



# Tufcote™ EG 189 High-Solids Epoxy Liner

(Formerly Century EcoGuard™ 189)



## GENERAL

### DESCRIPTION

Tufcote™ 189 is an ultra-low VOC, high solids epoxy liner that cures to form a smooth, glossy finish with excellent release properties. This product provides high corrosion protection, excellent chemical resistance and has increased flexibility over traditional linings to help reduce cracking and failures common in transportation linings.

#### Product Highlights:

- Complies fully with FDA 21 CFR § 175.300 (“Resinous and polymeric coatings”)
- Increased flexibility over traditional epoxy lining.
- High-build, single coat protection
- Ultra-low VOC

### SUGGESTED USES

The Tufcote™ 189 is designed to be used as a one-coat, internal liner used to transport bulk quantities of dry goods including plastic pellets used in food-grade service. Contact your Axalta Representative for additional service/commodity recommendations.

### COLORS AVAILABLE

Hopper Blue  
Custom Colors Available



## MIXING

### MIXING RATIO

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

### COMPONENTS

Base:  
189-H300-101

Activator:  
189-V-101

### REDUCTION

No reduction necessary for heated plural-component airless spray.

### INDUCTION

No induction or “sweat-in” required.

### POT LIFE

Temperature	
104° (40°C)	12 Min.
77°F (25°C)	30 Min.
60°F (15°C)	50 Min.
50°F (10°C)	90 Min.



## APPLICATION

### SURFACE PREPARATION

Surfaces should be cleaned and prepared to SSPC SP-1 "Solvent Clean" prior to abrasive blasting. Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water cleaning. When surface is dry, abrasive grit blast to achieve a minimum Sa 2½ (SSPC-SP 10). Recommended surface profile is Rz 75-100 micron/3-4 mils, corresponding to Rugotest No. 3, BN10 or Keane-Tator Comparator, minimum 3.0 G/S, or ISO Comparator, Medium (G). After blasting clean the surface carefully from abrasives and dust.

### 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:	8-16 Mil DFT
Coverage:	184 Sq. Ft/Gal @ 8 Mil DFT
Full Cure:	5-7 Days @ 77°F
Re-coat (Min):	6 Hr. @ 77°F
Re-coat (Max):	48 Hr. @ 77°F

### SPRAY APPLICATION

#### Heated Plural-Component Airless Spray

Application Equipment:	1:1 Ratio, Heated Plural-Component Airless
Material Temperature (Day Tank):	95°F - 140°F (Max)
Touch-up/Repair:	Spray, Brush/Roll
Optimum Spray Temperature:	115°F, Measured at Gun. Do not exceed 140°F
Supply Hose:	3/8" Insulated/Heated 80' Maximum
Spray Hose:	1/4", 10' Maximum
Recommended Spray Pressure:	3,500 - 4,500 PSI
Recommended Tip Orifice:	.019 - .021

Refer to the Tufcote™ EG 189 Application Guidelines for detailed surface preparation and application instructions.

### BRUSH & ROLL APPLICATION

This product may be applied by brush or roller for touch-up. Use nylon or other brushes designed for solvent based paints. Use ¼' rosin core roller covers designed for solvent-based paints.

### CLEAN UP THINNERS

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



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## DRY SCHEDULE

Cure time at 8 mil DFT

Temperature	Dry-Touch	Dry-Handle
104° (40°C)	1Hr.	3 Hr.
77°F (25°C)	4 Hr.	9 Hr.
60°F (15°C)	8 Hr.	17 Hr.
50°F (10°C)	13 Hr.	27 Hr.



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## PHYSICAL PROPERTIES

Finish	High-Gloss
Mixed VOC	.057 lbs./gal
Volume Solids	92% +/- 1%
Weight Solids	96% +/- 1%
Theoretical Coverage Per Gallon	1475 ft <sup>2</sup> @ 1 mil DFT 184 ft <sup>2</sup> @ 8 mils DFT

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

Package Size: 3-gallon pail, 30-gallon drum containers

### RECOMMENDED 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

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## SAFETY AND HANDLING

Please contact your Axalta 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 and understand the Safety Data Sheet before using this product.