

SELECTION & SPECIFICATION DATA

Type	Cycloaliphatic Amine-Cured Novolac Epoxy
Description	Densely cross-linked, 100% solids epoxy novolac coating that provides superior long-term resistance to a wide range of acids, salts and strong caustics. The outstanding adhesion properties of Fluid Flow Liquid Epoxy make it ideal for use on marginally-prepared substrates while delivering maximum performance. Outstanding adhesion to previously epoxy-coated substrates provides extended recoat window.
Features	<ul style="list-style-type: none"> • Excellent thermal compatibility with steel and concrete • Low permeation rate for tank lining service • Solvent free - 100% solids • Plural or single leg application • Quick return-to-service - 24 hours at 77°F (25°C) for hydrocarbon immersion service • Single-coat application
Uses	<ul style="list-style-type: none"> • High-temperature immersion tank lining • Crude oil storage to 350°F (177°C) • Floors and chemical trenches in process areas • Secondary containment areas • Bulk petroleum storage tank lining • Process equipment supports and pads • Truck loading and unloading pads • Internal pipeline, vessel and bulk storage tank linings
Color	Putty, Light Gray, White, Beige
Finish	Gloss
Dry Film Thickness (DFT)	15 - 24 mils per coat
Solids Content	99 - 100% by volume

SUBSTRATES & SURFACE PREPARATION

All	Substrate must be clean, dry and free of contaminants.
Steel	<p>Immersion: SSPC-SP 10/NACE 2 Near White Metal Blast with angular profile of 2.5 - 3.5 mils.</p> <p>Non-immersion: SSPC-SP 6/NACE 3 Commercial Blast with angular profile of 1.5 - 3.0 mils, SSPC-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.</p> <p>Self-priming on steel.</p>
Concrete or Concrete Masonry Units (CMU)	Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with SSPC-SP 13/NACE 6. Required surface profile is CSP 3-5. Voids in concrete surfaces may require filling. Mortar joints should be cured a minimum of 15 days. Prime with RR&C Concrete Epoxy Primer.
Previously Painted Surfaces	Consult with your Sherwin-Williams representative.

MIXING & THINNING

Ratio	3A:1B by volume
Mixing	For single leg spray, brush or roller, power mix parts A and B separately, then combine and power mix.
Thinning	<p>Spray: Up to 6.5 oz/gal (5%) with Sherwin-Williams 54 reducer</p> <p>Brush: Up to 16 oz/gal (12%) with Sherwin-Williams 54 reducer</p> <p>Roller: Up to 16 oz/gal (12%) with Sherwin-Williams 54 reducer</p>
Pot Life	35 minutes at 75°F (24°C)
	Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.
Cleanup	MEK or Acetone

APPLICATION GUIDELINES

Spray Application	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Airless Spray Plural Component	<p>Tip Size: 0.021-inch - 0.027-inch reversible type</p> <p>Part A Fluid Line: 1/2-inch ID</p> <p>Part B Fluid Line: 3/8-inch ID</p> <p>Spray Line: 1/2-inch ID x 100 feet maximum</p> <p>Whip: 1/4-inch - 3/8-inch ID</p> <p>Length of Whip: 6 feet maximum</p> <p>Pump Size: 56:1 or greater</p> <p>Static Mixer: 2 x 1/2-inch ID x 12-inch line (24-inches total) in length behind mixing valve</p> <p>Part A Temperature: 130°F - 135°F (54°C - 57°C)</p> <p>Part B Temperature: 90°F - 95°F (32°C - 35°C)</p> <p>Output: 4000 - 6000 psi, filter removed</p>
Airless Spray Single Leg or Hot Pot	<p>Pump Size: 56:1 (minimum)</p> <p>Hose Length: 50 ft x 3/8-inch ID (minimum)</p> <p>Whip Length: 10 ft x 1/4-inch - 3/8 in ID (minimum)</p> <p>Tip Size: 0.021-inch - 0.027-inch</p> <p>Output: 4300 - 6000 psi, filter removed</p>

Brush & Roller	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie in within 10 minutes at 75°F (24°C).
Brush	Use a medium bristle brush.
Roller	Use a short-nap synthetic roller cover with phenolic core.

CURE SCHEDULE & RECOAT WINDOW

SUBSTRATE TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN TO SERVICE (IMMERSION)
50°F (10°C)	8 hours	14 days	14 days
77°F (25°C)	3 hours	14 days	7 days
140°F (60°C)	30 minutes	1 hour	4 hours

Dry-to-touch: 4 hours at 77°F (25°C)

Return-to-service varies with chemical exposure. Consult with your Sherwin-Williams representative for guidance.

RR&C Fluid Flow Liquid Epoxy

PACKAGING, ESTIMATING & HANDLING

ITEM#	PRODUCT	PACKAGING
FFLE-1GLKT-SW	RR&C Fluid Flow Liquid Epoxy, Putty - Part A Resin, Beige - Part B Hardener, Black	0.75 gal (2.8 L) 0.25 gal (0.95 L)
Theoretical Coverage	106 square feet per gallon at 15 mils 66 square feet per gallon at 24 mils Allow for loss in mixing and application.	
Storage & Shelf Life	Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 12 months when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions. If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with your Sherwin-Williams representative.	
<u>SAFETY</u>		
Safety	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.	
Ventilation	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.	

TYPICAL PHYSICAL PROPERTIES

PROPERTY	SYSTEM	VALUE
Dry adhesion ASTM D4541	Blasted steel 1 coat	>3,000 psi
Wet adhesion ASTM D4541 5 days 158°F (70°C) water	Blasted steel 1 coat	>3,000 psi
Abrasion resistance ASTM D4060 1000 cycles CS17 wheel 1000 g load		63 mg loss 1,960 cycles per mil
Compressive strength ASTM C109	Blasted steel 1 coat	10,000 - 13,000 psi
Hardness ASTM D2240	Blasted steel 1 coat	83 - 90 Shore D

SERVICE TEMPERATURE

SERVICE	MAXIMUM TEMPERATURE
Dry, continuous	350°F (177°C)
Under insulation, continuous	300°F (149°C)
Temperature limitations will vary with chemical exposure. Consult with your Sherwin-Williams representative for guidance.	
Discoloration and loss of gloss occur above 200°F (93°C) but do not affect performance.	

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