

# ASIAN EPOXY DUAL COAT

Epoxy Surface Tolerant Primer

## PRODUCT DESCRIPTION

Two component high build, epoxy zinc phosphate primer with surface tolerant property.

## FEATURES AND RECOMMENDED USE

- Designed as a high performance primer for new construction and maintenance in coastal & industrial polluted environments
- Self priming, all-in-one primer cum top coat
- Can be applied on marginally prepared surfaces; tolerant to lower grades of steel preparation
- Good adhesion to ferrous as well as on non ferrous substrates like aluminium, galvanised & stainless steel
- Good inter coat compatibility over aged and sound conventional, epoxy & polyurethane paint
- Can be over coated with conventional coatings and most two component paints
- Good corrosion & chemical resistance

## TECHNICAL DATA

Colour	Light Grey
Gloss	Eggshell
Volume Solids	Approx. 60%
Recommended DFT / Coat	50 - 100 microns
Theoretical Coverage Capacity	12.0 Sq.mtr/ l @ 50 microns DFT 6.0 Sq.mtr/ l @ 100 microns DFT
Drying Time	Surface Dry : 5 hours Hard Dry : 16 hours Full Cure : 7 days
Over coating interval	Min. : 16 hours Max. : Unlimited, provided surface is cleaned from all contamination
Method of Application	Brush, Air spray & Airless spray

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

#### For immersion condition:

- Steel, blast cleaned to Sa 2.5 of Swedish specification

### For atmospheric exposure condition:

- New hot-rolled steel; blast cleaned to minimum Sa 2 of Swedish specification
- Weathered steel; power tool cleaned to St 3 or handtool cleaned to St 2
- Existing sound epoxy coating system and sound alkyd coatings; sufficiently roughened prior to painting  
High pressure fresh water washing or scrubbing to remove loose paint and contamination. Intact areas to be roughened. Damaged and rusty areas to be derusted to minimum St 3/ St 2 by powertool/ handtool cleaning

### For Non Ferrous substrate:

- Sufficiently roughened the surface with emery paper
- Ensure surface is free from oil, grease, oxides & other contaminations

### 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

- Asian Epoxy Dual Coat 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 for quick homogeneous 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

<b>Mixing Ratio (by volume)</b>	Base : Hardener 3 : 1
<b>Induction Time</b>	15 minutes
<b>Pot Life at 30°C</b>	3 hours

### Application

<b>Brush / Roller</b>	
Recommended thinner	T 131
Volume of thinner	0 - 10 %
<b>Air Spray</b>	
Recommended thinner	T 131
Volume of thinner	5 - 20 %
Nozzle orifice	1.5 - 3.00 mm
Nozzle pressure	0.3 - 0.4 MPa (= approx. 3-4 atm; 43-57 p.s.i)
<b>Airless Spray</b>	
Recommended thinner	T - 131
Volume of thinner	5 - 20 %
Nozzle orifice	0.41 - 0.48 mm
Nozzle pressure	20 -24 MPa (= approx. 200-240 atm; 2800-3400 p.s.i)

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 131. 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

- A typical DFT of 50-75 microns/ coat can be achieved by brush application
- Maximum film build up is best achieved by airless spray. Application by air spray or brush may require multiple coats to attain maximum film build
- As common with all epoxies, Asian Epoxy Dual Coat 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
- For requirement of durable cosmetic finish with good gloss and colour retention, overcoat with recommended durable topcoats
- Condensation occurring during or immediately after application may result in a matt finish and an inferior film
- Not recommended for immersion services in acids, alkalies & solvents
- A minimum of two coats application is recommended over prepared steel for optimum performance

## Overcoating and Topcoats

- Asian Epoxy Dual Coat can be top-coated with itself and with most conventional/ two component paints
- For suitable topcoats, consult Asian Paints PPG representative

<b>PACK SIZE</b>	4 ltrs (Base : 3 ltrs & Hardener : 1 ltrs) 10 ltrs (Base : 7.5 ltrs & Hardener : 2.5 ltrs)
<b>STORAGE</b>	<b>Shelf Life:</b> 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
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base - Not less than 24°C; Hardner - Not less than 24°C <b>VOC:</b> 360 gm/ ltr as per USA-EPA Method 24 <b>Product Weight:</b> 1.22 kg/ ltr

## 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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