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Canadian General
Standards Board

Office des normes
générales du Canada

Series 1
Série des 1

WITHDRAWAL

October 2011

Selected standards in the series Paints, pigments and related products

These CGSB standards and National Standards of Canada are hereby withdrawn due to limited use and support for their revision.

The Standards Council of Canada requires that accredited Standards Development Organizations, such as the CGSB, regularly review a consensus Standard to determine whether to re-approve, revise or withdraw. The review cycle is normally five years from the publication date of the latest edition of the Standard.

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RETRAIT

Octobre 2011

Sélection de normes de la série Peintures, pigments et produits connexes

Ces normes de l'ONGC et ces Normes nationales du Canada sont retirées par le présent avis en raison de leur utilisation limitée et du manque de support pour leur révision.

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CAN/CGSB-1.5-M91

Low Flash Petroleum Spirits Thinner
(ICS 87.040)

CAN/CGSB-1.28-98

Exterior Alkyd House Paint (ICS 87.040)

CAN/CGSB-1.36-97

General Purpose Interior Alkyd Varnish
(ICS 87.040)

CAN/CGSB-1.38-2000

Interior Enamel Undercoater (ICS 87.040)

CAN/CGSB-1.40-97

Anticorrosive Structural Steel Alkyd Primer
(ICS 87.040)

CAN/CGSB-1.57-2003

Interior Alkyd Semigloss Enamel
(ICS 87.040)

CAN/CGSB-1.59-97

Alkyd Exterior Gloss Enamel (ICS 87.040)

CAN/CGSB-1.60-97

Interior Alkyd Gloss Enamel (ICS 87.040)

cette information. Ces normes doivent être consultées à des fins archivistiques seulement puisque leur contenu a été révoqué à la date du présent avis de retrait.

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CAN/CGSB-1.5-M91

Diluant, essence minérale à faible point d'éclair (ICS 87.040)

CAN/CGSB-1.28-98

Peinture aux résines alkydes d'extérieur pour bâtiments (ICS 87.040)

CAN/CGSB-1.36-97

Vernis d'intérieur aux résines alkydes d'usage général (ICS 87.040)

CAN/CGSB-1.38-2000

Peinture-émail d'intérieur, pour couche de fond (ICS 87.040)

CAN/CGSB-1.40-97

Peinture pour couche primaire anticorrosion, aux résines alkydes, pour acier de construction (ICS 87.040)

CAN/CGSB-1.57-2003

Peinture-émail, d'intérieur, semi-brillante, aux résines alkydes (ICS 87.040)

CAN/CGSB-1.59-97

Peinture-émail, d'extérieur, brillante, aux résines alkydes (ICS 87.040)

CAN/CGSB-1.60-97

Peinture-émail brillante d'intérieur aux résines alkydes (ICS 87.040)

CAN/CGSB-1.61-2004

Exterior and Interior Marine Alkyd Enamel
(ICS 87.040)

CAN/CGSB-1.69-98

Aluminum Paint (ICS 87.040)

1-GP-71 (Oct 1983)

Methods of Testing Paints and Pigments
(ICS 87.040)

1-GP-71

Methods of Testing Paints and Pigments

No. 5-96

Drying Times of Paints and Related
Coatings (ICS 87.040)

No. 38-96

Blushing Resistance of Lacquer
Finishes (ICS 87.040)

No. 73-96

Beilstein Test for Chlorinated Solvents
(ICS 87.040)

CAN/CGSB-1.73-97

Exterior and Interior Enamel for Floors
(ICS 87.040)

CAN/CGSB-1.74-2001

Alkyd Traffic Paint (ICS 87.040)

CAN/CGSB-1.76-2000

Interior and Exterior Heat-Resistant Enamel
(ICS 87.040)

CAN/CGSB-1.81-M90

Air Drying and Baking Alkyd Primer for
Vehicles and Equipment (ICS 87.040)

CAN/CGSB-1.84-M91

Alkyd Primer for Hardwood (ICS 87.040)

CAN/CGSB-1.61-2004

Peinture-émail aux résines alkydes,
d'extérieur et d'intérieur, marine
(ICS 87.040)

CAN/CGSB-1.69-98

Peinture à l'aluminium (ICS 87.040)

1-GP-71 (oct. 1983)

Méthodes d'essai des peintures et pigments
(ICS 87.040)

1-GP-71

Méthodes d'essai des peintures et pigments

N° 5-96

Durée de séchage des peintures et
revêtements apparentés (ICS 87.040)

N° 38-96

Résistance à l'opalescence des
produits-laque de finition (ICS 87.040)

N° 73-96

Détermination de la présence de
solvants chlorés par l'essai de Beilstein
(ICS 87.040)

CAN/CGSB-1.73-97

Peinture-émail d'extérieur et d'intérieur,
pour sols (ICS 87.040)

CAN/CGSB-1.74-2001

Peinture alkyde de démarcation routière
(ICS 87.040)

CAN/CGSB-1.76-2000

Peinture-émail résistant à la chaleur,
d'intérieur et d'extérieur (ICS 87.040)

CAN/CGSB-1.81-M90

Peinture pour couche primaire aux résines
alkydes, séchant à l'air ambiant et au four,
pour véhicules automobiles et équipement
(ICS 87.040)

CAN/CGSB-1.84-M91

Peinture d'impression aux résines alkydes,
pour bois dur (ICS 87.040)

CAN/CGSB-1.88-92

Gloss Alkyd Enamel, Air Drying and Baking
(ICS 87.040)

CAN/CGSB-1.100-99

Interior Flat Latex Paint (ICS 87.040)

CAN/CGSB-1.104-M91

Semigloss Alkyd Air Drying and Baking
Enamel (ICS 87.040)

