

TECHTHANE[®] 98SS-HB HIGH PERFORMANCE ELASTOMER SPRAY LINING

DESCRIPTION

TECHTHANE 98SS-HB is a high-build batch-mix urethane elastomer lining applied with standard airless spray equipment. 98SS-HB forms a semi-rigid elastomeric lining that flexes with expansion and contraction, seals seams, and bridges gaps. 98SS-HB resists corrosion from many acidic and caustic solutions, and abrasion from fine particles and sliding objects. 98SS-HB bonds highly to prepared substrates. As an aliphatic-hybrid polyurea urethane, 98SS-HB has better hydrolytic stability, UV stability, and resistance to many chemicals than aromatic urethanes/polyureas, and is not affected by moisture during application as are standard urethanes. Individual coats of up to 30 mils (0.75 mm) DFT can be applied to vertical surfaces without sag, and coatings up to 250 mils (6.00 mm) DFT can be built with multiple coats. Typical applications involve corrosion protection and sealing where a lower coefficient of friction when dry is required compared to softer TECHTHANE linings.

PROPERTIES OF CURED LINING

Typical physical properties of TECHTHANE 98SS-HB sprayed and cured under normal conditions are as follows:

PROPERTY	VALUE ^a
Hardness, Shore A (ASTM D2240)	96
Tensile Strength (ASTM D412)	4,200 psi (29.00 MPa)
Elongation (ASTM D412)	350 %
100% Modulus (ASTM D412)	1,500 psi (10.35 MPa)
Tear Strength, Die-C (ASTM D624)	475 pli (83.15 kN/m)
Tear Strength, Split (ASTM D470)	100 pli (17.50 kN/m)
Film Density (ASTM D792)	0.96 g/cm ³
Abrasion Resistance, wet fine particle (Sand Slurry)	333% > steel
Adhesion, linear peel, to prepared substrates (ASTM D429)	75 pli (13.15 kN/m)
Surface Finish (Subjective)	semi-gloss to matte
Color	see 'Availability'

PROPERTIES OF LIQUID COMPONENTS

Typical properties of TECHTHANE 98SS-HB's liquid components are as follows:

PROPERTY	PART 'A'	PART 'B'	MIXED (A+B)
Solids Content, by volume, %	89.87	18.87	54.37
Weight, lbs./gal. (g/L)	8.46 (1014)	8.06 (966) ^b	8.26 (990)
Viscosity, cps/mPs @ 75°F (24°C)	4,500	175	250
Flash Point, TCC, °F (°C)	40 (4)	24 (-4)	24 (-4)
VOC, lbs./gal. (g/L)	0.73 (88)	6.11 (732)	3.42 (410)

APPLICATION SUMMARY (See following pages for further application information)

PROPERTY	
Application Environment	50-120°F (10-48°C), 0-100% R.H.
Application Equipment	single-component airless
Mix Ratio, A:B	1:1 by volume
Pot Life	60-70 minutes @ 75°F (24°C)
Coverage	850 mils/ft. ² /gal. (0.53 mm/m ² /L)
Per Coat Vertical/Horizontal Build, DFT	5-30 mils (0.10-0.75 mm)
Maximum Lining Thickness, DFT	250 mils (6.25 mm) ^c
Recoat Window, direct-to-basecoat (unprepped)	30 min.- 4 hours @ 75°F (24°C) for ultimate adhesion 12 hours @ 75°F (24°C) for 50 pli (8.75 kN/m) +

CHEMICAL COMPATIBILITY

TECHTHANE 98SS-HB is usable with a wide variety of chemicals and solutions, with compatibility typically best within the pH range of 2-12. Following is a brief overview of chemical compatibility:^d

CONTACT	BRIEF	SUSTAINED
Acid, Hydrochloric 5%	G	G
Acid, Phosphoric 10%	G	G
Acid, Phosphoric 30%	G	F
Acid, Sulfuric 10%	G	G
Acid, Sulfuric 30%	G	F
Ammonium Hydroxide	G	G
Fuel Oils	G	G
Gasoline	G	G
Water / Salt Water	G	G
Water, Chlorinated 1 ppm	G	G
Water, Chlorinated 4 ppm	G	F
Sodium Hydroxide 10%	G	G
Solvents	G-F	F-P

G: Good F: Fair P: Poor

TEMPERATURE COMPATIBILITY

TECHTHANE 98SS-HB is generally suitable for use in dry service up to 180°F (82°C), and wet or humid service up to 150°F (65°C). Chemicals and other variables may affect elevated temperature performance and adhesion. Although 98SS-HB becomes more rigid at lower temperatures, it remains flexible below -70°F (-57°C).

