

APCOTHERM EPN 200

Epoxy Phenolic Novalac

PRODUCT DESCRIPTION

Two component high build epoxy phenolic novolac coating for high temperature service.

FEATURES AND RECOMMENDED USE

- Designed to provide excellent corrosion & chemical resistance when used in high temperature service
- Recommended as a corrosion resistant barrier to protect for steelwork under thermal insulation subject to wet and dry cycles from -196° C to + 230° C
- Suitable for exposure to a wide range of corrosive environments and exterior of insulated or un-insulated steel pipeline, process equipments, vessels, etc., operating continuously upto 230°C and intermittently at 250°C
- Self priming; excellent adhesion on blast cleaned steel
- Excellent resistance to “Thermal Shock” experienced during rapid heating and cooling conditions

TECHNICAL DATA

Colour	Red Oxide (Self Standard)
Gloss	Matt
Volume Solids	Approx. 70%
Recommended DFT / Coat	100 - 125 microns
Theoretical Coverage Capacity	7.0 sq.mtr/ ltr @ 100 microns DFT 5.6 sq.mtr/ ltr @ 125 microns DFT
Drying Time at 30° C	Surface Dry : 5 hours Hard Dry : 12 hours Full Cure : 7 days
Over coating interval 30° C	Min. : 12 hours Max. : 4 days

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 2½ (ISO 8501-1:200) or SSPC-SP6. In case oxidation has occurred between blasting and application of Apcotherm EPN 200, 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

- Apcotherm EPN 200 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 too much thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 4 : 1
Induction Time	10 Minutes
Pot Life at 30°C	3 Hours

Application

Airless Spray	
Recommended thinner	T - 141
Volume of thinner	0 - 5%
Nozzle orifice	0.43 - 0.53 mm (17 - 21 Thou)
Nozzle pressure	17 - 20 MPa (= approx. 170 - 200 atm; 2500 - 2900 p.s.i.)
Cleaning Thinner	T 141
Brush / Roller	Suitable for stripe coating and small areas
Recommended thinner	T - 141
Volume of thinner	0 - 5%

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

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
- Typical system of 2 coats at 100 microns is recommended for optimum performance. By brush application, a three coat system to give a total dry film thickness of 200 microns is recommended. The total system thickness must not exceed 300 microns in order to avoid cracking at high temperature service.

- The maximum performance is achieved after complete curing
- As common with all epoxies Apcotherm EPN 200 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. The actual rate of chalking will depend upon climatic conditions and will normally be limited to a thin surface layer
- Apcotherm EPN 200 is not recommended as an internal tanklining

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. 250 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.45 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 is always recommended while spraying paint
- Please refer our Material Safety Data Sheet prior to using the product



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