CAN/CGSB-1.105-M91

Quick-Drying Primer (ICS 87.040)

CAN/CGSB-1.114-M91

Quick-Drying Flat Enamel (ICS 87.040)

CAN/CGSB-1.118-95

Interior Flat Alkyd Finish (ICS 87.040)

CAN/CGSB-1.119-2000

Interior Latex Primer-Sealer (ICS 87.040)

CAN/CGSB-1.122-99

Anticorrosive Vinyl Primer (ICS 87.040)

CAN/CGSB-1.132-M90

Zinc Chromate Primer, Low Moisture
Sensitivity (ICS 87.040)

CAN/CGSB-1.135-99

Flat Alkyd Enamel for Equipment
(ICS 87.040)

CAN/CGSB-1.138-97

Exterior Latex Flat Paint (ICS 87.040)

CAN/CGSB-1.143-98

Silicone Alkyd Heat-Resistant Aluminum
Enamel (ICS 87.040)

CAN/CGSB-1.88-92

Peinture-émail brillante aux résines alkydes,
séchant à l'air ambiant et au four
(ICS 87.040)

CAN/CGSB-1.100-99

Peinture-émulsion mate d'intérieur
(ICS 87.040)

CAN/CGSB-1.104-M91

Peinture-émail semi-brillante aux résines
alkydes séchant à l'air ambiant et au four
(ICS 87.040)

CAN/CGSB-1.105-M91

Peinture pour couche primaire à séchage
rapide (ICS 87.040)

CAN/CGSB-1.114-M91

Peinture-émail mate à séchage rapide
(ICS 87.040)

CAN/CGSB-1.118-95

Peinture de finition mate d'intérieur aux
résines alkydes (ICS 87.040)

CAN/CGSB-1.119-2000

Peinture-émulsion d'impression d'intérieur
(ICS 87.040)

CAN/CGSB-1.122-99

Peinture pour couche primaire, aux résines
vinyliques, anticorrosion (ICS 87.040)

CAN/CGSB-1.132-M90

Peinture pour couche primaire, au chromate
de zinc, à faible sensibilité à l'humidité
(ICS 87.040)

CAN/CGSB-1.135-99

Peinture-émail mate aux résines alkydes
pour équipement (ICS 87.040)

CAN/CGSB-1.138-97

Peinture-émulsion (latex) mate, d'extérieur
(ICS 87.040)

CAN/CGSB-1.143-98

Peinture-émail aux résines silicones-
alkydes résistante à la chaleur (ICS 87.040)

CAN/CGSB-1.145-97

Solvent-Based Pigmented Stain
(ICS 87.040)

CAN/CGSB-1.146-99

Cold Curing, Gloss Epoxy Coating
(ICS 87.040)

CAN/CGSB-1.150-M91

Clear Lacquer for Wood Furniture
(ICS 87.040)

CAN/CGSB-1.153-2000

High-Build, Gloss Epoxy Coating
(ICS 87.040)

CAN/CGSB-1.154-M89

Latex Type Paint for Concrete Floors
(ICS 87.040)

CAN/CGSB-1.158-M89

Cellulose Nitrate Primer, Modified Alkyd
Type (ICS 87.040)

CAN/CGSB-1.159-92

Acrylic Cellulose Nitrate Gloss Lacquer
(ICS 87.040)

CAN/CGSB-1.160-93

Low Gloss Acrylic Cellulose Nitrate
Lacquer (ICS 87.040)

CAN/CGSB-1.162-2004

Emulsion Coating for Stucco and Masonry
(ICS 87.040)

CAN/CGSB-1.165-2004

Cold-Curing Epoxy Primer (ICS 87.040)

CAN/CGSB-1.171-98

Inorganic Zinc Coating (ICS 87.040)

CAN/CGSB-1.175-97

Polyurethane Interior Coating (ICS 87.040)

CAN/CGSB-1.145-97

Teinture pigmentée à base de solvant
(ICS 87.040)

CAN/CGSB-1.146-99

Revêtement aux résines époxydiques,
durcissant à froid, brillant (ICS 87.040)

CAN/CGSB-1.150-M91

Vernis-laque pour meubles en bois
(ICS 87.040)

CAN/CGSB-1.153-2000

Revêtement par peinture aux résines
époxydiques, à pouvoir garnissant élevé,
brillant (ICS 87.040)

CAN/CGSB-1.154-M89

Peinture-émulsion (latex) pour sols en béton
(ICS 87.040)

CAN/CGSB-1.158-M89

Peinture-laque pour couche primaire, au
nitrate de cellulose et aux résines alkydes
modifiées (ICS 87.040)

CAN/CGSB-1.159-92

Produit-laque brillant à la résine acrylique et
au nitrate de cellulose (ICS 87.040)

CAN/CGSB-1.160-93

Peinture-laque aux résines acryliques et au
nitrate de cellulose, peu brillante
(ICS 87.040)

CAN/CGSB-1.162-2004

Revêtement de type émulsion pour stuc et
maçonnerie (ICS 87.040)

CAN/CGSB-1.165-2004

Peinture pour couche primaire aux résines
époxydiques, durcissant à froid
(ICS 87.040)

CAN/CGSB-1.171-98

Enduit au zinc minéral (ICS 87.040)

CAN/CGSB-1.175-97

Revêtement de polyuréthane d'intérieur
(ICS 87.040)

CAN/CGSB-1.176-2000

Interior Clear Moisture-Curing Polyurethane Coating (ICS 87.040)

CAN/CGSB-1.177-M91

Two-Component Polyurethane Coating, Resistant to Chalking and Yellowing (ICS 87.040)

1-GP-180Ma (Feb 1996)

Coating, Polyurethane, Two-Package, General Purpose (ICS 87.040)