ABRASION RESISTANCE

For fine-particle slurry and impingement abrasion resistance, TECHTHANE 98SS-HB has shown to be superior to many other materials. The figures below are results of the *Sand Slurry Abrasion Test*, the most relevant test for elastomeric materials and wet, fine-particle abrasion.* A relative volume loss of 30 for TECHTHANE 98SS-HB indicates an abrasion resistance approximately 400% greater than steel:

MATERIAL	RELATIVE LOSS FROM ABRASION	RESISTANCE, AS % OF STEEL
TECHTHANE 180	5	2000
TECHTHANE 90SS-MB	14	714
UHMW Polyethylene	22	454
TECHTHANE 98SS-HB	30	333
A.R. Steel	62	161
304 Stainless Steel	82	122
Carbon Steel	100	100
H.D. Polyethylene	218	-218
PVC	532	-532
6061 Aluminum	1042	-1042

ADHESION

TECHTHANE 98SS-HB requires substrates be properly prepared and primed to achieve its reliable, high adhesion. With the appropriate preparation and primer, adhesion to metal, concrete, and composite substrates is typically in the range of 65-100 pli (11.5-17.5 kN/m).

COVERAGE

The theoretical dry coverage of sprayed TECHTHANE 98SS-HB is 850 mils/ft.²/gal (0.53 mm²/L). For example, approximate coverage is as follows:

850 ft. ² /gal. @ 1 mil	0.53 m ² /L @ 1.00 mm
28.3 ft. ² /gal. @ 30 mils	0.26 m ² /L @ 2.00 mm
14.1 ft. ² /gal. @ 60 mils	0.18 m ² /L @ 3.00 mm
6.8 ft. ² /gal. @ 125 mils	0.13 m ² /L @ 4.00 mm
3.4 ft. ² /gal. @ 250 mils	0.11 m ² /L @ 5.00 mm

Note: Actual coverage rates vary by application and equipment.

SUGGESTED LINING THICKNESS

SERVICE TYPE	THICKNESS (DFT)
sealing, general corrosion	20-40 mils (0.50-1.00 mm) +
crack-bridging, light abrasion	40-60 mils (1.00-1.50 mm) +
moderate abrasion, impact	100 mils (2.50 mm) +
heavy abrasion, impact	250 mils (6.25 mm) + ^f

APPLICATION ENVIRONMENT

TECHTHANE 98SS-HB is best applied between 60-120°F (15-48°C), although temperatures outside this range are acceptable with allowances. TECHTHANE 98SS-HB is not affected in application by humidity and can be applied with 0-100% humidity (Substrate corrosion may be a problem at high humidity levels, however).

CURE TIME

The time required for TECHTHANE 98SS-HB to cure depends on coating surface temperature and thickness. Cure is faster with higher temperatures and thin coats, and slower with lower temperatures and thick coats. Also, a same thickness lining built with many thin coats cures faster than one built with fewer thick coats. For reference, cure times for a single, 30 mil (0.75 mm) WFT coat at selected constant temperatures are listed below. Applicators/end users must adjust their times accordingly.

CURE	50°F (10°C)	75°F (24°C)	100°F (38°C)
gel (recoat minimum)	1 hr.	35 min.	20 min.
tack-free	3 hrs.	1.5 hrs.	50 min.
75%	6 days	2 days	1.5 days
95% ('full')	9 days	6 days	3 days

75% cure is normally sufficient for immersion and light impact, and 95% cure for more severe use. TECHTHANE 98SS-HB will continue to strengthen and have greater physical properties after aging several weeks. Coated items should be put into service only after sufficient cure.

AVAILABILITY

PACKAGING: 2, 10, and 100 gallon sets.

COLOR: Gray, tan, blue, black, orange, yellow, green, and white. Custom colors available.

EQUIPMENT REQUIREMENT

TECHTHANE 98SS-HB is best applied with standard, industrial-grade, air-powered, airless spray equipment. Following is a list of general equipment guidelines:

COMPONENT	REQUIREMENT
Spray Machine Pump	Single-component, Air-powered
Air:Fluid Pressure Ratio	23:1+
Packings	Teflon
Ground	Earth Ground
Spray Hose	Heavy-duty Industrial
Size	1/4"–3/8" (6.00–9.00 mm)
Core	Teflon or Nylon
Pressure Rating	3,000 psi (20 MPa)
Conductivity	Conductive
Spray Gun	Single-component Airless
Tip Size	0.018"–0.025" (0.45–0.62 mm)

A 'Jiffy Mixer' or similar on an air drill is required for mixing the components.

