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PRODUCT DATA SHEET

SP-3889

DESCRIPTION: **SP-3889** is a 100% solids modified epoxy with similar performance characteristics to those of **SP-3888**[®], but with the added advantage of application using Standard Airless Spray equipment. The cathodic disbonding resistance of **SP-3889** is excellent at temperatures up to 95°C (203°F).

ADVANTAGES:

- 100% Solids - No VOCs.
- Used on projects where the use of plural component spray equipment is not possible.
- Isocyanate free.
- Excellent adhesion to grit blasted steel surfaces, Fusion Bond Epoxy, liquid epoxy, and urethane coatings.

USES:

- Coating of pipe, valves and fittings.
- Girth weld coatings.

APPLICATION:

- Spray Grade: Graco 45:1 or 56: 1 or greater Airless Spray equipment or equivalent.

CLEANING MATERIALS:

- SP-100 Equipment Wash
- SP-110 Tool Cleaner
- SP-120 Internal Storage Lubricant

SURFACE PREPARATION:

(Steel Substrate)

- Cleanliness: Near White
- Standards: NACE 2, Sa 2½ (Swedish Scale, ISO 8501-1)
SSPC SP-10 (Steel Structures Painting Council)
- Profile: 2.5 mils minimum to 5.0 mils maximum
(62.5 microns to 127 microns)



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RECOMMENDED

FILM THICKNESS:

- **Wet:** 20 mils minimum to 50 mils maximum (0.50 mm to 1.25 mm)
- **Dry:** 20 mils minimum to 50 mils maximum (0.50 mm to 1.25 mm)

RE-COAT INTERVAL:

@ 25°C (77°F) - Maximum: 2 Hours
@ 100°C (212°F) - Maximum: 5 Minutes

- Sweep blasting of the surface is required if the maximum re-coat interval is exceeded. Small areas ≤ 316 sq. cm. (≤ 49 sq. in.) may be sanded using a medium grit (80-100) carborundum cloth. All dust from the sanding or blast roughening must be removed from the surface prior to the application of the coating.

MIXING RATIO:

Spray Grade: By Volume: 3 Parts Base to 1 Part Hardener

HANDLING PROPERTIES:

Pot Life [100 gm mass @ 25°C (77°F)]..... 35 ± 5 minutes
Dry Time (ASTM D-1640) [30 mil coating thickness @ 25°C (77°F)]
Tack Free Time..... 3.0 hours
Dry Hard Time 8.0 hours

Ambient Temperature °C (°F) -25° to 100° (-13° to 212°)

Substrate Temperature..... The acceptable substrate (metal surface) temperature range for the application of SP-3889 is 10°C (50°F) to 100°C (212°F). Preheating of the substrate is required if the surface to be coated is below 10°C (50°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature before proceeding with the coating operation.

Storage / Shelf Life Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 40°C (104°F). Keep the lids sealed. The Shelf Life is a maximum of 24 months in unopened containers.



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SP-3889**LIQUID PROPERTIES:****BASE****HARDENER**

Appearance.....	Grey Viscous Liquid.	Light Amber Liquid.
Solids Content (%)	100	100
Specific Gravity (ASTM D-792).....	1.50 ± 0.03	1.06 ± 0.02
Specific Gravity (ASTM D-792).....	Base & Hardener Mixed:	1.39 ± 0.03
Coverage (Theoretical).....	Base & Hardener Mixed:	1604 (ft ² /U.S. Gallon/mil) 39.0 (m ² /Litre/25 microns)

PHYSICAL / MECHANICAL / ELECTRICAL PROPERTIES:

Adhesion to Steel:

Dry Adhesion (Pull-off Strength) (PSI) (ASTM D-4541-95-A4) [25°C (77°F)] (Self-Alignment Adhesion Tester, Type IV)	3000
Wet Adhesion (Hot Water Soak) (CSA-Z245.20-02, Clause 12.14, 28 Days) [75°C (167°F)].....	Rating #1
Cathodic Disbonding Test (mm) [CSA-Z245.20-02 Clause 12.8 modified to 28 Days @ 65°C (150°F)]	9-10
Cathodic Disbonding Test (mm) [CSA-Z245.20-02 Clause 12.8 modified to 28 Days @ 95°C (203°F)]	10-11
Hardness (Shore D) (ASTM D-2240-91) [25°C (77°F)]	85
Impact Strength (in.-lbs. / J) (ASTM D-256) [25°C (77°F)]	26.5 / 3.0
Flexibility (CSA-Z245.20-02 Clause 12.11) [25°C (77°F)]	1.50° ppd
Heat Resistance Dry (°C / °F)	195 / 383
Impact Strength (in.-lbs. / J) (ASTM D-256) [25°C (77°F)]	26.5 / 3.0

SAFETY: Read the Material Safety Data Sheets before use.**NOTE:** All epoxy coatings will change colour, lose gloss and chalk on exterior exposure.
However, the protective properties of the material will not be affected.**EFFECTIVE DATE:** April 12, 2006