

Madewell® 1312C™

100% Solids Polyamidoamine Epoxy Coating



FEATURES/BENEFITS

NONTOXIC	LONG POT LIFE
EXCELLENT ADHESION	IMPACT RESISTANT
SUPERIOR RECOATABILITY	ABRASION RESISTANT
HIGH WATER RESISTANCE IN IMMERSION	EASY TO CLEAN SURFACE

PRODUCT DESCRIPTION

MADEWELL 1312C is a heavy duty, 100% solids, two component polyamide epoxy coating. It is used for both new construction and maintenance of steel and concrete surfaces such as pools, tanks, sumps, trenches, decks, pipe interiors, process equipment, and other structures in the sanitary sewer, aquarium lining, chemical processing, power, refining, mining, pulp and paper, and oil refining industries.

MADEWELL 1312C protects surfaces against chemical attack under immersion, spill, and splash conditions as well as impact and abrasion damage caused by rough use or heavy traffic. It is normally applied at a nominal thickness of 10 to 20 mils in two coats. Its monolithic construction resists moisture, chemical, and bacteria penetration while being attractive and easy to clean. Its free spreading characteristics, fast set time, and ease of cleanup help to minimize labor costs and down time.

PRODUCT DATA

COMPOSITION:

100% solids, modified epoxy coating.

FINISH:

Gloss.

COLORS:

Standard: black, dark gray, medium gray, warm gray, light gray, white, dark blue, ocean blue, safety blue, diego blue, light blue, teal, seafoam green, forest green, brown, tan, khaki, pewter, and clear. Contact a Madewell Technical Representative for a standard color chart.

Custom colors available upon request.

THICKNESS:

10 to 20 mils in one or two coats, depending on the application. Consult a Madewell Technical Representative for specific recommendations.

COVERAGE:

Approximately 75 square feet (ft²) per gallon at 20 mils; 338 ft² per 4.5-gallon kit at 20 mils. Allowances should be made for waste.

PACKAGING:

Normally stocked in 4.5-gallon, two-component kits; special packaging available.

SURFACE PREPARATION:

Steel: Apply only to clean, sound surfaces. All metal surfaces should be degreased and decontaminated prior to abrasive blast cleaning. For immersion service, surfaces should be abrasive blast cleaned to a white metal (NACE No. 1 or SSPC SP 5) condition with a dense 2 to 4 mil anchor profile depth.

Concrete: Do not apply this product directly to concrete. At a minimum, concrete surfaces should be primed with **MADWELL 927** Penetrating Epoxy Primer. Deteriorated concrete may be restored using **MAINSTAY ML-72** or **ML-72F** Sprayable Microsilica Restoration Mortar followed by **MADWELL 927** Primer. Consult a Madewell Technical Representative for specific recommendations or see appropriate product data sheets for additional information.

EXTREMELY ROUGH SUBSTRATES & DEEP VOIDS:

Extremely rough or deteriorated concrete could be more economically smoothed and/or repaired using **MAINSTAY ML-72** or **MAINSTAY ML-72F** Mortar – see applicable product data sheets or contact a Madewell Technical Representative for more information.

SMOOTHING MINOR SURFACE IRREGULARITIES:

Use **MADWELL 1312P** Sprayable Epoxy Putty to smooth minor surface irregularities (less than 1/8" deep).

PRIMING:

Not required for steel surfaces. Concrete surfaces may be primed with **MADWELL 927** Primer. See product data sheet for surface preparation and application instructions. Apply **MADWELL 1312C** to primed surfaces when the **MADWELL 927** Primer has cured dry to the touch (but as soon as possible thereafter to avoid contamination of the primed surfaces).

MIXING RATIO:

Mix components at a volume ratio of 1.5 parts A to 1 part B. Whenever possible, avoid mixing partial kits.

MIXING:

This a two component system. All components (liquids A and B) should be between 70° Fahrenheit (F) and 90° F prior to mixing. The entire contents of each component should be thoroughly mixed individually before combining separate components together. If it is not possible to mix an entire kit, pour carefully measured quantities of both components into a clean container and blend thoroughly using a power agitator, such as a Jiffy® mixer, and a high strength industrial drill for 3 minutes. Do not mix more material than can be used within stated working times.

Note: **MADEWELL 1312C** has a 30 minute induction time, depending on temperature. After initial mixing, allow **MADEWELL 1312C** to sit for 30 minutes prior to re-mixing.

WORKING TIME:

Approximately 70 minutes at 70° F. Working time will be extended somewhat at lower temperatures and shortened when higher.

THINNING:

Thinning is not recommended.

APPLICATION:

This product is to be applied by trained workmen using specialized equipment. Both components must be preheated between 70° F and 90° F prior to application. A minimum 45:1 airless spray pump with an air input pressure of 50-90 pounds per square inch (psi) may be used to feed material through up to 50' of 3/8" diameter hose to a standard airless spray gun with a 0.21" to 0.025" reversible tip. It is recommended that

60 mesh in-line strainers/filters be used. Other equipment, such as whip hoses, heaters, or plural component equipment may be employed. **MADEWELL 1312C** can also be applied by brush or roller. Contact a Madewell Technical Representative for specific application equipment recommendations.

NUMBER OF COATS:

Depends on service requirements. Generally speaking, linings or coatings for immersion service should be holiday free. The number of coats required to attain a holiday free lining or coating may vary depending on surface profile or roughness. Single coat applications should be done in multiple passes, each made at right angles to the last.

CURE TIME:

Recoat Time: At a minimum, the product should be tack free when recoated. Maximum recoat time is 7 days 73° F.

Immersion Service: 24 to 72 hours, depending on the chemical service and cure temperature.

CLEAN UP:

Use xylene or methyl ethyl ketone (MEK) to clean application equipment. Skin should be cleaned using warm, soapy water or commercial hand cleaner.

DELIVERY & STORAGE:

Check containers for damage, and verify quantities before accepting shipments. Store components in sealed containers in a dry environment at moderate temperature conditions (40° F to 80° F).

SHELF LIFE:

1 year, depending on storage conditions, subject to reinspection thereafter.

SAFETY:

KEEP OUT OF REACH OF CHILDREN.

FOR INDUSTRIAL USE ONLY.

MADEWELL 1312C contains epoxy resins that *MAY CAUSE EYE, SKIN, RESPIRATORY, OR NERVOUS SYSTEM SENSITIZATION*. Adequate health and safety precautions should be observed during all storage, handling, use, and drying periods. For best results and safest usage, user is specifically directed to consult the current Safety Data Sheet for this product. When using this product in a confined space or closed area, consult the current Occupational Safety and Health Administration (OSHA) or American National Standards Institute (ANSI) bulletins on safety requirements. Do not take internally. If swallowed, call a physician immediately. Keep away from open flame, and keep containers tightly closed when not in use.

WARRANTY:

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