

CODE :EP-241

**PRODUCT NAME:**

**Polyamide Cured Epoxy Tie Coat**

**DESCRIPTION:**

EP-241 is a two component superior polyamide cured epoxy sealer coating for porous substrates which forms durable coating systems with a wide range of topcoats for immersion and non-immersion services. It is suitable for a variety of substrates.

EP-241 is recommended for zinc silicate primed structural steel, machinery, pipes and tanks exterior in paper mills, oil refineries, power plants, chemical process and waste treatment plants. It is also suitable for decks, hulls and superstructures of ships, barges and workboats, offshore platforms and related structures, interiors of cargo holds and tanks, and ballast tanks. With the proper topcoat, EP-241 withstands splash or spillage of water, solvents, chemicals and petroleum products, but also immersion in fresh water or sea water salt solutions and sour crude. Suitable topcoats are epoxies, coal tar epoxies, acrylics, and polyurethane coatings.

**TECHNICAL DATA:**

Binder	Epoxy resin
Pigment	Suitable pigments and extenders
Finish	Flat ( ASTM D 523)
Shade	Red - grey- green - light grey
Specific gravity after mixing	1.3 ± 0.1 Kg/Lit (ASTM D 1475)
Volume solid	52 ± 3 % ( ASTM D 2697)
Flash point	28 °C
Typical dry film thickness	20-40 microns per one coat ( ASTM D 1186)
Number of coat	One
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Primed steel, Aluminum and galvanized
Application method	Conventional or airless spray , brush , roller ( FED.ST 141(method4331))
Thinner / Cleaner	T-200
Weight of added thinner	5-10 %
Induction Time at <25 °C	20-30 minutes
Theoretical spreading rate ( at 30 microns)	17.3 M <sup>2</sup> /Lit ( ASTM D 344)
Packing	Base : 25 kg (EP-241) Hardener : 4 kg (EP-241H)
Shelf life	Base :12 Months Hardener :12 Months

## Drying Time (ASTM D 1640)

Touch dry	Hard dry	Overcoating		Full cure
		Min	Max	
60-90 minutes	6-10 hours	6-10 hours	30 days	7 days

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

Above Specification Is Based On Mixture Of The Two Components.

(23 ± 3 °C And , 30 ± 5 % RH.)

## Pot life (ASTM D 1849)

Temp. of paint	15°C	25°C	40°C
Pot life	9-12 hours	6-8 hours	2-3 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.

### Primed Surfaces

EP-241 should always be applied over a recommended anti-corrosive coating scheme.

The primer surface should be dry and free from all contamination, and EP-241 must be applied within the overcoating intervals specified.

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g.sa2 ½(ISO 8501 - 1:1988) or SSPC-SP10, Abrasive, or SSPS-SP11, power tool cleaning) and patch primed prior to the application of EP-241.

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

## Application Method

This 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 0.019-0.021 inch Total output pressure at spray tip not less than 141 Bar (2000 psi)
Air Spray	Nozzle orifice 1.8-2mm Nozzle pressure: 2-4 Bar (29-58psi )
Brush	Typically 20-30 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.