

STATE OF CALIFORNIA

Department of Transportation

Dark Green Finish Paint Waterborne Acrylic Latex/ FEVE Blend Vehicle *(Specification PWB 180A)

SCOPE

This specification covers a pre-mixed waterborne paint formulated for use as a finish coat on properly prepared metal surfaces. This coating is intended for spray application, limited application can be made by brushing and rolling. This paint is an industrial maintenance coating and is not for residential use.

REQUIREMENTS

General:

This specification is intended to specify paint that will meet service requirements for bridge construction and maintenance. Application and use of this coating shall be in conformance with the provisions in Section 59-2, "Painting Structural Steel", or Section 59-3, "Painting Galvanized Surfaces", whichever is applicable, and Section 91, "Paint," of the *State of California Department of Transportation Standard Specifications*. All properties listed shall be maintained for a minimum of one year after manufacture. If the vendor is making this paint for the first time, the Transportation Laboratory in Sacramento must be consulted.

Materials:

The raw materials for use in the paint formula shall conform to the specifications designated or paint material code number herein after specified.

QUALITY ASSURANCE

All paint intended for use by the California Department of Transportation (Department) must be sampled, tested and approved by the Transportation Laboratory **before** shipment.

The manufacturer shall take a representative one-quart sample of each batch of paint and ship the samples to the Transportation Laboratory for approval, unless other arrangements have been made. Raw materials and copies of batch records used in the manufacture of the paint shall be submitted if requested.

Transportation Laboratory, Chemical Testing Branch, 5900 Folsom Blvd., Sacramento, CA 95819, attn.: Lisa Dobeck, Fax (916) 227-7168.

A batch shall be that amount of paint that was manufactured and packaged in a single operation. The paint container shall be labeled with, but not limited to, the State Specification number, date of manufacture and batch number. The Department also

reserves the right to retest any batch after delivery. Results from such retesting shall prevail over all other tests and will be the basis of rejection. Material not meeting the specification shall be removed and replaced by the supplier at their expense, including all costs for handling, retesting and shipping.

All tests shall be conducted in accordance with the appropriate ASTM test methods referenced under the "Characteristics of Mixed Paint" section of this document and methods used by the Transportation Laboratory.

Patents:

The contractor shall assume all costs arising from the use of patented materials, equipment, devices, or processes used on or incorporated in the work, and agrees to indemnify and save harmless the State of California, and its duly authorized representatives from all suits at law or action of every nature for, or on account of, the use of any patented materials, equipment, devices, or processes.

Predispersed colorants:

Chroma-Chem® 897 colorants were used in the development of this formulation. Minor adjustments of the amounts used may be necessary to match the colors specified due to manufacturing variations. Predispersed colorants from other manufacturers may not be compatible with this formulation. Colorants selected shall be low VOC, light fast and chemically resistant. They shall not contain lead, chrome or zinc.

Composition:

Paint shall be mixed in the following sequence and proportions. Use sufficient time and agitation necessary to get a good grind viscosity with uniform dispersion. Minor adjustments may be necessary to obtain an acceptable batch of paint due to manufacturing variations. Do not exceed 100°F during this operation. The binder blend ratio shall be 40% Lumiflon FE-4300 and 60% Aquamac 440 by total weight of binder used.

<u>Grind Ingredients:</u>		<u>Weight percent</u>	<u>Lbs./ 100gal</u>
Water	(1)	1.84	17.0
Dispersant	(2)	0.03	0.28
Surfactant	(3)	0.06	0.57
Ammonium hydroxide (28%)	(4)	0.22	2.0
Defoamer	(5)	0.33	3.0
Minex-4	(6)	2.17	20.0
Flash rust inhibitor	(7)	0.22	2.0
Preservative	(8)	0.11	1.0

Thickener-1	(9)	0.22	2.0
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<u>Let Down Ingredients:</u>		<u>Weight percent</u>	<u>Lbs./ 100gal</u>
Styrenated acrylic latex	(10)	44.87	414.0
Ammonium hydroxide (28%)	(11)	0.38	3.5
(Coalescent)	(12)	3.75	34.6
Fluoroethylene vinyl ether emulsion	(13)	29.91	276.0
Thickener-2	(14)	0.38	3.5
Thickener-3(**)	(15)	0.71	6.5
Organic yellow	(16)	5.78	53.34
Phthalogreen	(17)	5.04	46.48
Yellow iron oxide	(18)	2.59	23.90
Titanium dioxide	(19)	1.41	13.02

**Caution: Acrysol® RM-995 is a very effective rheology modifier. Initially add ½ the amount and allow sufficient time to reach equilibrium. Add small amounts until the desired viscosity is obtained. The viscosity will continue to increase for 24-48 hrs after addition. It is highly recommended to make small test batches of this coating before attempting full scale production.

