

APCODUR RAPID RECOAT PF COATING

Fast curing epoxy coating



PRODUCT DESCRIPTION

Two component, polyamide cured epoxy coating pigmented with zinc phosphate

FEATURES AND RECOMMENDED USE

- Recommended as a one or two coat primer / finish coating or as an intermediate over recommended anti-corrosive primer
- Fast drying & rapid recoating properties
- Excellent corrosion and chemical resistance
- Good abrasion resistance
- Low volatile organic content

TECHNICAL DATA

Colour	Off – White, Red Oxide and Greys
Gloss	Semi - Glossy
Volume Solids	Approx. 70%
Recommended DFT / Coat	75 - 150 microns
Theoretical Coverage Capacity	9.3 sq.mtr/ ltr @ 75 microns DFT 4.6 sq.mtr/ ltr @ 150 microns DFT
Drying Time at 30°C	Surface Dry : 45 minutes Hard Dry : 3 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 1 hours Max. : 1 month, provided surface is dry and clean from all contamination

*Other limited shades on request

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, the surface should be reblasted.
- A blasting profile of (Rz) 50-75 microns is recommended.
- If blast cleaning is impractical, remove loose rust/ scale using power tools to achieve St 3 grade of surface preparation as per Swedish standards.
- Suitable zinc primer or epoxy primer, dry & free from all surface contamination

Concrete:

- New concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. Ensure that the surface is free from curing compounds, release agents, trowelling compounds, surface hardeners, grease, oil dirt, and old coatings, loose or disintegrated concrete.
- The surface to be preferably prepared by light blasting. In case blasting is not practical, wire brushing to be adopted to remove lattices, followed by treating with dilute (10%) hydrochloric acid. Remove acid and contaminants by liberal water wash. Ensure that acid solution does not retain on the surface & joints. Allow the surface to dry thoroughly before applying primer

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 Rapid Recoat PF 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 6 : 1
Induction Time	15 minutes
Pot Life at 30°C	2 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	0 - 10%
Nozzle orifice	0.41 - 0.48 mm
Nozzle pressure	15 – 19 MPa (= approx. 150 – 190 atm; 2100 – 2700 p.s.i.)
Cleaning Thinner	T 141
Brush (only for touch up)	
Recommended thinner	T 141
Volume of thinner	0 - 5%
Cleaning Thinner	T 141

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 of in accordance with appropriate regional legislation.

Note:

The product can be applied upto 150 microns/ coat by airless spray application, however the minimum overcoating interval will be extended and maximum overcoating interval will be reduced

For rapid overcoating, the primer and subsequent coat is to be applied by spray only

Product Characteristics

- Maximum film build in one coat application is best attained by airless spray. Application by air spray may require a multiple cross spray pattern to achieve maximum film build
- To provide good penetration with the concrete substrate, it is recommended to add 10-15% thinner for the first coat application
- The maximum performance is achieved after complete curing.
- As common to all epoxy, the product will chalk and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

PACK SIZE	20 ltrs (Base : 17.15 ltrs & Hardener : 2.85 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. 300 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.55 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.

'APCODUR' is a Trademark of Asian Paints Ltd. | Licensed user: Asian Paints PPG Pvt. Limited.

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