CAN/CGSB-1.181-99

Ready-Mixed Organic Zinc-Rich Coating (ICS 87.040)

CAN/CGSB-1.183-99

Zinc-Rich Epoxy Coating (ICS 87.040)

CAN/CGSB-1.184-98

Coal Tar-Epoxy Coating (ICS 87.040)

CAN/CGSB-1.188-2004

Emulsion Filler for Masonry Block (ICS 87.040)

CAN/CGSB-1.189-2000

Exterior Alkyd Primer for Wood (ICS 87.040)

CAN/CGSB-1.190-M90

Sanding Type Primer Surfacer (ICS 87.040)

1-GP-191M (Apr 1980)

Enamel, Automotive Refinishing, Fast Drying, Gloss (ICS 87.040)

1-GP-192Ma (Feb 1985)

Deck Coating, Nonslip, Epoxy (ICS 87.040)

CAN/CGSB-1.176-2000

Revêtement de polyuréthane, d'intérieur, durci à l'humidité, non pigmenté (ICS 87.040)

CAN/CGSB-1.177-M91

Revêtement de polyuréthane, à deux constituants séparés, non jaunissant et non farinant (ICS 87.040)

1-GP-180Ma (févr. 1996)

Revêtement de polyuréthane, à deux constituants séparés, pour utilisation générale (ICS 87.040)

CAN/CGSB-1.181-99

Enduit riche en zinc, organique et préparé (ICS 87.040)

CAN/CGSB-1.183-99

Enduit aux résines époxydiques, riche en zinc (ICS 87.040)

CAN/CGSB-1.184-98

Revêtement à base de goudron de houille-résines époxydiques (ICS 87.040)

CAN/CGSB-1.188-2004

Apprêt-émulsion pour blocs de maçonnerie (ICS 87.040)

CAN/CGSB-1.189-2000

Peinture d'impression, d'extérieur, aux résines alkydes, pour le bois (ICS 87.040)

CAN/CGSB-1.190-M90

Peinture pour couche primaire surfaçante de type ponçable (ICS 87.040)

1-GP-191M (avr. 1980)

Peinture-émail brillante, à séchage rapide, pour le repeinture des carrosseries de véhicules automobiles (ICS 87.040)

1-GP-192Ma (févr. 1985)

Revêtement de pont, antidérapant, aux résines époxydiques (ICS 87.040)

CAN/CGSB-1.193-99

High-Build Epoxy Marine Coating
(ICS 87.040)

CAN/CGSB-1.195-99

Interior Latex Semigloss Paint (ICS 87.040)

CAN/CGSB-1.198-2001

Cementitious Primer for Galvanized
Surfaces (ICS 87.040)

1-GP-200Ma (Jan 1985)

Deck Coating, Nonslip, Polyurethane
(ICS 87.040)

CAN/CGSB-1.202-2003

Interior Alkyd Low Gloss Enamel
(ICS 87.040)

CAN/CGSB-1.203-2003

Exterior Latex Wood Primer (ICS 87.040)

CAN/CGSB-1.204-98

Exterior Latex Pigmented Stain
(ICS 87.040)

CAN/CGSB-1.205-2003

Sealer for Application to Asbestos-Fibre
Releasing Materials (ICS 87.040)

CAN/CGSB-1.207-98

Low-Temperature Curing Epoxy Coating
(ICS 87.040)

CAN/CGSB-1.208-99

Marine Interior Water-Borne Gloss Enamel
(ICS 87.040)

CAN/CGSB-1.209-2003

Interior Latex Low Gloss Paint (ICS 87.040)

CAN/CGSB-1.210-2003

Quick-Drying Alkyd Primer for Structural
Steel (ICS 87.040)

CAN/CGSB-1.193-99

Revêtement aux résines époxydiques, à
pouvoir garnissant élevé, marin
(ICS 87.040)

CAN/CGSB-1.195-99

Peinture-émulsion semi-brillante d'intérieur
(ICS 87.040)

CAN/CGSB-1.198-2001

Peinture primaire additionnée de ciment,
pour surfaces galvanisées (ICS 87.040)

1-GP-200Ma (janv. 1985)

Revêtement de pont, antidérapant, aux
résines polyuréthanes (ICS 87.040)

CAN/CGSB-1.202-2003

Peinture-émail d'intérieur, aux résines
alkydes, peu brillante (ICS 87.040)

CAN/CGSB-1.203-2003

Peinture-émulsion (latex) d'impression
extérieure, pour bois (ICS 87.040)

CAN/CGSB-1.204-98

Teinture-émulsion pigmentée pour extérieur
(ICS 87.040)

CAN/CGSB-1.205-2003

Peinture d'obturation pour matériaux
renfermant des fibres d'amiante
(ICS 87.040)

CAN/CGSB-1.207-98

Revêtement aux résines époxydiques
durcissant à basse température
(ICS 87.040)

CAN/CGSB-1.208-99

Peinture-émail brillante en suspension
aqueuse, marine, d'intérieur (ICS 87.040)

CAN/CGSB-1.209-2003

Peinture-émulsion d'intérieur peu brillante
(ICS 87.040)

CAN/CGSB-1.210-2003

Peinture primaire aux résines alkydes à
séchage rapide pour acier de charpente
(ICS 87.040)

CAN/CGSB-1.211-95

Coating Systems for Marine Floating Navigational Aids (Buoys) (ICS 87.040)

CAN/CGSB-1.212-2004

Heavy-Metal-Free Marine Primer for Steel and Light-Alloy Surfaces (ICS 87.040)

CAN/CGSB-1.213-2004

Etch Primer (Pretreatment Coating or Tie Coat) for Steel and Aluminum (ICS 87.040)

