

**CODE :EP-208-HB**

**PRODUCT NAME:**

**Polyamide Cured Coal Tar Epoxy Coating.**

**DESCRIPTION :**

EP-208-HB is a two component coal tar epoxy coating which displays excellent corrosion and chemical resistance for tank lining, immersion and non-immersion service in crude oil, salt solutions and fresh or sea water with just a single coat.

EP-208-HB is industrial lining and coating for use varying from cold to hot climates on marine structures, pilling, ballast tanks, crude oil cargo, ships bottoms, burned pipes, oil production and refining plants, sewage treatment plants.

EP-208-HB is suitable for use over both steel and concrete. It normally does not require a primer or any additional topcoats but also can be applied over inorganic zinc silicate primer to serve as a tie coat between primer and topcoat.

**TECHNICAL DATA:**

Binder	Coal tar Epoxy resin
Pigment	Suitable pigments(M.I.O&Iron oxide) and extenders
Finish(ASTM D -523)(60°)	flat (<25)
Shade (RAL)	Black , Brown
Specific gravity after mixing	1.4± 0.1 Kg/Lit
Volume solids(ASTM D -2697)	77±3 %
Flash point(ISO 3679)	27 °C
Typical dry film thickness	100-200 Microns per one coat
Number of coat	One or Two
Mixing ratio by weight	Base : 100 parts Hardener : 16parts
Substrate	Blasted or primed steel or concrete
Application method	Conventional or airless spray , brush , roller
Thinner / Cleaner	T-200
Weight of added thinner	5-15 %
Induction Time at <25 °C	Maximum 10 minutes
Theoretical spreading rate (at 100 microns)	7.7 M <sup>2</sup> /Lit
Packing	Base : 25 Kg Hardener : 4 Kg
Shelf life*	Base: 12 Months Hardener: 12 Months

**\*Note:** It is dependent on storage temperature and reduces at storage temperature above 20° C. Do not store above 40 °C. Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.

## Drying Time

Temp	Touch dry	Hard dry	Over coating		Full cure
			Min	Max	
15°C	(ISO 12 hours 1517)	80-100 hours	72 hours	7days	13 days
25°C	6 hours (ISO 9117)	48-60 hours	48 hours	5days	7 days
40°C	4 hours	36-48 hours	36 hours	3days	4 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	6 hours	4 hours	2 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 ISO 8504:1992.

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

### Abrasive Blast Cleaning

For immersion service, EP-208-HB must be applied to surfaces blast cleaned to a minimum of Sa2½ (ISO 8501-1:1988) or SSPC-SP10. However, for atmospheric exposure EP-208-HB may be applied to surfaces prepared to a minimum of SA 2 (ISO 8501-1:1988) or SSPC-SP6.

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

A surface profile of 60-75 microns is recommended.



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### Primed surfaces

EP-208-HB can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination, and EP-208-HB must be applied within the overcoating intervals specified.

Area of breakdown, damage, etc., should be prepared to the specified standard (eg.SA2½ (ISO 8501-1:1998), or SSPC-SP10, abrasive blasting, or SSPC-SP3, (hand/ power cleaning) and patch primed prior to the application of EP-208-HB.

### Concrete Surfaces

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry. -Surface preparation shall not take place in following conditions:

- 1 -At temperature below 5 °C.
- 2 -When the relative humidity greater than 85%.
- 3 -When the metal surface temperature is less than 3 °C above the dew point.
- 4 - Outside day light hours on exterior locations

### 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.

### Application Equipments

Air less Spray	Tip range 0.021-0.023 inch Total output pressure at spray tip not less than 200 Bar (2900 psi)
Air Spray	Nozzle orifice 1.8-2.2mm Nozzle pressure: 3-5 Bar (43-72 psi )
Brush	Typically 50-70 mic can be achieved.
Roller	Typically 50-70 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.