



FEDERAL INDUSTRIAL LININGS

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TECHNICAL DATA SHEET

FEDFOOD 511

DESCRIPTION

FEDFOOD 511 is a two component solvent free, high build epoxy coating utilizing resins that are compliant with the requirements of FDA regulation 21CFR 175.300 for coatings or linings in contact with food, edible oils, drinking water or alcoholic beverages containing up to 12% alcohol by volume. It is specially designed to provide excellent corrosion protection and can be used in atmospheric and submerged conditions. **FEDFOOD 511** can be applied to all types of metal and concrete substrates. May also be used with fibreglass reinforcing.

PRINCIPLE USES

FEDFOOD 511 is intended as a food grade & potable water grade coating/lining for potable water tanks, beer tanks, wine tanks, beverage tanks & and dry or wet food tanks, vessels or silo's. It is resistant to most common chemicals, petroleum products, dilute acids and alkalis, aliphatic solvents, sea water, wine and beer.

PERFORMANCE DATA

Description

Results

Pot Life (Minutes)	80 min (25°C)
Mix Ratio	2 : 1 (by volume)
Colours	White, Grey or Green
Touch Dry (Hours) @ 25°C	8 hrs
Open Time / Over Coating Time @ 25°C	10 - 24 hrs
Hard Dry (Hours) @ 25°C	30 hrs
Walk on Dry (Hours) @ 25°C	48 hrs
Full Cure @ 25°C	7 days
Kit Size	3lt & 15lt kits
Volume Solids	100%
Theoretical Coverage (m ²)	2 coats @ 4m ² /litre/coat (250µ DFT per coat)
Indicated WFT / DFT	250µm / 250µm per coat
Service Temperature	Atmospheric 70°C / Submerged 50°C
Shelf Life	12 months

ADVANTAGES

- Easily applied by brush, roller or airless spray
- Good abrasion resistance
- Good resistance to chemicals, alcohols (up to 12%) & solvents
- Can be used in food grade & potable water applications
- Can be used on all metal & concrete substrates

SURFACE PREPARATION

Mechanical preparation of the steel substrate is important before application of **FedFood 511**. The substrate should be structurally sound and free of oil, dust and debris, grease, paint, corrosion deposits, laitance or other surface deposits. De-Grease substrate with **FedGuard 999** prior to grit blasting if required.

FedGuard 999 also acts as a rust inhibitor to prevent flash rust for up to 4 days after grit blasting.

Metal surfaces should be prepared by grit blasting to Sa 2½ (ISO 8501-1) and primed with **FedPrime MC808**. If grit blasting is not possible a suitable surface tolerant primer (**FedPrime STE**) is required (available from Federal Industrial Linings).

On concrete surfaces **FedPrime MC808 Primer** must be used. The surface should be prepared by grit blasting or as per standard practice (mechanical grinding or acid etching) to expose aggregate surface or to achieve the necessary cleanness & roughness prior to application of **FedPrime MC808 Primer**. Any porous or absorbed areas still showing after priming applications, should be primed again.

MIXING

Premix base (Part A) and shake hardener (Part B) to disperse any settlement. Add all of Part B to part A and mix using a mixer with a mixing paddle at medium speed for 2-3 minutes until both components have fully dispersed and is homogenous. Ensure to rotate the mixer inside the container and into the corners of the container. Do not add thinners. Only mix full packs.

APPLICATION

Apply **FedFood 511** to the total recommended thickness of 500µm (2 or 3 coats of 165µm to 250µm each) using an airless sprayer or brushes & rollers to a cleaned and prepared surface. A written specification always supersedes any application guideline. Apply subsequent coats within 10 to 24 hours after application. Should the over coating time be exceeded roughen the surface & wash the coating off with high pressure fresh water or solvent wipe to remove any surface salts & deposits prior to over coating.

CLEANING

Clean hands and skin immediately after use with industrial hand cleaner.

Clean tools and equipment immediately after use with **FedThin** Epoxy Thinners, or **FedClean 701** equipment cleaner.

LIMITATIONS

- Application temperatures between 5°C and 40°C.
- Max service temperature is 70°C dry & 50°C submerged.
- Avoid excessive application.
- Avoid contact with skin.
- Do not release into sewer or surface water.

STORAGE AND STABILITY

Both **FEDFOOD 511** Part A and Part B have a shelf life of 12 months when stored in unopened containers in a cool, dry place. Failure to do so will result in a reduction of shelf life.

SAFETY AND HANDLING

FEDFOOD 511 contains chemicals. Use only with adequate ventilation. Avoid breathing of vapours and prolonged or repeated skin contact. Protective clothing and gloves should be worn when handling this product.

All sources of ignition should be removed. If exposed, eyes should be well flushed with water for 15 minutes and medical attention must be sought instantly.

This product is for professional use only. The applicators and operators must be trained, experienced and have the ability and equipment to apply the coatings correctly and according to specification. Applicators and operators must use the appropriate PPE when using this product. The safety procedures applicable to the handling of chemical materials should be read, understood and rigidly adhered to.

The information contained in this bulletin is, to the best of our knowledge true and accurate, but any recommendations or suggestions which may be made, are without guarantee, since the conditions of use are beyond our control. Furthermore, nothing contained herein shall be construed as a recommendation to use any product in conflict with existing patents covering any material or its use.