoxy Putty is suggested for buried pipe, sewage plants, refineries, offshore drilling platforms, marine service, pulp and paper industry, dam gates, mining and chemical plants. The principal use for ENGARD 490 Epoxy Putty is in water-chemical problem areas which require a putty with excellent chemical and physical resistance properties.

SERVICE LIMITATIONS

Atmospheric temperature resistance up to 250F and immersion temperature resistance up to 200F depending upon the individual environment. For immersion service and exposure to corrosive chemicals, elevated temperatures or use with cathodic protection systems, CONTACT ENGARD FOR SPECIFIC RECOMMENDATIONS AND INSTRUCTIONS BEFORE PROCEEDING.

ORDERING AND STORAGE

NOTE: Chemical and physical resistance, color and gloss retention, solids content and application properties may be affected by or vary according to color and gloss level selected. Color and gloss variation may occur due to different induction and heat/dry time cure cycles used or if subject to moisture before curing is completed. Color and gloss retention may be affected (yellowing, darkening and/or flattening) by exposure to elevated temperatures. Certain colors may require a white base coat be applied prior to finish coating and/or may require multiple applications in order to achieve satisfactory hiding and uniformity of appearance. All whites and pastel colors are manufactured using chalk resistant titanium dioxide (rutile grade) unless designated or requested specifically otherwise. When ordering or computing working coverage, allow for application loss and surface irregularities. Multiple coats may be necessary to achieve the desired film thickness due to variations in design configuration, application equipment, temperature and other factors. Store in a protected area between 40F and 100F. Material should not be used if storage conditions or suggested shelf life have been exceeded unless found to be satisfactory after reinspection by ENGARD.

SUGGESTED SURFACE PREPARATION

No more surface preparation should be performed than can be properly coated. Round off all sharp edges and rough welds. All burrs and weld spatter should be completely removed. Concrete and masonry should cure at least thirty (30) days and have a moisture content prior to coating below 8% as measured by an instrument such as a Delmhorst Model DP. Wood and composition materials should have a moisture content prior to coating below 15% as measured by an instrument such as a Delmhorst BD-7. Oil, grease and heavy deposits of surface contaminants should be removed by use of ENGARD 9 Solvent Degreaser or ENGARD 7 Surface Cleaner.

All surfaces must be clean, dry and free of any dirt, dust, chalk, grease, oils, salts, curing compounds, release agents, preservatives and other deleterious materials before application is performed. **NOTE:** Vacuuming the topside of all horizontal and sloped surfaces is recommended.

CARBON STEEL: It is recommended for immersion or severe exposures that metal surfaces be prepared in accordance with SSPC-SP10 (Near-White Blast Cleaning). For atmospheric or mild exposures metal surfaces may be prepared in accordance with SSPC-SP6 (Commercial Blast Cleaning). Prepared metal surfaces should have an anchor profile of not less than two mils (.002) as measured by use of a non-destructive instrument such as a Keane-Tator Surface Profile Comparator. Apply an application coat of a suitable ENGARD primer or coating in accordance with ENGARD's instructions after applying this product.

ALLOY STEELS AND NON-FERROUS METALS: Chemically clean surfaces in accordance with SSPC-SP1 (Solvent Cleaning). Abrasive "brush" blast to provide a lightly profiled and etched surface. Apply ENGARD 135 Pretreatment Primer to a dry film thickness of not more than one-half mil (.0005) or apply ENGARD 1 Metal Conditioner in accordance with ENGARD's instructions depending upon the service environment. **NOTE:** Coatings applied to these surfaces may not achieve the same degree of adhesion and toughness.

WELDING: Welding should precede coating. In the event welding or flame cutting is performed on metal already coated with this product, do so in accordance with the latest instructions in U.S.A. Standard Z49:1 "Safety in Welding and Cutting". All welded, burned or otherwise damaged areas should be cleaned to base metal, prepared and recoated as specified.