CAN/CGSB-1.214-2004

Heavy-Metal-Free, Water-Borne, Marine Primer for Steel and Light-Alloy Surfaces (ICS 87.040)

CAN/CGSB-1.215-96

Two-Package Epoxy Blockfiller (ICS 87.040)

CAN/CGSB-1.216-97

Exterior Water-Borne Gloss Enamel (ICS 87.040)

CAN/CGSB-1.219-2001

Lead and Chromate-Free Waterborne Traffic Paint (ICS 87.040)

CAN/CGSB-1.220-2001

Lead and Chromate-Free Alkyd Traffic Paint (ICS 87.040)

CAN/CGSB-1.223-2004

Heavy-Metal-Free, Water-Borne Wash Primer-Tie Coat (ICS 87.040)

CAN/CGSB-1.300-2000

Applied Coating System of Semigloss Baked Finish for Metal Office Furniture (ICS 87.040)

CAN/CGSB-1.500-75

Methods for Test for Toxic Trace Elements in Protective Coatings (ICS 87.040)

CAN/CGSB-1.211-95

Systèmes de revêtement pour aides à la navigation flottantes (bouées) (ICS 87.040)

CAN/CGSB-1.212-2004

Peinture primaire sans métal lourd, marine, pour surfaces en acier et en alliage léger (ICS 87.040)

CAN/CGSB-1.213-2004

Peinture primaire réactive (enduit de traitement préliminaire ou couche de liaison) pour l'acier et l'aluminium (ICS 87.040)

CAN/CGSB-1.214-2004

Peinture primaire, sans métal lourd, en suspension aqueuse, marine, pour surfaces en acier et en alliage léger (ICS 87.040)

CAN/CGSB-1.215-96

Apprêt pour blocs aux résines époxydiques en deux constituants (ICS 87.040)

CAN/CGSB-1.216-97

Peinture-émail brillante d'extérieur en suspension aqueuse (ICS 87.040)

CAN/CGSB-1.219-2001

Peinture à l'eau de démarcation routière sans plomb ni chromate (ICS 87.040)

CAN/CGSB-1.220-2001

Peinture alkyde de démarcation routière sans plomb ni chromate (ICS 87.040)

CAN/CGSB-1.223-2004

Peinture primaire réactive – Couche de liaison, sans métal lourd, en suspension aqueuse (ICS 87.040)

CAN/CGSB-1.300-2000

Système de revêtement de finition semi-brillant, cuit au four, pour meubles métalliques de bureau (ICS 87.040)

CAN/CGSB-1.500-75

Méthodes d'essai des éléments toxiques à l'état de trace dans les revêtements protecteurs (ICS 87.040)

CAN/CGSB-1.501-M89

Method for Permeance of Coated
Wallboard (ICS 87.040)

CAN/CGSB-1.501-M89

Méthode de détermination de la perméance
des panneaux muraux revêtus (ICS 87.040)



Canadian
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CAN/CGSB-1.207-98

Supersedes CAN/CGSB-1.207-M91

Low-Temperature Curing Epoxy Coating

National Standard of Canada

Canada



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Although the intended primary application of this standard is stated in its Scope, it is important to note that it remains the responsibility of the users of the standard to judge its suitability for their particular purpose.

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The principal objectives of the Council are to foster and promote voluntary standardization as a means of advancing the national economy, benefiting the health, safety and welfare of the public, assisting and protecting the consumer, facilitating domestic and international trade, and furthering international co-operation in the field of standards.

A National Standard of Canada is a standard which has been approved by the Standards Council of Canada and one which reflects a reasonable agreement among the views of a number of capable individuals whose collective interests provide, to the greatest practicable extent, a balance of representation of producers, users, consumers and others with relevant interests, as may be appropriate to the subject in hand. It normally is a standard that is capable of making a significant and timely contribution to the national interest.

Approval of a standard as a National Standard of Canada indicates that a standard conforms to the criteria and procedures established by the Standards Council of Canada. Approval does not refer to the technical content of the standard; this remains the continuing responsibility of the accredited standards-development organization.

Those who have a need to apply standards are encouraged to use National Standards of Canada whenever practicable. These standards are subject to periodic review; therefore, users are cautioned to obtain the latest edition from the organization preparing the standard.

The responsibility for approving National Standards of Canada rests with the:

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LOW-TEMPERATURE CURING EPOXY COATING

Prepared by the
Canadian General Standards Board 

Approved by the
Standards Council of Canada 

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CANADIAN GENERAL STANDARDS BOARD

LOW-TEMPERATURE CURING EPOXY COATING

1. SCOPE

- 1.1 This standard applies to a high-build two-component epoxy coating¹ that is self-priming and low-temperature curing for the protection of clean steel or concrete surfaces exposed to severely corrosive conditions.
- 1.2 This coating is intended for use as a protective coating on interior and exterior substrates exposed to fresh or sea water immersion, tidal and splash zones, high humidity, condensation, soil burial, brine, alkalies, chemical fumes and chemical splashings by moderately strong sulfuric and muriatic acids. Although this coating is suitable for exterior use, chalking will occur upon weathering. Durability can be improved by applying other finishes suitable for the intended end use. This coating is most suited to application by airless spray. Small areas may be coated with a brush or roller.
- 1.3 This coating is mainly intended for use on steel surfaces and suitably treated galvanized steel and aluminum. However, it may also be used on wood, masonry and concrete surfaces. Primers are not required in normal usage, but if conditions dictate, the manufacturer's advice regarding a suitable primer shall be obtained.
- 1.4 The testing and evaluation of a product against this standard may require the use of materials and/or equipment that could be hazardous. This document does not purport to address all the safety aspects associated with its use. Anyone using this standard has the responsibility to consult the appropriate authorities and to establish appropriate health and safety practices in conjunction with any applicable regulatory requirements prior to its use.

