

APCODUR RAPID RECOAT HB MIO

Epoxy intermediate pigmented with lamellar micaceous iron oxide

PRODUCT DESCRIPTION

Two component, high build epoxy intermediate pigmented with lamellar micaceous iron oxide

FEATURES AND RECOMMENDED USE

- High build intermediate coat for use on pre-primed steel
- Rapid curing and overcoating properties
- Excellent resistance to moisture and saline conditions
- Good resistance to water and splashes of mild chemicals
- Good abrasion resistance
- Easy application by air/airless spray

TECHNICAL DATA

Colour	Grey (Self Standard)
Gloss	Matt
Volume Solids	Approx. 60%
Recommended DFT / Coat	75 - 125 microns
Theoretical Coverage Capacity	8.0 sq.mtr/ ltr @ 75 microns DFT 4.8 sq.mtr/ ltr @ 125 microns DFT
Drying Time at 30°C	Surface Dry : 90 minutes Hard Dry : 16 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 4 hours Max. : 1 Month, provided surface is cleaned 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, epoxy primer or epoxy intermediate coat; dry and free from all surface contamination. In case of aged epoxy coating, the surface should be sufficiently roughened and cleaned prior to painting
- For application over weathered zinc primers, ensure white rust removal by thorough water scrubbing/ high pressure water cleaning. A mist coat is recommended when applied over zinc primers

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, the surface should be reblasted
- A blasting profile of (Rz) 50-75 microns is recommended

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 RR HB MIO 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 5 : 1
Induction Time	30 minutes
Pot Life at 30°C	5 hours

Application

Air Spray	
Recommended thinner	T 141
Volume of thinner	5 - 25 %
Nozzle orifice	1.5 - 3.0 mm
Nozzle pressure	0.3-0.4 MPa (= approx. 3 – 4 atm; 43 – 47 p.s.i.)
Cleaning Thinner	T 141
Airless Spray	
Recommended thinner	T 141
Volume of thinner	5 - 10%
Nozzle orifice	0.48 - 0.53 mm
Nozzle pressure	19 MPa (= approx. 190 atm; 2800 p.s.i.)
Cleaning Thinner	T 141
Note: Brush application is recommended only for touch up.	

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 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 50-75 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

PACK SIZE	20 ltrs (Base : 16.67 ltrs & Hardener : 3.33 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. 350 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.68 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



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