CONCRETE AND MASONRY: Clean surface by abrasive "brush-off" blast or etch with 10% hydrochloric acid. If etching is employed, the acid solution should be applied at a spreading rate of 1.5 pints per square yard to obtain total wetting of the substrate, and thoroughly worked into the surface by stiff bristled brushes until the bubbling reaction has subsided. **PROTECTIVE CLOTHING AND EQUIPMENT SHOULD BE USED WHENEVER WORKING WITH ACIDS!** The etched surface should then be thoroughly washed and scrubbed with clean water and stiff bristled brushes and/or high pressure water hosing to remove all salts and loose particles. Surface and substrate must be thoroughly dry before proceeding with any coating application. Repair and trowel smooth all cavities and voids with ENGARD 490 Epoxy Putty. Clean silica may be added to ENGARD 490 Epoxy Putty to fill large cavities and voids. Apply an application coat of a suitable ENGARD primer or coating in accordance with ENGARD's instructions after applying this product.

WOOD AND COMPOSITION MATERIALS: Uniformly abrade the surface and feather any irregular edges by hand or power sanding or abrasive "brush" blasting under low pressure. The surface must be roughened sufficiently to provide a profile adequate to insure a bond. Apply an application coat of a suitable ENGARD primer or coating in accordance with ENGARD's instructions after applying this product.

ZINC PRIMED AND PREVIOUSLY COATED SURFACES, POROUS SUBSTRATES, PLASTICS AND MISCELLANEOUS MATERIALS: Contact ENGARD for specific recommendations and instructions before proceeding. NOTE: Coatings applied to these surfaces may require a special tie coat or barrier primer. Always check compatibility before application over a previous coated area.

NOTE: Different ENGARD coatings and/or surface preparation procedures may also be completely satisfactory for use with this product. If, for any reason, additional information, instructions or explanations are needed, refer to the appropriate supplemental technical bulletins and manuals or contact ENGARD before proceeding.

SUGGESTED APPLICATION PROCEDURE

1. Completely read the Product Technical Bulletin and Material Safety Data Sheet before proceeding.
2. Flush all equipment clean with ENGARD 43 Thinner.
3. Add the total contents of Component A (Activator) into Component B (Base). Do not vary these proportions. Power stir thoroughly until completely mixed and continue agitation during application. **EMPTIED CONTAINERS ARE HAZARDOUS BECAUSE THEY RETAIN PRODUCT VAPOR AND RESIDUE.** Properly destroy and dispose of containers after use.
4. Thin only if required for proper application with ENGARD 43 Thinner. Do not exceed applicable volatile organic compound (VOC) regulations.

THINNING CALCULATION EXAMPLES

VOLUME 43 THINNER	GMS/LITER VOC CONTENT	LBS/GAL VOC CONTENT
0%	0	0.00
5%	39	0.33
10%	75	0.63
15%	108	0.90
20%	138	1.15
25%	165	1.38
30%	191	1.59
40%	236	1.97
50%	276	2.30

5. Apply by putty knife or trowel.
6. Pot life of a mixed one gallon kit is approximately 1/2 hour @ 70F. Pot life is significantly shorter at higher temperatures or in larger quantities and longer at lower temperatures or in smaller quantities. **CAUTION! Do not allow catalyzed material to stand in equipment after use!** Clean immediately with ENGARD 43 Thinner.

7. Application at air and surface temperatures lower than 125F and above 40F and more than 5F above the dew point is suggested. If it is necessary to apply this product at temperatures or humidities beyond these preferred limits, contact ENGARD for additional information, instructions and explanations before proceeding.

8. Recoat when material is relatively dry and firm, but before coating reaches complete cure and hardness. Curing times are significantly shorter at higher temperatures or lower thickness and longer at lower temperatures or higher thickness. Suggested immersion or severe exposure topcoat guide for this product at 70F and 50% relative humidity is 2 hours minimum to 24 hours maximum.