2. REFERENCED PUBLICATIONS

- 2.1 The following publications are referenced in this standard:
- 2.1.1 Canadian General Standards Board (CGSB)
1-GP-71 — Methods of Testing Paints and Pigments.
- 2.1.2 Health Canada
Hazardous Products (Liquid Coating Materials) Regulations.
- 2.1.3 American Society for Testing and Materials (ASTM)
B 117 — Standard Practice for Operating Salt Spray (Fog) Apparatus
D 1212 — Standard Test Methods for Measurement of Wet Film Thickness of Organic Coatings
D 3960 — Standard Practice for Determining Volatile Organic Compound (VOC) Content of Paints and Related Coatings.
- 2.1.4 U.S. General Services Administration
Federal Standard
595B — Colors Used in Government Procurement.
- 2.2 A reference to a regulation is always to the latest issue. A dated reference is to the issue specified. An undated reference is to the latest issue unless otherwise specified by the authority applying this standard. The sources are given in the Notes section.

¹Unreacted volatile polyamine curing agents having a boiling point lower than 300°C are not permitted in coatings complying with this standard.

3. GENERAL REQUIREMENTS

- 3.1 The coating shall be a two-component material consisting of an epoxy resin or a modified epoxy resin and a curing agent(s). The distribution of the ingredients between the components is left to the discretion of the manufacturer, provided that the components when adequately mixed and allowed to stand according to the manufacturer's instructions, shall produce a coating complying with the requirements of this standard. The coating shall be free of coal tar pitch.
- 3.2 The coating may contain such ingredients as antisetling, thickening and flow agents.
- 3.3 When the components are thoroughly mixed, normally without thinning, and applied by spray within 2 h after mixing and at temperatures between -5 and 40°C , the coating shall produce a uniform film of $200 \pm 25 \mu\text{m}$ dry thickness on a vertical surface without sags or runs. The coating shall also be suitable for minor touch-ups of small areas.
- 3.4 **Storage Stability** — When stored in their respective original unopened containers for one year at temperatures between -5 and 40°C , the components, as received, shall be capable of being readily mixed to a uniform condition by stirring. The components should never be subjected to temperatures exceeding 50°C . When the components are mixed together as described in par. 3.1, the resulting coating shall meet the requirements for applicability and appearance in accordance with par. 4.15.
- 3.5 **Colour** — The coating shall conform to the gloss tint colours of U.S. Federal Standard 595B or to an adequately defined commercial colour as specified (par. 7.1).
- 3.6 **Toxic Elements** — The coating shall be manufactured in accordance with the requirements of the Hazardous Products (Liquid Coating Materials) Regulations for designated toxic elements.

4. DETAILED REQUIREMENTS

The coating shall comply with the the following detailed requirements when tested in accordance with the specified test method:

		Test Method			
		Min.	Max.	CGSB 1-GP-71	ASTM
4.1	Flash point, $^{\circ}\text{C}$	27	—	3.1	—
4.2	Drying time, surface dry, h	—	8	5	—
	Complete cure, room temperature, d	—	5	Method A (Par. 6.2.2)	—
	Complete cure, low temperature, d	—	8	(Par. 6.2.2)	—
4.3	VOC, mg/L	—	340	—	D 3960
4.4	Sag Resistance — When applied at a dry film thickness of $200 \pm 25 \mu\text{m}$ and tested in accordance with par. 6.2.3, the coating shall show no evidence of sagging or flowing back over the uncoated area.				
4.5	Pot Life — When held at room temperature and tested in accordance with par. 6.2.4, the mixed coating shall have a consistency suitable for application for at least 2 h. Then when thinned with not more than 10% of thinner, the coating shall remain lump-free and brushable.				
4.6	Flexibility — When subjected to the bending test using a 170 mm O.D. mandrel and when tested in accordance with par. 6.2.5, the cured film shall show no cracking or peeling.				
4.7	Adhesion — When a 6 mm square is cut in the film and when tested in accordance with par. 6.2.6, the cured film shall show good adhesion to steel and good intercoat adhesion.				
4.8	Impact Resistance (Direct)				
4.8.1	At Room Temperature ($23 \pm 2^{\circ}\text{C}$) — When subjected to an impact of 3.4 J at room temperature and tested in accordance with par. 6.2.7.1, the cured film shall show no loosening, cracking, flaking or chipping.				

