Protective & Marine Coatings
PRODUCT DATA SHEET

HEAT-FLEX® 750
ALKYLATED AMIDE EPOXY

Revised: April 5, 2023

PRODUCT DESCRIPTION

HEAT-FLEX 750 is a high solids micaceous iron oxide enhanced alkylated amide epoxy providing both corrosion resistance and high temperature resistance. The micaceous iron oxide provides excellent edge retention properties, higher temperature resistance, improved anticorrosion performance, film reinforcement, tolerance to over film thickness, and lower moisture permeation.

INTENDED USES

- External protection for process pipes, valves and vessels operating continuously between the temperatures of -321°F/-196°C and 400°F/204°C with excursions to 450°F/232°C
- Suitable for use on both carbon and stainless steel in insulated, uninsulated and cryogenic environments

PRODUCT DATA

Finish: Flat

Colors: Gray and Dark Gray

Volume Solids: 78% ± 3%, mixed (ASTM-D2697-91)

VOC (EPA Method 24), mixed: <250 g/L; 2.1 lb/gal

Mix Ratio: 4:1 by volume

Typical Thickness:

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils (microns)	**5.0** (125)	**13.0** (325)
Dry mils (microns)	**4.0** (100)	**10.0** (250)
~Coverage sq ft/gal (m^2/L)	**125** (3.1)	**312** (7.8)
Theoretical coverage **sq ft/gal** (m^2/L) @ 1 mil / 25 microns dft	**1251** (30.7)	

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Shelf Life: 12 months, unopened
Store indoors at 40°F (4.5°C) to 100°F (38°C).

Flash Point: Part A: 106°F (41°C)
Part B: 109°F (43°C)

Reducer / Clean Up[1]: High Solids Compliant Thinner #1 - Fast

Weight: 17.3 ± 0.2 lb/gal ; 2.08 Kg/L, mixed

[1]See Application section on next page for more information

Average Drying Times:

	59°F (15°C)	73°F (23°C)	95°F (35°C)
Touch:	1.25 hours	45 minutes	30 minutes
Handle:	10 hours	6 hours	3 hours
Recoat:			
minimum:	6 hours	4 hours	2 hours
maximum:	7 days	7 days	7 days
Pot life:	2.5 hours	1.5 hours	1 hour
Sweat-in-time:	none required		

Pot life is dependent upon temperature and mass.

If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to coating application, surfaces should be assessed and treated in accordance with ISO 8504:2000. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Minimum recommended surface preparation:

Iron & Steel: SSPC-SP10/NACE 2, 2-3 mil (50-75 micron) profile

Stainless Steel: Abrasive blast clean SSPC-SP17, 2.0 mil (50 micron) anchor profile

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APPLICATION

Airless Spray
Pressure.....2200 psi minimum (151 bar)
Tip .....015"-.019" (0.38-0.48 mm)

Conventional Spray
Atomization Pressure.....50 psi (3.4 bar)
Fluid Pressure.....5 psi (0.3 bar)
Reduction**.....As needed up to 10% by volume

Brush*
Brush.....Natural Bristle
Reduction**.....As needed up to 10% by volume

Roller*
Cover .....3/8" woven with solvent resistant core
Reduction**.....As needed up to 10% by volume to aid flow and leveling

**Application of more than one coat may be necessary to give equivalent dry film thickness to a single spray applied coat.*

**Material can be reduced up to 10% in VOC restricted areas (≤250 g/L) with High Solids Compliant Thinner #1 - Fast. Other areas (>250 g/L) use High Solids Compliant Thinner #1 - Fast or MEK. Choose a reducer that is compliant in your area. Confirm compliance with state and local air quality rules before use.

Clean up mixing and application equipment immediately after use, in VOC restrictive areas (VOC ≤25 g/L, or ≤3%), with High Solids Compliant Thinner #1 - Fast. Other, less restrictive areas (>25 g/L or >3%), use High Solids Compliant Thinner #1 - Fast or MEK. Choose a cleaner that is compliant in your area. Confirm compliance with state and local air quality rules before use.

If specific application equipment is not listed above, equivalent equipment may be substituted.

RECOMMENDED SYSTEMS

Dry Film Thickness / ct.		Mils	(Microns)
Steel or Stainless Steel			
1 Ct.	Heat-Flex 750	5.0-10.0	(125-250)
1 Ct.	Heat-Flex 750	5.0-10.0	(125-250)

The systems listed above are representative of the product's use, other systems may be appropriate.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

APPLICATION CONDITIONS

Temperature:

Air & Material:	40°F (5°C) minimum, 120°F (49°C) maximum
Surface:	40°F (5°C) minimum, 212°F (100°C) maximum At least 5°F (2.8°C) above dew point
Relative humidity:	90% maximum

APPROVALS

- Tested in accordance with ISO 19277 Houston pipe test CUI 3
- ISO 12944 CX

ADDITIONAL NOTES

Do not tint.

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

Do not mix previously catalyzed material with new.

If an aesthetic finish is required for ambient temperatures up to 248°F (120°C), then Heat-Flex 750 is compatible with a wide range of Sherwin-Williams polyurethane, polysiloxane and NCO free finishes. At temperatures above 248°F (120°C), please consult with your Sherwin-Williams Representative.

HEALTH AND SAFETY

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Sheet.