

DESCRIPTION

Two-component, surface tolerant glass flake high build polyamine cured epoxy coating.

PRINCIPALS CHARACTERSTICS

- For use in both off shore splash zone maintenance and on shore application
- Designed for use in heavy duty and corrosive environments
- Glass flake reinforced for improved impact and abrasion resistance
- Recommended for application on exterior of buried pipes
- Excellent see water ,cracking and corrosion resistance
- Long term protection in a single coat application
- Strong adhesion properties ,suitable for wet blast cleaned substrates

COLOR AND GLOSS LEVEL

- Grey (other color available in request)
- gloss

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of component	Two
Mass density	1.46 kg/l
Volume solid	83 ±2 %
VOC (supplied)	Max 150 g/L
Recommended dry film thickness	200-1000 µm (8-40 mils)depending on the system
Theoretical spreading rate	4.3 m ² for 200 µm
Dry to touch	4 hours
Over coating interval	Minimum:8hours Maximum: 3 days
Full cure after	7days
Shelf life	Base: at least 24 months when stored cool& dry Hardener: at least 24 months when stored cool& dry



Recommended substrate conditions and temperatures

SUBSTRATE CONDITIONS

- Steel blast cleaned to ISO-SA2½
- Blasting profile of 40 - 80 (1.6 – 1.3 mils) is recommended
- Previous coat must be dry and free from any contamination

SUBSTRATE TEMPERATURE

- Substrate temperature during application and curing should be above -5°C(23°F)
- Substrate temperature during application and curing should be 3°C(5°F) above dew point

Instruction for use

Mixing ratio by volume base to hardener 75:25

- Temperature of the mixed base and hardener preferably above 15°C(59°F)
- Adding too much thinner results in reduced sag resistance and slower cure.
- Thinner should be added after mixing two components

Induction time

Non

Pot life

1.5 hours @20°C (68 °F)



Air less spray

Recommended thinner

Thinner no 90

Volume of thinner

0 - 5% depending on required thickness and application conditions

Nozzle orifice

0.53 – 0.69 mm

Nozzle pressure

15 MPA

Air spray

Recommended thinner

Thinner no 90

Volume of thinner

0 to 8% depending on required thickness and application conditions

Nozzle orifice

1.5 – 3 mm

Nozzle pressure

0.2 – 0.4 MPA



BRUSH / ROLLER

Only for touch up and repair

Volume of thinner

0 to 5% depending on required thickness and application conditions

Cleaning thinner

Thinner No 50

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
300 µm (3 mils)	2.8 m ² /l
500 µm (4 mils)	1.66 m ² /l

Curing time for DFT up to 300 µm (12 mils)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	10 hours	24 hours	15 days
10°C (50°F)	8 hours	20 hours	10 days
20°C (68°F)	4 hours	10 hours	7 days
30°C (86°F)	2 hours	4 hours	5 days

-adequate ventilation must be maintained during applications and curing



Pot life at application viscosity	
Mixed product temperature	Pot life
15°C (59°F)	2 hours
20°C (68°F)	1.5 hours
30°C (86°F)	1 hours

SAFETY PRECAUTIONS

- This is a solvent- borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eye