There are additional factors which can influence the drying rate such as: the method of application; the quantity of thinner added, if any; the amount of air circulation and ventilation; humidity variations, etc. Allow final dry time of at least 5 days at 70F before placing in operating service. Heat curing may be used to increase drying speed and resistance properties. If desired, after the final coat has been applied, allow solvents to evaporate before gradually raising the temperature until the substrate reaches 150F for a period of 2 hours. NOTE: Contact ENGARD for different heat cure time cycles.

9. If it is necessary to spot repair or topcoat with the same product after this material has reached complete cure and hardness, the following preparation is suggested: Properly clean the areas, then uniformly abrade the surface and feather the edges by hand or power sanding or abrasive "brush" blasting under low pressure. The surface must be roughened sufficiently to provide a profile adequate to insure a mechanical bond. Also, the use of ENGARD 2 Tie Solvent may be desired.

10. Check for desired dry film thickness. Use a non-destructive instrument such as a Mikrotest on ferro-magnetic substrates and an Elcometer "Eddy-Current" Tester on non-ferrous metallic substrates. Use an instrument such as a Tooke Gage on non-metallic substrates when a destructive tester is necessary.

11. On surfaces subject to severe environments, check for pinholes, holidays and bare areas. Use a non-destructive detector such as a Tinker & Razor M-1 on conductive substrates.

12. If the coating is to be subjected to contact with either food or potable water or to protect the purity of stored products, disinfect or decontaminate the fully-cured-coated surface by thoroughly flushing clean with 50 ppm chlorine water solution. Rinse with fresh water and drain to waste. All solvent vapors must be completely removed before placing in operating service.

14. All coatings to be applied in accordance with the latest revisions of Steel Structures Painting Council, American Concrete Institute and the Forest Products Research Society surface preparation and application specifications. If, for any reason, additional information, instructions or explanations are needed, refer to the appropriate supplemental technical bulletins and manuals or contact ENGARD before proceeding.

SUGGESTED FINISH COATING PROCEDURE

If a primer sealer or topcoat is to be applied over this product refer to the appropriate supplemental technical bulletins and manuals or contact ENGARD for specific recommendations and instructions before proceeding. NOTE: Finish or topcoats may require a special tie or barrier primer. Always check for compatibility before application over a previously coated area.

ATMOSPHERIC OR MILD EXPOSURES: All coated surfaces must be relatively firm and have cured for minimum period of 2 hours at 70F and 50% relative humidity and be clean, dry and free of any dirt, chalk, grease, oils, salts, curing compounds, release agents, preservatives and other deleterious materials before the application of the primer or topcoat is performed.

IMMERSION OR SEVERE EXPOSURES: All coated surfaces must be relatively firm and have cured for minimum period of 2 hours at 70F and 50% relative humidity and be clean, dry and free of any dirt, chalk, grease, oils, salts, curing compounds, release agents, preservatives and other deleterious materials before the application of the finish or topcoat is performed. If it is necessary to apply the finish or topcoat over this product after it has reached complete cure and hardness or cured beyond the recommended maximum topcoat period, the following additional preparation is suggested: Uniformly abrade the coated surface and feather the edges by hand or power sanding or abrasive "brush" blasting under low pressure. The surface must be roughened sufficiently to provide a profile to insure a mechanical bond. Also, the use of ENGARD 2 Tie Solvent may be desired.

SUGGESTED APPLICATION EQUIPMENT

PUTTY KNIFE OR TROWEL.

CLOTHING: Wear protective garments, goggles and filter masks. Protective barrier creams should be used on any exposed areas of skin.

IN CONFINED AREAS AND TANKS - READ THIS NOTICE! Use explosion-proof lighting and electrical equipment, non-sparking tools, clothes and shoes. Ground all structures and equipment. Use procedures which prevent static electrical sparks. Wear properly fitted appropriate NIOSH/MSHA approved fresh air respirator such as MSA or equal with 1/4" I.D. or larger air supply line connected directly to proper air source during and after application unless air monitoring demonstrates vapor/mist levels are within safe limits. Use suction type exhaust fans and blowers with sufficient cfm capacity to keep solvent vapors below 20% of the explosive limit. NOTE: Air circulation and exhausting of solvent vapors must be continued until the coatings have fully cured to insure that no potential for fire, explosion or health hazard remains.

