



**HPC/Industrial Maintenance**

**COAL CAT® Resinous Cured Coal Tar Epoxy Coating**

**Generic Type**

Two component, polyamide-cure type

**Tinting and Base Information**

Do Not Tint	
97-640	Component A- Black
97-641	Component B

**General Description**

Intended for heavy industrial coating systems for immersion and environmental resistance to: fresh and salt water, many organic and inorganic acids, inorganic bases and salts, crude oils, petroleum and petro-chemical products, oil brines, sewage water, hydrogen sulfide liquors and fumes.

**Recommended Uses**

- Concrete
- Metal
- Galvanized Metal

**Features / Benefits**

Excellent resistance to alkalines, salts, oxidizing agents and most acid dilutions.  
Recommended for immersion service.  
Perfect for tanks, pipes and structural steel in heavy industrial areas.

**Limitations of Use**

**DO NOT USE FOR POTABLE WATER.** Not intended for residential use. While this product will lose gloss and chalk on exterior exposure, film integrity is not adversely affected. Do not attempt to apply enough material with a single spray pass to deliver the required 6-7 mils dry per coat. Do not apply over surfaces with dew or moisture condensation on them, or when the relative humidity and ambient air temperatures are near the dew point, which might cause moisture to form.

**Product Data**

<b>Gloss:</b>	High Gloss initially
<b>VOC*:</b>	1.95 lbs/gal 235.00 g/L
<b>Coverage:</b>	165 to 193 sq ft/gal (15 to 18 sq. m/3.78L)
<i>Note: Does not include loss due to varying application method, surface porosity, or mixing.</i>	
<b>DFT:</b>	6.0 minimum to 7.0 maximum
<b>Weight/Gallon*:</b>	10.0 lbs. (4.5 kg) +/- 0.3 lbs. (136 g)
<b>Volume Solids*:</b>	72.2% +/- 2%
<b>Weight Solids*:</b>	80.5% +/- 2%
<b>Mix Ratio:</b>	4 parts Comp. A to 1 part Comp. B
<b>Clean-up:</b>	PPG 97-725 Epoxy Thinner

Results will vary by color, thinning and other additives.

\*Product data calculated on mixed product

**Drying Time:**

To Touch:	2 hours
To Handle:	6 hours
To Recoat:	16 hours

Dry Time @77°F (25°C); 50% relative humidity

**Pot Life:** 9 hours

**In Service Temperature:**

Dry Heat (F): 325° Dry Heat (C): 162°

<b>Flash Point:</b>	97-640 90°F, (33°C)
	97-641 65°F, (18°C)

Remove all loose paint, mill scale, and rust. The surface to be coated must be dimensionally stable, dry, clean, and free of oil, grease, release agents, curing compounds, and other foreign materials.

**NON-IMMERSION SERVICE:** The minimum surface preparation for substrates is SSPC-SP6 Commercial Blast cleaning, NACE Number 3. Service life of coating is in direct proportion to surface preparation.

**IMMERSION SERVICE:** Near White Metal Blast SSPC-SP10, NACE Number 2, is mandatory. The surface to be coated must be clean, dry, and well prepared to receive the coating.

HPC Systems in Detail Brochure (H10788) COATING SYSTEMS: 1-HD, 3-HD, 4-HD, 6-HD, 46-HD.

For specific recommendations, see your Pittsburgh Paints dealer or call 1-800-441-9695.

### Recommended Primers

none Self priming on properly prepared surfaces.

### Application Information

#### Recommended Spread Rates:

Wet Mils :	8.3	minimum to	9.7	maximum
Wet Microns:	210.8	minimum to	246.4	maximum
Dry Mils :	6.0	minimum to	7.0	maximum
Dry Microns:	152.4	minimum to	178.0	maximum

**Application Equipment:** Changes in application equipment, pressures and/or tip sizes may be required depending on ambient temperatures and application conditions.

**Conventional Spray:** Fluid Nozzle: DeVilbiss MBC-510 gun, with 704 or 777 air cap with D or E tip and needle, or comparable equipment. Atomization Pressure: 55 - 70 Fluid Pressure: Can not specify, dependent on numerous factors.

**Airless Spray:** Pressure 3000 psi, tip 0.017" - 0.025"

**Brush:** High Quality Natural Bristle Brush

**Roller:** Not Recommended.

#### Thinning:

Where permitted by local VOC regulations the following thinning recommendations may be used.

Conventional Spray up to 12 oz. per gallon with 97-725 Thinner

Airless Spray up to 12 oz. per gallon with 97-725 Thinner

Brush up to 64 oz. per gallon with 97-725 Thinner

Roller not applicable

### Directions for Use

The 97-640 should be thoroughly agitated with a mechanical mixer before and during the time the curing agent, 97-641, is being added. After the two components are thoroughly mixed and blended, allow the material to digest for 30 minutes or longer before use. Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available through our website or by calling 1-800-441-9695.

#### Permissible temperatures during application:

Material:	50 to 90°F	10 to 32°C
Ambient:	50 to 100°F	10 to 38°C
Substrate:	50 to 100°F	10 to 38°C

PPGAF believes the technical data presented in this bulletin is currently accurate; however, no guarantee of accuracy, comprehensiveness, or performance is given or implied. Improvements in coatings technology may cause future technical data to vary from what is in this bulletin. For complete, up-to-date information visit our web site or call 1-800-441-9695

**Packaging:** 1-Gallon (3.78L) 5-Gallon (18.9L)

Quart (946 mL)

Not all products are available in all sizes.



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**Bulletin: 97-640**

Additional copies of this bulletin can be obtained from our web site or by calling 1-800-428-7806.

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