

CODE: EP-202

PRODUCT NAME:

Polyamide Cured Epoxy Primer

DESCRIPTION:

EP-202 is a Two component polyamide cured epoxy primer which has excellent adhesion and anti-corrosive property as well as excellent resistance to water, chemicals and salt solutions for immersion and non-immersion services, interiors of cargo holds and tanks , and ballast tanks , structural steel machinery, pipes and tanks exterior in paper mills , oil refineries , power plants , chemical process and waste treatment plants as well as decks , hulls and superstructures of ships , barges and workboats, offshore platforms and related structures.

TECHNICAL DATA:

Binder	Epoxy resin
Pigment	Red Iron Oxide & M.I.O
Finish	Flat
shade	Red brown
Specific gravity after mixing	1.4±0.1 Kg/Lit
Volume solid	60 ± 3%
Flash point	26°C
Typical dry film thickness	50-80 Microns per one coat
Number of coats	One
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Blasted steel
Application method	Conventional or airless spray , brush , roller
Thinner/ Cleaner	T-200
Weight of added thinner	10-15%
Induction time at <25 °C	20-30 minutes
Theoretical spreading rate (at 80 microns)	7.5 M ² /Lit
Packing	Base : 25 kg Hardener : 4 kg
Shelf life	12 Months

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Approved b



Drying Time

Temp	Touch dry	Hard dry	Overcoating		Full cure
			Min	Max	
15°C	3 hours	22 hours	20 hours	-	12 days
25°C	2 hours	18 hours	15 hours	-	7 days
40°C	90 minutes	14 hours	8 hours	-	3 days

Note: Drying times are dependent on applied film thickness; all data in this catalogue are reported at recommended DFT.

Pot life

Temp. of paint	15°C	25°C	40°C
Pot life	9 hours	7 hours	4 hours

Surface Preparation

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO8504:1992.

Where necessary, remove weld spatter, and where required smooth Seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning

Abrasive Blast Cleaning

Abrasive blast clean to Sa2 ½(ISO 8501-1:1988) or SSPC-SP10. If oxidation has occurred between blasting and application of EP-202, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

A surface profile of 35-50 microns is recommended.

Shop primed Steelwork

EP-202 is suitable for application to steelwork freshly coated with zinc silicate shop primers.

If the shop primer show extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

Weld seams and damaged areas should be cleaned to Sa2 ½(ISO 8501-1:1988) or SSPC-SP10.

-Surface preparation shall not take place in following conditions:

A) At temperature below 5 °C.

B) When the relative humidity greater than 85%.

C) When the metal surface temperature is less than 3 °C above the dew point

D) Out side day light hours on exterior locations.

-Apply EP-202 as soon as possible after surface preparation to prevent rusting.

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Application Method

Material is supplied in two containers as a unit. Always mix a complete unit in the proportion supplied. Once the unit has been mixed it must be used within the working Pot life specified.

1-Agitate part A with a power agitator.

2-Combined entire contents of curing agent (part B) With Base (Part A) and mix thoroughly with power agitator.

(Stir during application to maintain uniformity of material.)

Application Equipments

Air less Spray	Tip range 0.015-0.021inch tip not less than 176 Bar (2500 phi)	Total output pressure at spray
Air Spray	Nozzle Orifice:1.8-2.2mm Nozzle Pressure:3-5 Bar (43-72 psi)	
Brush	Typically 50 mic can be achieved.	
Roller	Typically 50 mic can be achieved.	

Flush Equipment with recommended Cleaner before and after use.

ENVIRONMENTAL CONDITIONS:

- To prevent moisture condensation during application, surface temperature must be at least 3 °C above the dew point.
- Never apply coatings under reverse environmental condition.
- In hot climate, material temperature should be 20 to 25 °C prior to mixing; otherwise pot life becomes very short.
- For satisfactory cure, air and surface temperature must be above 10 °C
- Paint shall not be applied when wind speed is in excess of 7 m/s

Air temperature	10 to 40 °C
Surface temperature	10 to 50 °C
Material temperature	10 to 30 °C
Relative humidity	Max 80 %

Health and Safety:

This product is Flammable. Keep away from heat and open flame .Keep container closed .Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

- 1-Circulate adequate fresh air continuously during application and drying.
- 2-Use fresh air masks and explosion proof equipment.
- 3- Prohibit all flames, sparks, welding and smoking.

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