NOTE: All equipment and procedures are to conform to the latest safety requirements of applicable regulatory agencies. Follow equipment manufacturer's directions and instructions on all equipment used. Different equipment combinations and equivalent equipment from other manufacturers may be completely satisfactory for use with this product. If, for any reason, additional information, instructions or explanations are needed, refer to the appropriate supplemental technical bulletins and manuals or contact ENGARD before proceeding.

HAZARD WARNING - READ THIS NOTICE!

THIS PRODUCT CONTAINS EPOXY RESINS AND AMINE COMPOUNDS. DO NOT USE IF YOU HAVE HAD A REACTION TO THESE MATERIALS.

WARNING! VAPOR HARMFUL! CAUSES SEVERE EYE AND SKIN BURNS. MAY CAUSE SKIN SENSITIZATION OR OTHER ALLERGIC RESPONSES. HARMFUL OR FATAL IF SWALLOWED!

Keep away from heat, sparks and open flame. Use only with adequate ventilation. Prevent breathing of vapor or spray mists. Wear a properly fitted appropriate respirator during application and until all vapors and spray mists are gone. Prevent contact with eyes and skin. Do not take internally. Keep closures tight and upright to prevent leakage. Keep container closed when not in use. In case of spillage, absorb and dispose of in accordance with local applicable regulations. **FIRST AID:** In case of skin contact, wash thoroughly with soap and water; for eyes, flush immediately with plenty of water for 15 minutes and call a physician. Remove and wash contaminated clothing before reuse. (Discard contaminated shoes). If inhaled, remove to fresh air. If breathing difficulty persists or occurs later, consult a physician and have label and MSDS information available. If swallowed, **CALL A PHYSICIAN IMMEDIATELY. DO NOT** induce vomiting.

IN CONFINED AREAS AND TANKS OBEY SPECIAL SAFETY AND EQUIPMENT INSTRUCTIONS!

FOR INDUSTRIAL USE BY PROFESSIONAL APPLICATORS ONLY. NOT INTENDED FOR SALE TO THE GENERAL PUBLIC. Not to be sold or delivered to any person under 18 years of age. KEEP OUT OF THE REACH OF CHILDREN! If, for any reason, additional product and safety information, instructions or explanations are needed, CONTACT ENGARD IMMEDIATELY!

LIMITED WARRANTY - READ THIS NOTICE!

ENGARD's technical advice, recommendations and services are provided without charge and are carefully based on the most accurate and reliable information we have obtained. All technical information, test results, instructions and suggested recommendations are predicated on storage, application and service performance conditions at an ambient temperature of 70F and 50% relative humidity unless designated specifically otherwise in writing. ENGARD fully warrants and guarantees the uniformity of its products within manufacturing tolerance. However, since the use of ENGARD's products, their application, the regulation of the service environment, their maintenance and routine, etc. are factors beyond its direct control, its products are furnished only upon the condition that the customer shall make his own determination of the suitability of ENGARD's products for his particular purpose, and ENGARD disclaims all responsibility for results obtained or any damages incurred from their usage. THEREFORE, IN THE EVENT THAT THERE ARE ANY DAMAGES WHICH ARISE OUT OF ENGARD'S NEGLIGENCE OR BREACH OF WARRANTY, WE WILL SUPPLY, AT ENGARD'S OPTION, EITHER SUFFICIENT MATERIAL FREE OF CHARGE TO REPLACE ANY DEFECTIVE PRODUCTS OR REFUND OF THEIR PURCHASE PRICE FOR A ONE YEAR PERIOD FROM DATE OF PURCHASE. Failure to give written notice of claim within one year from date of delivery shall constitute a waiver of all claims in respect to such products. **THERE ARE NO OTHER WARRANTIES EITHER EXPRESSED OR IMPLIED WHICH ARE NOT STATED HEREIN!**