

APCODUR HB RR COATING

Epoxy

PRODUCT DESCRIPTION

Two component high build, rapid recoat, anti-corrosive epoxy primer

FEATURES AND RECOMMENDED USE

- Designed as a high performance coating for corrosive environments
- Available in zinc phosphate & micaceous iron oxide pigmented versions
- Faster drying properties with minimal overcoating interval
- Excellent mechanical properties
- Can be top coated with conventional coatings and most two component paints

TECHNICAL DATA

Colour	Greys & Limited shades
Gloss	Satin to Semiglossy
Volume Solids	Approx. 80%
Recommended DFT / Coat	100 - 200 microns
Theoretical Coverage Capacity	8.0 sq.mtr/ ltr @ 100 microns 4.0 sq.mtr/ ltr @ 200 microns
Drying time @ 30 °C (by Spray application)	Surface Dry : 90 minutes Hard Dry : 4 hours Full Cure : 7 days
Overcoating interval	Min. : 4 hours Max. : 1 month, provided surface is dry and clean from all contamination
Method of Application	Brush, Air spray & Airless spray

- The data given is for guideline only. The physical values are subjected to normal manufacturing tolerances, colour and testing variances
- The volume solids indicated are as per ASTM D 2697 air drying method.
- Above mentioned product characteristics are for testing parameters at 30°C and 65% relative humidity temperature etc. The information provided above is at 30° C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General:

- Steel; blast cleaned to min Sa 2.5 of Swedish specification
- 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

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 ZP 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 too much thinner may lead to reduced sag resistance.

Mixing Ratio (by volume)	Base : Hardener 4 : 1
Induction Time	15 minutes
Pot Life at 30°C	1 hours

Application

Brush / Roller	
Recommended thinner	: T 141
Volume of thinner	: 0 - 10 %
Air Spray	
Recommended thinner	: T 141
Volume of thinner	: 5 - 25 %
Nozzle Orifice	: 1.5 - 3.00 mm
Nozzle Pressure	: 0.3- 0.4 MPa (= approx 3-4 atm; 43-57 p.s.i.)
Airless Spray	
Recommended thinner	: T 141
Volume of thinner	: 5 - 20 %
Nozzle orifice	: 0.53 - 0.66 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 141. It is recommended to flush out spray equipment periodically 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. By air spray, a multiple cross spray pattern application may be required for higher film build.
- As common with all epoxies APCODUR RR ZP Coating may lead to chalking & discoloration on exterior exposure. However, these phenomena are not detrimental to anti-corr sive performance. The actual rate of chalking depends upon climatic conditions and normally limits to a thin surface layer.
- For requirement of durable cosmetic finish with good gloss and colour retention, overcoat with recommended durable topcoats like PU.
- Condensation occurring during or immediately after application may result in a matt finish and an inferior film.
- Premature exposure to ponding water leads to colour change, especially in dark colours.

Overcoating and Topcoats

- Apcodur RR ZP Coating is made to apply directly on the blasted MS substrate.
- Apcodur RR ZP Coating can be top-coated with itself and with most conventional / two component paints. For suitable topcoats consult Asian Paints PPG representative.

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:	190 - 230 gm/ ltr (depending on shades) as per USA-EPA Method 24
	Product Weight:	14.0 – 15.2 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 use of 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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