- 4.8.2 **At 5°C** — When subjected to an impact of 2.7 J at 5°C and tested in accordance with par. 6.2.7.2, the cured film shall show no flaking, loosening, cracking or chipping.
- 4.9 **Flame Resistance** — When tested in accordance with par. 6.2.8 and subjected to the two foot tunnel test for 5 min ± 2 s, the cured film shall show no dripping, flashing or burning. Immediately after the flame is extinguished, the film shall show softening only in the flame impingement area and no liquefaction or after-glow. After the panel has cooled to room temperature, it shall not show any blistering. The char length shall not exceed 125 mm and the length of non-adhered coating shall not exceed 125 mm.
- 4.10 **Salt Spray Resistance** — When tested in accordance with par. 6.2.9 and exposed to 50 d in the salt spray cabinet, films on scored and unscored steel panels shall show no blistering, loss of adhesion, softening or other defects. The substrate panel shall show no corrosion, except for the scored panels, which shall not show more than 3 mm undercreep at the score lines. The 6 mm top and bottom of the panels shall be disregarded.
- 4.11 **Resistance to Salt Water and Diesel Fuel** — When tested in accordance with par. 6.2.10, the cured film shall not show blistering or loss of adhesion and not more than slight softening. In addition the substrate shall not show any corrosion when scored coated panels are immersed 7 d in aerated synthetic sea water followed by 7 d in diesel fuel and then a further 7 d in aerated synthetic sea water.
- 4.12 **Hot Water Immersion** — When tested in accordance with par. 6.2.11 and immersed 40 d in water at 60°C, the cured film shall not show blistering or loss of adhesion, and the substrate shall not show any corrosion.
- 4.13 **Acid Resistance** — When tested in accordance with par. 6.2.12, the cured film shall withstand the action of 5% sulfuric acid for 72 h without softening, blistering, wrinkling, loss of adhesion and shall not show more than a slight colour change. When examined under 10X magnification, dulling shall be disregarded.
- 4.14 **Alkali Resistance** — When tested in accordance with par. 6.2.13, the cured film shall withstand the action of 10% sodium hydroxide for 21 d without softening, blistering, wrinkling, loss of adhesion and shall not show more than a slight colour change. Dulling shall be disregarded.
- 4.15 **Applicability and Appearance**
- 4.15.1 **Brushing** — The coating shall spread and lap well and shall show no excessive pull under the brush. When dry, the film shall be free from sags and runs and shall show no excessive brush marks or other defects in accordance with par. 6.3.1.
- 4.15.2 **Spraying** — When applied with an airless spray gun, as recommended by the manufacturer, the coating shall spray well and shall show no tendency to sag, creep or run when tested in accordance with par. 6.3.2.
- 4.15.3 **Rolling** — When applied by roller, as recommended by the manufacturer's instructions, the coating shall have good working properties without sagging, pinholing, lack of uniformity or other defects when tested in accordance with par. 6.3.3.
- 4.15.4 **Recoatability** — When tested in accordance with par. 6.3.4, a second coat of the epoxy coating applied over the first by rolling, brushing or spraying, after the first coat has been allowed to dry for 18 h and also for 7 d, shall show no tendency to crater and shall not sag or run.
- 4.15.5 **Appearance of Dry Film** — When tested in accordance with par. 6.3, the coating shall dry to a smooth, uniform film, free from grit, craters, pinholes, blisters and other surface imperfections.

5. PREPARATION FOR DELIVERY

- 5.1 Unless otherwise specified (par. 7.1), preparation for delivery shall conform to normal commercial practice.
- 5.2 **Labelling** — In addition to complying with the labelling requirements of any relevant Acts or Regulations, each container shall be suitably labelled to show the following information:

Manufacturer's name and address

Name of material

Standard number: CAN/CGSB-1.207-98

Manufacturer's batch number

Manufacturer's code number (if applicable)

Date of manufacture

Detailed mixing and application instructions

A note to indicate that the mixed material shall be used within 2 h

Thinning instructions

Safety precautions at time of application

Warning label as follows — "This is a VOC compliant product."

Instructions for cleaning brushes, spray equipment and tools with the epoxy thinner conforming to CAN/CGSB-1.197, and if desired, the manufacturer's recommended thinner.

6. INSPECTION

6.1 **Sampling** — Sampling shall be carried out in accordance with CGSB standard 1-GP-71, Method 1.1.

6.2 Testing

6.2.1 **Panel Preparation** — Unless otherwise specified, apply in accordance with CGSB standard 1-GP-71, Method 98.1, two coats of the epoxy coating to steel panels prepared in accordance with CGSB standard 1-GP-71, Method 100.2, at a dry film thickness of 200 ± 25 μm per coat. Allow the first coat to dry for 24 h and the second for 7 d in accordance with CGSB standard 1-GP-71, Method 103.1, unless otherwise specified in the method. Before applying the second coat, examine the film of the first coat for slick (an oily or sticky surface). If slick is present, wash it off in accordance with par. 7.3.4. For salt spray and immersion tests, protect the backs and edges of the panels with several coats of bituminous paint or the coating under test.

6.2.2 **Complete Cure** — To determine the degree of cure, use CGSB standard 1-GP-71, No. 5, Method C, ignoring the cure time. Apply one coat of the epoxy coating at a dry film thickness of 200 ± 25 μm and cure for 5 d under standard conditions in accordance with CGSB standard 1-GP-71, Method 103.1. Apply the coating to another panel and cure for 3 d at -5°C . Immediately after 3 d, cure a further 5 d at 5°C . Apply the solvent and allow it to remain in contact with the films for 1 h at the specified temperatures after which there shall be no blistering, wrinkling or lifting, and not more than slight softening. At the end of a 6 h recovery period at the specified temperatures, re-examine the films for hardness.

6.2.3 **Sag Resistance** — Press a strip of 25 mm masking tape across the full width of a solvent-cleaned 75×150 mm cold-rolled steel panel, parallel to, and centred on, the shorter axis of the panel. Spray the mixed coating on the panel at a dry film thickness of not more than 200 ± 25 μm . As specified in ASTM D 1212, use a wet film thickness gauge to estimate the film thickness. Immediately after applying the coating, carefully remove the masking tape and keep the panel in a vertical position (with the bare strip horizontal) in a conditioned room in accordance with CGSB standard 1-GP-71, Method 103.1. At the end of 4 h examine the panel for sagging or running of the coating into the bare area.

6.2.4 **Pot Life of the Mixed Coating** — Fill a 500 mL paint can with the freshly mixed coating, seal tightly and store at $23 \pm 2^{\circ}\text{C}$ for 2 h. Then examine the coating for consistency, brushability and applicability. Using not more than 10% thinner, thin the coating in accordance with the manufacturer's instructions and assess for condition and brushability.