APPLICATION INSTRUCTIONS

Surface Preparation

For proper, high adhesion, TECHTHANE 98SS-HB should only be applied to surfaces that have been properly prepared. In most cases this means cleaning, gritblasting, re-cleaning, and priming. The following is a brief overview of surface preparation requirements – refer to the appropriate TECHGRIP™ primer's Product Data Bulletin for additional instructions.

Metal: Detergent wash, grind down edges to a 1/8" (3.00 mm) radius, grit-blast, clean, prime with TECHGRIP M3, C2, or C1/FG1 combination.

Concrete: Let age 28 days, water blast, allow to dry, fill large holes with TECHGRIP C1, fill cracks with T150 caulk, prime with C2 or C1/FG1 combination.

FRP/Epoxy: Clean, grind down edges to a 1/8" (3.00 mm) radius, sand or grit blast, clean, prime with TECHGRIP FG1.

Cured Urethane Elastomer: Clean with MEK or detergent, abrade, wipe with MEK, prime with TECHGRIP E1.

Rubber: Detergent wash, abrade, clean with MEK, prime with TECHGRIP R1 or E1, spot test prior to full-scale use.

Fabric/Cloth: No surface preparation is normally required for clean, open-weave fabrics.

Mixing Components

Do not open or mix Part 'A' or 'B' until ready to use.

1) Re-mix the Part 'B' component prior to each use, and also the Part 'A' component if it has or may have been exposed to cold temperatures. This is especially important if less than the entire container is to be used at one time.

2) Measure out equal amounts of Part 'A' and Part 'B' by volume, for example, 1 gallon Part 'A' and 1 gallon Part 'B'.

3) Add the Part 'B' into the Part 'A' container. Make sure to get all of the Part 'B' out of its container.

4) Blend the mixture thoroughly with a jiffy-mixer or sheer blade on an air drill at high speed. Reach all parts of the container, taking care to blend in the material along the side walls and in the corners of the container. Half-way into the mixing process, stop, scrape the side walls, bottom, and corners of the container with a straight-edge to prevent any unmixed Part 'A' material from remaining there, and thoroughly blend the entire container once more. (Complete mixing time is normally about 5 minutes for a 5 gal./ 20L mix)

5) Transfer the mixture into a neutral container. It is ready to be sprayed at this point.

Pot Life

The pot life of mixed TECHTHANE 98SS-HB varies by material temperature:

TEMPERATURE	POT LIFE
50°F (10°C)	80-90 min.
75°F (24°C)	60-70 min.
100°F (38°C)	45-55 min.

Note: Coats applied at the beginning of the pot life will be smoother and denser than coats applied at the end of the pot life. For smoothest surface appearance, apply the last coat(s) with a freshly-mixed batch.

Application

1) Set the spray machine to the lowest possible pressure that gives a good spray pattern with the spray tip being used (typically ~60 psi with a 0.020" tip).

2) Apply coats in a smooth and even, overlapping manner, avoiding runs and sags that occur when areas are applied too thick. Apply a minimum of 5 wet mils (0.10 mm) and a maximum of 40 wet mils (1.00 mm) per coat. Let base coats solidify prior to applying additional coats.

Let each base coat solidify prior to applying any additional coats. Be sure that recoats are in accordance with 'RECOAT TIME AND PREPARATION' on the following page.

3) When finished coating, let the coated surface properly cure prior to handling or placing into service.

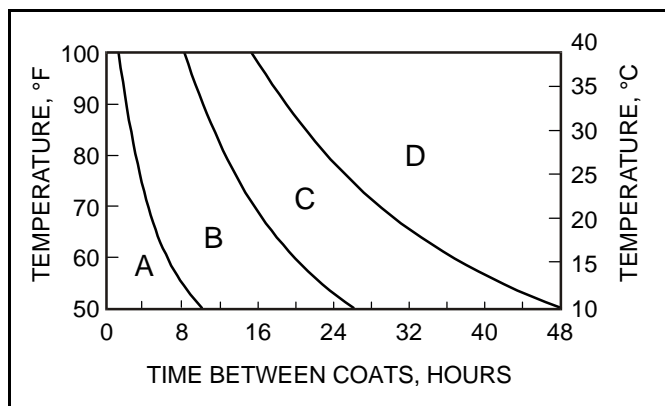
Recommendations:

- Smoothen tight corners with TECHTHANE T150 caulk prior to coating.
- Overlap flange and lip edges.
- Avoid leaving coating-substrate interface seams exposed to service.
- Rotate moveable objects on a turning fixture for fastest build, most consistent thickness & coverage, and best surface finish.
- Topcoat with TECHTHANE 90SS-FF or 98SS-FF for a high gloss finish.

Note: Do not apply 98SS-HB when the temperature of the substrate is less than 5°F (2.8°C) above the dew point, when the ambient temperature is below 50°F (10°C), or when the substrate is expected to become wet prior to application.