Characteristics of Paint:

VOC, grams per liter, ASTM Designation: D 6886 or SCAQMD Method 313	100 Maximum
Flash Point, °F, ASTM Designation: D 3828	>215
Density, grams per milliliter, ASTM Designation: D 1475	1.09 to 1.13
Nonvolatile content, percent, ASTM Designation: D 2369	46.5 - 48.4
Pigment content, percent, ASTM Designation: D 3723	5.4 - 5.8
Volume nonvolatile content, percent, ASTM Designation: D 2697	41.5 - 44.5
Consistency, ASTM Designation: D 562, g (Equivalent KU)	170 - 191 76 - 82

High-shear viscosity, ASTM Designation: D 4278 0 to 5-P cone, shear rate 12 000 s ⁻¹	0.3 - 0.4 P
pH	8.0 - 9.0
Fineness of grind, Hegman, ASTM Designation: D 1210	6 Minimum
Contrast Ratio, ASTM Designation: D 2805, 150 µm clearance applicator	1.00 Minimum
Specular Gloss, ASTM Designation: D 523 @ 20° @ 60°	28-35 64-72
Color to match Federal Standard 595B color number 14090 unless otherwise specified.	
Color Tolerance, ASTM Designation: D 2244, CIE 1976 L*a*b*, 10° Standard observer, Illuminant D 65	2 ΔE Maximum
Color Tolerance after 4000 hours of UV-exposure, maximum ΔE ASTM Designation: D 4587, Cycle-2, UVA-340 bulbs	3.5 ΔE Maximum
Film hardness by pencil test, ASTM Designation: D 3363	2B Minimum
Anti-Sag Index, ASTM Designation : D4400, Anti-Sag Meter Type ASM-4, 4-24 Mils.	10.8 Minimum
Fluorine content, ASTM Designation: E1621, Recommended Fluorine X-ray line Kα, Angle 2θ° 42.9, Crystal PX1, using 15 mil drawdown.	10.6 % Minimum in dry film
Dry time at 25°C, 4 mil wet film, ASTM Designation: D1640	
Set to touch, hours	½ maximum
Dry through, hours	1 maximum

Material Ingredients of Paint:

- 1) Water
- 2) Tamol® 165A (Dow Chemical Co.)
- 3) Surfynol® CT-111 (Air Products)
- 4) Ammonium Hydroxide (28%)
- 5) FoamStar® ST 2438 (BASF)
- 6) Minex® 4 (The Cary Company)
- 7) Sodium Nitrite (15% solution)

- 8) PROXEL® BD20 (Dow Chemical Co.)
- 9) Acrysol® RN-2020 NPR (Dow Chemical Co.)
- 10) Aquamac® 440 (Polynt Composites USA Inc.)
- 11) Ammonium Hydroxide (28%)
- 12) (Dowanol® DPnB) Di (propylene glycol) butyl ether (Dow Chemical Co.)
- 13) Lumiflon™ FE-4300 (AGC Chemicals Americas, Inc.)
- 14) Acrysol® RM-12W (Dow Chemical Co.)
- 15) Acrysol® RM-995 (Dow Chemical Co.)
- 16) Organic Yellow 897-2601 (Chromaflo Technologies)
- 17) Phthalogreen 897-5501 (Chromaflo Technologies)
- 18) Yellow Iron Oxide 897-1801 (Chromaflo Technologies)
- 19) Titanium White 897-0001 (Chromaflo Technologies)

Packaging:

The containers shall be new, round and of no more than twenty-liter (20 L) capacity. Pails larger than fifteen liters shall be standard, full open head. Three liter and larger containers shall have ears and bails. All containers shall be suitably lined or constructed so as to prevent any reaction between the container and contents and also must comply with U.S. Department of Transportation or I.C.C. Regulations as applicable. Labels must be marked with the volatile organic content (VOC), mixing instructions, and the following provision in addition to any other labeling required.

Application:

The paint shall be applied to a total dry film thickness of 1.5 mil minimum and 3.0 mil maximum. This coating is intended for spray application, however limited application can be made by brush. Paint should not be applied when the ambient or surface temperature is above 100 °F or below 50 °F, when the relative humidity exceeds 75 percent, or when the surface temperature is less than 5 °F above the dew point.

Clean-up:

Use tap water for clean up. 10% ammonia, acetone or other suitable solvent may be used to remove dried paint from spray guns and other equipment.