

APCODUR EHB COATING

Epoxy Finish

PRODUCT DESCRIPTION

Two component, high solid, high build aliphatic amine cured epoxy coating

FEATURES AND RECOMMENDED USE

- Designed as a build coat or finish in protective coating systems for protection of steel and concrete structures
- Recommended for highly corrosive industries in both new constructions and maintenance situations
- Excellent chemical and water resistance

TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 85%
Recommended DFT / Coat	100 - 300 microns
Theoretical Coverage Capacity	8.5 sq.mtr/ ltr @ 100 microns DFT 2.8 sq.mtr/ ltr @ 300 microns DFT
Drying time at 30°C	Surface Dry : 4 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
- Suitable zinc primer (for steel) and epoxy primer (for steel and concrete) or intermediate; dry and free from all surface contamination. In case of aged epoxy coating, the surface should be sufficiently roughened prior to painting
- For application over weathered zinc primer, ensure white rust removal by thorough water scrubbing/ high-pressure water cleaning. Zinc rich coating are porous and hence pinhole may occur in subsequent coat due to solvent popping. To minimize pinholes, apply a mist coat as the first pass of the subsequent coat, let the entrapped air escape and then apply full coat

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 EHB Coating 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 4 : 1
Induction Time	10 minutes
Pot life at 30°C	60 minutes

Application

Airless Spray	
Recommended thinner	T - 141
Volume of thinner	5 - 20%
Nozzle orifice	0.53- 0.66 mm (21 – 26 Thou)
Nozzle Pressure	20 - 24 MPa (= approx. 200 - 240 atm; 2900 - 3500 p.s.i.)
Cleaning Thinner	T- 141
Brush / Roller	
Recommended thinner	T - 141
Volume of thinner	0 - 10%

Note: As common to all epoxy, the product will chalk and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

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

Product Characteristics

- Maximum film build is best attained by airless spray
- Typically 100 - 125 microns can be achieved by brush application. Multiple coats will be required to achieve the total specified dry film thickness by brush application
- For requirement of exterior durability with good gloss and colour retention, overcoat with recommended topcoats
- The maximum performance is achieved after complete curing

PACK SIZE	20 ltrs (Base : 16 ltrs & Hardener : 4 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. 125 ± 30 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.48 ± 0.06 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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