Recoat Time and Preparation

Elapsed time and surface temperature determine the level of surface preparation required between coats of TECHTHANE 98SS-HB to get reliable, strong adhesion. In most cases, no extra preparation is required -- additional coats can be applied directly over previous coats. However, if a new coat is to be applied to an old coat outside of its 'no-prep' 'Recoat Window,' than various levels of surface preparation are required to ensure the *highest level* of adhesion. The chart below is provided as a general guide in determining the recommended preparation level. To use the chart, move up from the appropriate 'Time Between Coats' and across from the appropriate 'Temperature' listing -- the resulting point identifies what preparation is required, as stated below the chart. If in doubt, use the greater preparation level.



AREA RECOMMENDED PREPARATION BEFORE RECOATING

A	No preparation required
B	Wipe surface with MEK, allow to evaporate
C	Wipe surface with MEK, prime with TECHGRIP E1
D	Buff, wipe surface with MEK, prime with TECHGRIP E1

CLEAN UP

Use toluene or xylene to clean uncured TECHTHANE 98SS-MB from mixing and application equipment. Cured 98SS-MB must be soaked for removal. To ensure continued proper application of 98SS-MB, spraying and mixing equipment should be flushed and cleaned immediately after use to prevent build-up of cured 98SS-MB on internal parts.

Dispose of used containers in accordance with local, regional, and national regulations.

STORAGE AND SHELF LIFE

Store TECHTHANE 98SS-HB containers in a cool, dry area away from potential exposure to heat, sources of ignition, direct sun, or large variations in temperature. Under these conditions, the shelf life of unopened containers is 1 year minimum from date of shipment. Reseal opened containers quickly.

SAFETY

TECHTHANE 98SS-HB Part 'B' and the Part 'A' and 'B' mixture are flammable. Avoid exposure of the product to sparks, flames, and heat sources. Use only non-sparking motors and equipment throughout application of TECHTHANE 98SS-HB.

TECHTHANE 98SS-HB Part 'A' contains isocyanates (aliphatic) and solvent, and Part 'B' contains amines and solvent. Avoid overexposure by inhalation, eye contact, skin contact, or ingestion. To reduce inhalation potential, use only in well-ventilated areas that minimize exposure to product and wear proper respiratory protection. For indoor or confined areas, forced-air ventilation is required to draw vapor away. While working in confined areas such as enclosed or narrow tanks, fresh-air breathing equipment is required. In applications with *adequate* ventilation, chemical cartridge masks designed for organic vapors are acceptable when used in accordance with their guidelines. To avoid eye contact, chemical splash goggles must be worn. To avoid skin contact, impervious protective clothing must be worn. Wash thoroughly after application.

Refer to the Material Safety Data Sheet (MSDS) for further information prior to use of this material. MSDS available 24 hrs. at 888-TECHFACTS / 540-667-2664 (MSDS # 100, 101).

FOR INDUSTRIAL USE ONLY.

a) Figures are based on sprayed specimens of 60–120 mils (1.50–3.00 mm) DFT, cured 7–21 days at 75°F (24°C) average, and are typical of actual applicator field results. NOTE: These figures should not be compared with 'best-case' sprayed figures or figures based on cast, poured, or thin-film/drawn-down laboratory specimens processed and cured under unrealistic, optimum conditions as done by other manufacturers.

b) Varies by color choice.

c) Total thickness can be greater by applying thinner coats and/or allowing extra time between each coat. Contact your rep. for more information.

d) Users are advised to conduct their own tests prior to use. For more extensive, general compatibility information, refer to 'Chemical Compatibility of TECHTHANE.'

e) The Sand Slurry Abrasion Test is used to estimate the abrasion resistance of materials to solutions containing fine, abrasive particles. In the test, materials are subjected to an abrasive sand/water solution for several hours. After thorough drying, their volume lost to abrasion is measured and compared to steel. Field service results show the test to be an accurate indicator of actual service performance for all fine abrasives. Note: Taber and other tests designed for hard materials and dry, sliding abrasion are not relevant to this type of product nor the type of abrasion to which they are typically subjected, and provide no useful data to this effect.

8/25/98

The information herein is to assist persons in determining whether our products are suitable for their applications. Because we cannot anticipate the conditions under which this information or our products may be used, the information should not be construed as an express or implied warranty of merchantability or fitness for any particular purpose. Users are advised to conduct their own tests to determine the suitability of any of our products for any particular purpose. The exclusive remedy for all proven claims is replacement of our products and in no event shall we be liable for special, incidental, or consequential damages. Nothing in this bulletin is to be considered as a recommendation to use this product so as to infringe on any patent.