6.2.5 **Flexibility** — Mix the components in the proportions supplied, or as specified in the manufacturer's instructions; then at a dry film thickness of 200 ± 25 μm , apply one coat, by brush, to each of four $65 \times 450 \times 3$ mm steel panels conforming to CGSB standard 1-GP-71, Method 100.2. Allow the panels to cure for 7 d at room temperature in accordance with CGSB standard 1-GP-71, Method 103.1 and then force cure for 24 h at 55°C . In accordance with CGSB standard 1-GP-71, Method 103.1, bring the panels to room temperature for 1 h; then with the film side up and at an interval of 1 to 1.5 s, bend the panels 180° over a 170 mm O.D. pipe. Examine the bends for cracks, using 10X magnification, disregarding cracks at edges that extend no further than 6 mm.

6.2.6 *Adhesion*

- 6.2.6.1 *7 d Intercoat Adhesion* — On a panel prepared as specified in par. 6.2.1, test the coating for adhesion to the substrate and also for intercoat adhesion. Test for adhesion at the end of 7 d by cutting two straight lines 6 mm apart through to the steel with a sharp scalpel and by making another two cuts 6 mm apart and perpendicular to the first two. If adhesion is poor, the film between these cuts can be readily lifted with the scalpel. A microscope or magnifier is a necessary aid in this test.

6.2.7 *Impact Resistance*

- 6.2.7.1 *At Room Temperature ($23 \pm 2^\circ\text{C}$)* — Prepare and cure the panels as outlined in par. 6.2.1, except use phosphated steel panels in accordance with CGSB standard 1-GP-71, Method 100.3. In accordance with CGSB standard 1-GP-71, Method 147.1, determine the direct (coated side) impact resistance at room temperature as specified in CGSB standard 1-GP-71, Method 103.1 using a Gardner Variable Impact Tester with a ring inlay having a 16 mm opening. After the film has been subjected to the specified impact, examine it for any defects under 10X magnification.
- 6.2.7.2 *At 5°C* — Place the prepared panels, prepared as specified in par. 6.2.7.1, and the apparatus in the cold chamber maintained at $5 \pm 2^\circ\text{C}$. After the panels are conditioned for at least 4 h, carry out the direct (coated side) impact resistance in the cold chamber as specified in par. 6.2.7.1.

- 6.2.8 *Flame Resistance* — As specified in par. 6.2.1, prepare three panels $600 \times 95 \times 3$ mm. Seven days after the application of the second coat, the flame resistance test shall be carried out for a test time of $5 \text{ min} \pm 2 \text{ s}$ in accordance with CGSB standard 1-GP-71, Method 118.7.

- 6.2.9 *Salt Spray Resistance* — As specified in par. 6.2.1, prepare at least six panels and condition them for 7 d. On three of the panels, cut an X to bright metal from corner to corner with a sharp knife at an angle of 30° to the panel, with the plane of the blade perpendicular to the panel and lying in the direction of the cut. Immediately, expose all six panels for 50 d in a salt spray cabinet operated in accordance with ASTM B 117. Then examine the panels for compliance with the requirements specified in par. 4.10.

- 6.2.10 *Resistance to Salt Water and Diesel Fuel* — As specified in par. 6.2.1, prepare three panels and condition them for 7 d. Cut an X to bright metal from corner to corner by holding a sharp knife at an angle of 30° to the panel, with the plane of the blade perpendicular to the panel and lying in the direction of the cut. Immediately immerse the panels totally in aerated synthetic sea water prepared in accordance with CGSB standard 1-GP-71 Method 113.1 for 7 d. Immediately after this immersion, examine the panels for defects; then totally immerse them for 7 d in diesel fuel contained in a covered beaker at a temperature of $23 \pm 2^\circ\text{C}$. Immediately after this immersion, examine the panels for defects. Next totally immerse them for 7 d in aerated synthetic sea water as above; then examine them for compliance with the requirement specified in par. 4.11.

- 6.2.11 *Hot Water Immersion* — Totally immerse at least two panels, prepared, coated and dried as specified in par. 6.2.1, for 40 d in hot distilled water maintained at 60°C . Immediately after the immersion period, examine the panels for compliance with the requirements specified in par. 4.12.

- 6.2.12 *Acid Resistance* — Prepare a panel as described in par. 6.2.1; then test in accordance with CGSB standard 1-GP-71, Method 105.2 and examine for compliance with the requirements specified in par. 4.13.

- 6.2.13 *Alkali Resistance* — Prepare a panel as described in par. 6.2.1; then test in accordance with CGSB standard 1-GP-71, Method 106.1 and examine for compliance with the requirements specified in par. 4.14.

6.3 *Applicability and Appearance*

- 6.3.1 *Brushing Properties* — Vertically mount a cleaned, degreased 600×900 mm cold-rolled steel panel. Using a 75 mm brush, apply sufficient coating to yield a dry film thickness of $200 \pm 25 \mu\text{m}$. Apply the coating in horizontal strokes and finish off with vertical strokes. Note whether the coating spreads and laps well and whether it pulls under the brush. Allow the coating to dry and inspect the dry film.

- 6.3.2 *Airless Spraying Properties* — The spray gun used for this test shall be recommended by the manufacturer. As specified in par. 6.3.1, place another steel panel in a vertical position. Adjust the flow and gun distance from the

panel so that the spray pattern is smooth, level and uniform. Apply sufficient coating to yield a dry film thickness of $200 \pm 25 \mu\text{m}$. Examine the film when wet and after drying in a vertical position for 24 h.

6.3.3 **Rolling Properties** — As specified in par. 6.3.1, mount another steel panel and apply sufficient mixed coating by roller to the whole panel to yield a dry film thickness of approximately $200 \pm 25 \mu\text{m}$. Examine the film when wet and after drying in a vertical position for 24 h.²

6.3.4 **Recoatability Properties** — After drying the three panels prepared above for 18 h, apply a second coat in the same manner to one half of each panel. Inspect immediately after application and again after drying in a vertical position for 24 h. Dry the panels for a further 6 d and apply a second coat to the remaining half of the panels. Dry the panels for 24 h and examine for any irregularities.

