

Selection & Specification Data

Generic Type	Epoxy Polyamide
Description	Solvent-free patching compound used for repairing pits, cracks and voids in steel, concrete, wood and other surfaces. Has the unique ability to be mixed, applied and cured underwater.
Features	<ul style="list-style-type: none"> ▪ Designed for underwater and other wet applications ▪ Can be applied up to 2" in thickness ▪ Self-priming on most surfaces and over most generic types of coatings ▪ Rapid cure characteristics ▪ VOC compliant to current AIM regulations
Color	Olive Green
Finish	Flat
Primers	Self-priming
Topcoats	Epoxies, Polyurethanes if required
Dry Film Thickness	1/8"-2" (3.1-50 mm) for most applications 1/4" (6.4 mm) is practical maximum thickness for vertical and overhead applications.
Solids Content	By Volume: 99% ± 1%
Theoretical Coverage Rate	1604 mil ft ² (24.5 m ² /l at 25 microns) Allow for loss in mixing and application. Field experience has displayed a realistic coverage rate of 8 ft ² /gallon (.2 m ² /l). This figure accounts for actual losses and the fact that the product is frequently applied at higher dry film thicknesses.
VOC Values	As supplied: 0.00 lbs/gal (0 g/l) These are nominal values.
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C)

Substrates & Surface Preparation

General	Remove all oil or grease from the surface with Carboline Surface Cleaner 3 in accordance with SSPC-SP1.
	Remove all dirt, loose paint, spalling concrete, rotted wood, marine growth and other contaminants by abrasive blasting or high pressure water blasting.
	Hand or power tool cleaning methods may be used but are of limited benefit and are time consuming.
	Abrasive blasting can be done underwater as the initial air blast will clear a path through the water for the abrasive/air mixture.
	When working at the splash zone or in salt water, coat cleaned metal surfaces as soon as possible to minimize new corrosion.

KOP-COAT® A-788

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve desired results.

General Guidelines:

General Apply by hand, trowel or broad knife. Spread material smoothly onto the surface in a 1/8" to 1/4" (3.1 to 6.4 mm) thick layer using enough pressure to displace water and air bubbles. Smooth out the area by hand. When starting another mix, start spreading at and away from the previous applied film. This will help prevent trapped air bubbles or leaving an area uncoated.

If applying to dry surfaces in dry air, periodically rewet hands or tools with water to keep the product from sticking.

When used as a patch or grout, force the material into the hole or crack and smooth by hand to the thickness needed. For larger patches greater than 1/2" (12.7 mm), use a steel or fiberglass plate for added support. Apply A-788 to the substrate, then embed the support plate (cut larger than the hole) and apply A-788 overall.

When applied underwater or when wetted with water during application, the surface of A-788 will form an emulsified lighter green "scum" layer. This layer is normal and facilitates application. The film under the "scum" layer remains undisturbed and will cure properly. The "scum" layer will cure and become part of the finish when A-788 is cured above water; however, this layer will remain soft and uncured when the A-788 is kept underwater during curing.

Mixing & Thinning

Mixing Mix one Part A to one Part B by volume. Mix by hand "scooping" a quantity of the "A" component from the can and then "scoop" the same quantity of the "B" component from its can. Mix and knead the two components by hand until the yellow and black colors have combined to make a uniform olive green color. Apply this mixture immediately after mixing; no sweat-in time is required. To assist in mixing, keep the gloved hands and the materials wet with water during the mixing process.

Thinning Not recommended. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Pot Life Working times at 70°F (21°C), below and above water:
Golfball size mix: 40 minutes
Baseball to Softball size mix: 30 minutes
1/2 gallon mix: 15 minutes
Working times are reduced by one-half at temperatures above 80°F (27°C).

Do not mix more material than can be applied in the working times listed. The material may still appear to be workable after the time limit is exceeded, but it will not properly adhere to the substrate after application and curing.

Cleanup & Safety

Cleanup Use Thinner #2 or Acetone.

Safety Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas. Some people may be sensitive to the epoxy resins used in this material, so tight fitting rubber gloves should always be worn during the mixing process. When used for marine applications in splash zone areas, use all necessary precautions to protect the applicators. Wear wet or dry suits if necessary to help preserve body heat and use approved life jackets and safety lines. Avoid working in rough water.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	65°-75°F (18°-24°C)	60°-80°F (16°-27°C)	60°-80°F (16°-27°C)	30-70%
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	100°F (38°C)	110°F (43°C)	100°F (38°C)	100%

Special application techniques may be required above or below normal application conditions. Do not apply or cure in acidic or alkaline water (pH less than 6 or greater than 9) or in solutions containing solvents.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Touch	Dry to Handle or Topcoat	Maximum Recoat Time
50°F (10°C)	8 Hours	36 Hours	72 Hours
60°F (16°C)	4 Hours	16 Hours	48 Hours
75°F (24°C)	2 Hours	8 Hours	24 Hours
90°F (32°C)	1 Hour	6 Hours	12 Hours

These times are based on a 1/8" (3.1 mm) dry film thickness. Higher film thicknesses or cooler temperatures will require longer cure times. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding to produce a rough surface and to remove the "scum" layer before the application of any further coatings.

Packaging, Handling & Storage

Shipping Weight (Approximate)	1/2 Gallon Kit 10 lbs (4 kg)	2 Gallon Kit 30 lbs (13 kg)
Flash Point (Setflash)	Part A: >200°F (93°C) Part B: >200°F (93°C)	
Storage Temperature & Humidity	40° -110°F (4°-43°C) Store indoors. 0-100% Relative Humidity	
Shelf Life	Part A & B: Min. 24 months at 75°F (24°C)	

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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