

APCODUR CF 640

Surface tolerant epoxy coating



PRODUCT DESCRIPTION

Two component, high build, self-priming, rust encapsulating, modified epoxy coating

FEATURES AND RECOMMENDED USE

- Designed as a high performance maintenance coating for coastal and industrial polluted environments
- Self priming; eliminates the usage of primer
- Suitable as a touch up coat in projects for weld seams and damaged
- Can be applied on marginally prepared surfaces; tolerant to lower epoxy coatings grades of steel preparation
- Can be over coated with conventional coatings and most two component paints
- Good adhesion to aged and sound epoxy, polyurethane and conventional alkyds
- Good chemical resistance and Good corrosion resistance

TECHNICAL DATA

Colour	Range
Gloss	Satin
Volume Solids	Approx. 80%
Recommended DFT / Coat	75 - 125 microns
Theoretical Coverage Capacity	10.7 sq.mtr/ ltr @ 75 microns DFT 6.4 sq.mtr/ ltr @ 125 microns DFT
Drying time at 30°C	Surface Dry : 2 hours Hard Dry : 12 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 12 hours Max. : 1 Month, provided surface is dry and clean from all contamination.

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method.
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30°C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel , abrasive blast clean to min. Sa 2 1/2 (ISO 8501-1: 200) or SSPC –SP6. In case oxidation has occurred between blasting and application of Apcodur CF 640, the surface should be reblasted
- A blasting profile of (Rz) 50-75 microns is recommended

For atmospheric exposure condition

- New hot-rolled steel; blast cleaned to min Sa 2 of Swedish specification
- Weathered steel-power tool cleaned to St 3 or hand tool cleaned to St 2
- Existing sound epoxy coating system and sound alkyd coatings; sufficiently roughened, dried, and cleaned High pressure fresh water washing or scrubbing to remove loose paint and contamination. Intact areas to be roughened. Damaged and rusty areas to be derusted to minimum St3 /St2 by power tool / hand tool cleaning

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcodur CF 640 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 1 : 1
Induction Time	15 minutes
Pot Life at 30°C	2 hour

Application

Air Spray	
Recommended thinner	T 141
Volume of thinner	5 - 25%
Nozzle orifice	1.5 – 3.00 mm
Nozzle Pressure	0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 57 p.s.i.)
Cleaning Thinner	T 141
Airless Spray	
Recommended thinner	T 141
Volume of thinner	5 - 15%
Nozzle orifice	0.53 - 0.66 mm (21 – 26 Thou)
Nozzle Pressure	20 – 24 MPa (= approx. 200 – 240 atm; 2800 – 3400 p.s.i.)
Cleaning Thinner	T 141
Brush	
Recommended thinner	T 141
Volume of thinner	0 - 10%
Cleaning Thinner	T 141

Note: Air spray is generally not recommended. For touch up of small and inaccessible area air spray can be done.

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Special Instruction

- Surface discoloration may occur upon exposure to sunlight, elevated temperatures or chemicals. However, this does not impact anti-corrosive performance
- Not recommended for immersion services in acids, alkalies & solvents
- A test patch is recommended over non-ferrous metals and adhesion to be checked as per ASTM D 3359 to confirm suitability
- While applying on condensed areas, thoroughly wipe out the moisture before application

Product Characteristics

- Maximum film build in one coat is best attained by airless spray. Air spray (pressure pot) may require a multiple cross spray pattern to achieve optimum film build. By brush application typical 75 microns is achieved in one coat and multiple coats will be required to achieve the total specified thickness
- The maximum performance is achieved after complete curing
- A minimum of two coats are recommended over prepared surface
- As common to all epoxy, the product will chalks and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

PACK SIZE	20 ltrs (Base : 10 ltrs & Hardener : 10 ltrs) 40 ltrs (Base : 20 ltrs & Hardener : 20 ltrs)
STORAGE	Shelf Life: Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Base : Not less than 24°C Hardener : Not less than 24°C VOC: Approx. 200 ± 40 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.7 ± 0.07 kg/ ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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Head Office: Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, Near Religare Building, S.V. Road, Goregaon (W), Mumbai 400 062. **Tel No:** 022 61089800, **Email:** customercare.apppg@asianpaintsppg.com, **Website:** www.asianpaintsppg.com