7. NOTES

7.1 **Options** — The following options must be specified in the application of this standard:

a. Colour of coating (par. 3.5)

b. Preparation for delivery, if other than as specified (par. 5.1).

7.2 **Surface Preparation** — This coating performs best when the steel is blast-cleaned. Commercial blast cleaning in accordance with SSPC-SP6 (corresponding to pictorial standards Sa 2 of SSPC-VIS 1) or ASTM D 2200 is considered to be adequate in most of non-immersion exposures. Surfaces subject to severe chemical exposures should be blast-cleaned to the near white grade SSPC-SP 10 (corresponding to Sa 2-1/2 of SSPC-VIS 1), and surfaces exposed to total immersion should be blast-cleaned to white (clean) metal SSPC-SP 5 (corresponding to pictorial standards Sa 3 of SSPC-VIS 1). Other surfaces should be prepared in accordance with manufacturer's instructions.

7.3 Recommended Practices

7.3.1 Epoxy coating complying with this standard should be used as directed by the manufacturer. Regardless of stated pot life, freshly prepared coating should not be mixed with previously mixed coating. The coating should be applied only at temperatures between -5 and 40°C and at relative humidities below 80%.

7.3.2 At least two coats should be applied by airless spray to yield a minimum dry film thickness of at least $175 \mu\text{m}$ per coat. If brush or roller application is used, additional coats may be required to achieve the specified film thickness. A heavily loaded natural bristle brush should be used with this coating. A minimum of 18 h and a maximum of 7 d drying time between coats should be allowed under normal painting conditions. When recommended by the manufacturer, longer intervals between recoating may be permissible.

7.3.3 Roller or brush application of epoxy coatings is somewhat difficult and the final finish will be less uniform than when applied by spray. When application by spray is not practical, roller coating or brushing should be restricted to small areas. When applying this coating by brush or roller, care must be taken to avoid air entrapment.

7.3.4 With these coatings, a slick film may appear on the surface. This film should be washed off with a solution of 1 part methyl alcohol to 9 parts of water, but care should be taken to prevent staining of adjacent areas. Washing to remove the slick does not impair surface properties of the coating. Removal of the slick is especially important before recoating.

7.3.5 The coating should be applied under conditions of adequate ventilation and hygiene to protect the worker's skin and health. The manufacturer's instructions should be strictly adhered to.

7.4 **Cautionary Statement** — Good ventilation is essential. The coating contains volatile flammable solvents, and proper precautions should therefore be taken to prevent the possibility of sparks or open flame being present during application and while the material is drying.

7.5 **Equipment** — Since most synthetic materials are attacked by the solvents used in the epoxy coatings, natural bristle brushes conforming to CGSB specification 22.1 and mohair or cotton rollers are recommended.

²Rolling should be in accordance with the manufacturer's instructions.

- 7.5.1 Care should be taken to clean equipment thoroughly at regular intervals, and immediately after use, with a thinner supplied by the manufacturer or a thinner conforming to CAN/CGSB-1.197. Cleaning with solvents must be followed by a soap and water rinse to remove residual coating since the epoxy coating will cure even though immersed in solvents.
- 7.6 **Related Publications**
- 7.6.1 Canadian General Standards Board (CGSB)
CAN/CGSB-1.197 — Thinner for Epoxy Coatings
22.1 — Brushes, Paint, Varnish, Enamel and Lacquer, Flat, Hog Bristle.
- 7.6.2 American Society for Testing and Materials (ASTM)
D 2200 — Pictorial Surface Preparation Standards for Painting Steel Surfaces.
- 7.6.3 National Association of Corrosion Engineers (NACE)
NACE No. 1/SSPC-SP 5 — Joint Surface Preparation Standard: White Metal Blast Cleaning
NACE No. 2/SSPC SP10 — Joint Surface Preparation Standard: Near-White Metal Blast Cleaning
NACE No. 3/SSPC SP6 — Joint Surface Preparation Standard: Commercial Blast Cleaning.
- 7.6.4 Society for Protective Coatings (SSPC)
SSPC-Vis 1 — Visual Standard for Abrasive Blast Cleaned Steel
SSPC Guide to Vis 1 — Visual Standard for Abrasive Cleaned Steel.
- 7.7 **Sources of Referenced Publications**
- 7.7.1 The publications referred to in par. 2.1.1 and 7.6.1 may be obtained from the Canadian General Standards Board, Sales Centre, Ottawa, Canada K1A 1G6. Telephone (819) 956-0425 or 1-800-665-CGSB (Canada only). Fax (819) 956-5644.
- 7.7.2 The publication referred to in par. 2.1.2 may be obtained from Health Canada, Health Canada, Products Safety Bureau, Statistics Canada Main Building, Room 1000, Tunneys Pasture, Ottawa, Ontario K1A 0K9. Telephone (613) 957-9545.
- 7.7.3 The publications referred to in par. 2.1.3 and 2.1.4 may be obtained from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA , 19428-2959, U.S.A., telephone (610) 832-9585, fax (610) 832-9555 or from Global Info Centre Canada, 240 Catherine Street, Suite 305, Ottawa, Ontario K2P 2G8, telephone (613) 237-4250 or 1-800-854-7179, fax (613) 237-4251.
- 7.7.4 The publications referred to in par. 7.6.3 and 7.6.4 may be obtained from Global Info Centre, 240 Catherine Street, Suite 305, Ottawa, Ontario K2P 2G8. Telephone (613) 237-4250 or 1-800-854-7179, fax (613) 237-4251.
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