

APCOGUARD CF 707 FINISH

Epoxy phenolic novolac

PRODUCT DESCRIPTION

Two component, high build amine cured epoxy phenolic coating

FEATURES AND RECOMMENDED USE

- Excellent resistance to furnace oil, diesel, engine oil and wide range of petroleum solvents
- Excellent corrosion resistance for steel work under thermal insulation subject to wet and dry cycles
- Suitable to exposure wet heat up to 150°C and dry heat up to 200°C
- Excellent abrasion and impact resistance

TECHNICAL DATA

Colour	Greyish Black (Self Standard)
Gloss	Matt - Eggshell
Volume Solids	Approx. 70%
Recommended DFT / Coat	100 - 150 microns
Theoretical Coverage Capacity	7.0 sq.mtr/ ltr @ 100 microns DFT 4.7 sq.mtr/ ltr @ 150 microns DFT
Drying time at 30°C	Surface Dry : 6 hours Hard Dry : 16 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 16 hours Max. : 5 days, provided the surface is dry and 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

- To apply over suitable epoxy primer (Apcodur CP 682) or can be applied on directly abrasive blast cleaned steel surface
- In case of aged epoxy coating, the surface should be roughened and cleaned thoroughly prior to painting
- 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
- Where necessary remove weld spatter, weld seams and sharp edges prior to application of primer

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 primer or this coating, the surface should be reblasted
- A blasting profile of (Rz) 50-75 microns is recommended
- Any surface defect revealed by the blast cleaning process should be corrected or treated appropriately (grinding, filling etc.)

Application Conditions

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

Mixing

- ApcoGuard CF 707 Finish 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
- If required, thinner should be added after mixing the components. Addition of too much thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 5 : 1
Induction Time	10 minutes
Pot Life at 30°C	2 hours

Application

Airless Spray	
Recommended thinner	T 141
Volume of thinner	5 – 25% by volume
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 / Roller	
Thinner	T 141
Thinner Intake	5 - 15% by volume
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 off in accordance with appropriate regional legislation

Product Characteristics

- Full cure must be allowed prior to subjecting coating system to service conditions
- Due to exothermic reaction, temperature after the mixing may increase. This will affect the pot life. Please ensure the mixed quantity is used immediately
- The application parameters to be adjusted at site depending on line conditions
- In confined areas, relative humidity to be controlled by using de-humidification unit
- For system recommendation or any specific query, please consult Asian Paints PPG technical representative

PACK SIZE	20 ltrs (Base : 16.67 ltrs & Hardener : 3.33 ltr)
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 25°C Hardener : Not less than 25°C VOC: Approx. 320 gm/ ltr as per USA-EPA Method 24 Product Weight: Approx 1.59 kg/ ltr

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapour 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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