

CODE: EP-240

PRODUCT NAME:

Polyamine Cured Epoxy Tie coat

DESCRIPTION:

EP-240 is a two component high performance tie coat compatible with inorganic zinc silicate primers on primed steel structures, machinery , piping in chemical plants, pulp and paper mills , refineries , power and chemical plants , decks, hulls , bottoms , offshore platforms , interior and exteriors of tanks and other structures exposed to sever weathering or salt spray.

EP-240 forms an excellent corrosion barrier and is suitable for most industrial and marine new construction, repair and field maintenance application, where an epoxy coating is required in low temperature conditions.

EP-240 is user friendly and can be applied also as topcoat by a variety of spray application methods over a broad temperature range.

Topcoats required where glossy finish and improved colour retention is desired.

TECHNICAL DATA:

Binder	Epoxy resin
Pigment	Chemical resistant pigment& M.I.O
Finish	Flat
Shade	White,Grey,Red,Brown,
Specific gravity after mixing	1.4±0.1 Kg/Lit
Volume solid	70±3 %
Flash point	22 °C
Typical dry film thickness	100-150 Microns
Number of coat	One or two
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Primed steel
Application method	Airless spray , brush
Thinner / Cleaner	T-200
Weight of added thinner	5- 7 %
Induction Time at <25 °c	Not applicable
Theoretical spreading rate - one coat (at 100 microns)	7 M ² /Lit
Packing	Base : 25 kg Hardener : 4 kg
Shelf life	12 Months

Drying Time

Temp	Touch dry	Hard dry	Overcoating		Full cure
			Min	Max	
15°C	6 hours	30 hours	24 hours	Not limited	12 days
25°C	4 hours	24 hours	18 hours	Not limited	7 days
40°C	2½ hours	15 hours	12 hours	Not limited	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	120 minute	90 minute	60 minute

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.

Primed Surfaces

EP-240 should always be applied over a recommended anti-corrosive coating scheme.

The primer surface should be dry and free from all contamination, and EP-240 must be applied within the overcoating intervals specified.

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. sa2½ (ISO 8501 -1:1988) or SSPC-SP10, Abrasive, or SSPC-SP11, power tool cleaning) and patch primed prior to the application of EP-240.

Concrete, precast blockwork etc

EP-240 is suitable for application to concrete. For the first coat it is recommended that EP-240 is thinned 10-12% by T-200 in order to provide good penetration into the concrete substrate and act as primer/ sealer coat.

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 and free from curing compounds, release agents, trowelling compounds, surface hardener, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitance.

Surface preparation shall not take place in the 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) Outside day light hours on exterior locations.

EP-240/2

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 0.017-0.021 inch Total output pressure at spray tip not less than 141 Bar (2000 psi)
Air Spray	Not Recommended
Brush	Typically 60-70 mic can be achieved.
Roller	Not Recommended

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.