1241 Surface Tolerant Epoxy Coating System™

Technical Data Sheet

Revision date: April 2022

Exception Corrosion Protection and Primer

- Applicator-friendly formulation
- Two types of catalyst - 1241 for cold weather, 1241CS for warmer weather
- Ideal for steel and aluminum
- Adheres to damp surfaces
- Fast re-coat with the 1241 Catalyst

Multi-Purpose Surface Tolerant Coating System

OVER 40 YEARS

PRODUCT DESCRIPTION

1241 is a multi-purpose, surface tolerant, two-part epoxy coating system that applies easily to non-optimal surfaces yet provides excellent chemical and abrasion resistance for marine vessels and offshore structures above and below the waterline. Its chemically-cured formulation allows application at low temperatures and to damp surfaces, even those exhibiting flash rust. 1241 cures to a semi-gloss finish for use in tank linings or on pipe coatings. Its self-priming nature provides an excellent surface for ship and barge antifouling hull coatings. **There are two types of catalyst –** 1241 for cold weather applications and 1241CS for warm weather applications. The 1241CS catalyst cures slower than the regular 1241 catalyst. See Pot Life in the Characteristics section.

CHARACTERISTICS

Finish: Semi-gloss
Colors: Gray
Volume Solids: 68%
Weight Solids: 80%
VOC (EPA Method 24):
Unreduced: 281 g/l; 2.35 lb/gal, when mixed.
Mixing Ratio: 4:1 by volume
Typical film Thickness Per Coat:
Wet: 5.9 – 11.8 mils (150-300 microns)
Dry: 4.0 – 8.0 mils(102-203 microns)
Coverage: 136-273 sq ft/gal (3.3-6.7 m2/liter) at stated DFT and volume solids
Recommended Coats: 2
Pot Life: 3 hours with 1241 Catalyst, 8 hours with 1241CS Catalyst
Weight per gallon: 11.6 ± 0.2 lbs mixed
Flash Point: 100°F
Reducer/Clean Up: 2033

FEATURES & BENEFITS

- Exceptional corrosion protection in both salt and fresh water immersion and corrosive chemical environments provides multiple uses for ships, marine structures, in fabrication and during new construction
- Surface tolerant formulation, reduces surface preparation time and cost
- Low temperature cure expands application window (to 0°F, -18°C)
- Quick drying with 1241 Catalyst provides fast re-coating
- Low VOC formulation complies with rigid VOC limits

APPLICATION TIPS

An easy rule in epoxies for overcoating is when the coating is dry to touch, yet still has some tack, it is ready for overcoat (press thumb onto surface; the surface should leave a thumb print without lifting any epoxy)

For best results in uniformity, apply at the recommended mil thickness.

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Brush and roll applications may require multiple coats to achieve maximum film thickness and uniformity of appearance. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary, cross spray at a right angle. Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, over thinning, climatic conditions, and excessive film build.

In order to avoid blockage of spray equipment, clean equipment, before use or before periods of extended downtime with recommended cleaning solvent.

Dry Times and Overcoating Intervals when using 1241C Catalyst:

Substrate Temp.	Recoating With 1241		Overcoating With Bottom Paint		Sweat-In Time
Temp F°(C°)	Min	Max	Min	Max	
32°F (0°C)	11 hours	1 month	11 hours	2 days	10 mins.
77°F (25°C)	4 hours	1 month	4 hours	1 day	none
90°F (32°C)	2 hours	1 month	2 hours	8 hours	none

Dry Times and Overcoating Intervals when using 1241CS Slow Cure Catalyst:

Substrate Temp.	Recoating With 1241		Overcoating With Bottom Paint		Sweat-In Time
Temp F°(C°)	Min	Max	Min	Max	
32°F (0°C)	22 hours	1 month	16 hours	3 days	10 mins.
77°F (25°C)	8 hours	1 month	6 hours	1 day	none
90°F (32°C)	4 hours	1 month	4 hours	8 hours	none

Cure for immersion: 7 days @ 77°F

SURFACE PREPARATION

Surface must be clean, dry, clean, free of oil, grease, form release agents, curing compounds, other foreign matter and be structurally sound. All direct to metal coatings provide maximum performance over blasted surfaces. There are situation and cost limitations which preclude blasting. Surface Tolerant Epoxy Primer 1241 was designed to provide excellent protection over less than ideal surface preparation. The minimum standard for non-immersion is SSPC-SP2 or ISO8501-1:2007 St2; for immersion service the minimum standard is SSPC-SP6 or ISO8501-1:2007 Sa2. These minimum surface preparation standards apply to steel that has been previously abrasive blasted, coated and deteriorated.

New Surfaces:

Steel
New steel surfaces should be initially abrasive blasted to near-white metal surface cleanliness in accordance with SSPC-SP10 or ISO8501-1:2007 Sa2.5. Blast profile on steel should be at least 2.5 mils (63 microns) in depth.

MIXING INSTRUCTIONS

Mix paint thoroughly by power drill motor and Jiffy Mixer paddle or by boxing and stirring before use.

Apply paint at the recommended film thickness and spreading rate as indicated on front page.

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer or cleaner. Any reduction must be compliant with VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up: Sea Hawk 2031-2033 Epoxy Reducer

Airless Spray

Unit.....45:1 Pump or larger
Pressure.....2400 - 3000 psi
Hose.....1/4" - 3/8" ID
Tip .....0.019 - 0.023 fluid tip
Filter .....60 mesh
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 phenolic core

SAFETY PRECAUTIONS

Refer to the SDS before use. Published technical data and instructions are subject to change without notice. Contact your Sea Hawk representative for additional information.

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