



Tufcote™ CE 181 High-Gloss DTM Epoxy

(Formerly CenturyExtreme™ 181)



GENERAL

DESCRIPTION

The Tufcote™ CE 181 DTM Epoxy is a high-gloss finish, low VOC (Volatile Organic Compound), direct-to-metal epoxy coating designed to protect steel surfaces from atmospheric exposure. This product provides excellent corrosion and chemical protection as well as improved UV stability compared to traditional DTM epoxy coatings.

Product Highlights:

- No additional Solvent/Thinner required for airless spray application.
- No induction or “Sweat-in” required
- Low VOC

SUGGESTED USES

The Tufcote™ CE 181 DTM Epoxy is intended for use over properly prepared steel substrates and is designed to provide a durable, high-gloss, chemical resistant exterior finish.

- Railcar Manufacturing and Refurbishment
- Heavy Equipment
- Trailer Chassis and Frame
- Marine/OEM/Industrial Maintenance

NOT RECOMMENDED FOR

- Immersion service

PERFORMANCE PROPERTIES

Chemical	Excellent
Humidity	Excellent
Weather	Excellent
Impact	Excellent

COLORS AVAILABLE

Black
Gray
White
Custom Colors Available



MIXING

MIXING RATIO

1:1 BY VOLUME (BASE/ACTIVATOR)
1 PART BASE / 1 PART ACTIVATOR

COMPONENTS

Black, 181-B300-103
Hopper Gray, 181-D300-102
White, 181-W300-105
Ferric Brown, 181-J300-100

Activator, 181-V-110



REDUCTION

No reduction necessary for airless spray.

INDUCTION

No induction or “sweat-in” required.

Using a power-mixer, agitate each individual component thoroughly to ensure that no undispersed pigment remains on the bottom of the containers. Then combine 1 part by volume of Part A (Activator) with 1 part by volume of Part B (Base). Thoroughly agitate the mixture using a power-mixer. No Sweat-in is required. Only mix enough material that can be used within the applicable pot-life. See pot-life/temperature chart below for details.

POT LIFE

Temperature	
104° (40°C)	40 Min.
77°F (25°C)	2 Hr.
60°F (15°C)	4 Hr.



APPLICATION

SURFACE PREPARATION

For optimum performance, this product should be applied over abrasive blast cleaned steel surfaces prepared to SSPC-SP 5, 6, 7 or 10 with a 2.0 – 3.0 mil abrasive blast profile. Poor surface preparation will reduce the overall performance and service life of the coating. For best results, surfaces should be clean, dry and free of loose rust, dust, dirt, oil, grease, salt deposits or other contaminants prior to abrasive blasting. Remove all dust and abrasives before applying coating. If applying over previously installed coatings, test an inconspicuous area for lifting or softening of existing coating prior to full application.

APPLICATION CONDITIONS

Substrate and air temperatures must be at least 5°F (3°C) above the dew point and rising. Water condensation on the new film may cause surface imperfections and poor cure. Do not apply when Relative Humidity exceeds 85%. Avoid placing freshly painted components outdoors under wet, rainy conditions. Lower temperatures (< 60°F) will increase dry times. Do not use this product when temperatures fall below 50°F. Substrate temperatures above 120°F may cause the product to sag, curtain, or run.

APPLICATION DATA

Coating Thickness:	4-10 Mil DFT
Coverage:	147 Sq. Ft/Gal @ 8 Mil DFT
Full Cure:	10 Days @ 77°F
Re-coat:	6-8 Hr. @ 77°F

SPRAY APPLICATION

Airless Spray

Unit:	30:1 or Larger
Pressure:	2,800 – 3000 psi
Tips:	0.017” – 0.021”

Conventional Spray

Spray Gun:	Binks 95
Fluid Nozzle:	68
Air Cap:	68P
Atomizing Pressure	50 psi
Fluid Pressure	10-12 psi

BRUSH & ROLL APPLICATION

These products may be applied by brush or roller for touch-up. Use nylon or other brushes designed for solvent based paints. Use 3/8” rosin core roller covers designed for solvent-based paints. See application Guidelines for detailed instructions.



CLEAN UP THINNERS

Flush all paint supply lines immediately after application. Clean equipment Century thinners 10-T-101 or 10-T-120. Use soap and water to remove any material from hands or skin.



DRY SCHEDULE

Cure time in hours at recommended thickness @ 50% RH

Dry Time:

Temperature	Dry-Touch	Dry-Handle	Dry-Decal
104° (40°C)	1 Hr.	2 Hr.	2 Hr.
77°F (25°C)	5 Hr.	8 Hr.	8 Hr.
60°F (15°C)	9 Hr.	15 Hr.	15 Hr.
50°F (10°C)	15 Hr.	24 Hr.	24 Hr.



PHYSICAL PROPERTIES

Finish	High-Gloss
Mixed VOC	2.02 lbs./gal
Volume Solids	72%
Weight Solids	78%
Theoretical Coverage Per Gallon	1154 ft ² @ 1 mil DFT
	192 ft ² @ 6 mils DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Package Size 5 gallon pail, 50 gallon drum containers

STORAGE CONDITIONS

Store components between 55°F and 100°F. Store in dry shaded/covered conditions away from sources of heat and ignition.

Shelf-Life, Part A, 24 Months-Unopened, 77°F
Part B, 24 Months-Unopened, 77°F

SAFETY AND HANDLING

Please contact your Century representative for acceptable alternatives to the thinners listed above. Use soap and water to remove any material from hands or skin. Cleanup solvents or thinners are recommended to be used in accordance with each facilities Environmental, Health and Safety standards, regulations and procedures. Please read and understand the Safety Data Sheet before using this product.