

CODE :EP-254

PRODUCT NAME:

Heavy Duty, Chemical Resistance Epoxy Tank Lining

DESCRIPTION :

EP-254 is a two component 100 percent solid content epoxy coating with excellent barrier properties that can be applied to steel tank internals to provide corrosion protection to the internals steel storage tanks contain a range of products, including crude oil, unleaded gasoline blends, MTBE, aviation fuel, and a selected range of aromatic and aliphatic solvents.

TECHNICAL DATA:

Binder	Epoxy resin
Pigment	Chemical Resistance Pigments
Finish	Gloss
Shade	White and dark grey
Specific gravity after mixing	1.4± 0.1 Kg/Lit
Volume solid	98-100%
Flash point	100 °C
Typical dry film thickness	300-600 mic for general purpose
	400-1000 mic for tank floor
	1250-1400 mic when used as a laminate with fiber glass.
Number of coat	One or two
Mixing ratio by weight	Base : 100parts Hardener : 39parts
Substrate	Blasted or primed steel or concrete
Application Method	Airless ,Roller or brush
Thinner / Cleaner	Not Suitable (Cleaner: T-C-200)
Theoretical spreading rate At(500) microns	2M ² /Lit
Packing	Base : 18 kg Hardener :7 kg
Shelf life	12 Months

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Drying Time

Temp	Touch dry	Hard dry	Overcoating		Full cure
			Min	Max	
15°C	10hours	38 hours	24 hours	--	14 days
25°C	6 hours	26 hours	10 hours	--	7 days
40°C	3 hours	17 hours	7 hours	-	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	90 minutes	50 minutes	30 minutes

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

This product must only be applied to surfaces prepared by abrasive blast cleaning to SA 2 ½ (ISO8501:1988) or SSPC-SP10.

A sharp, angular surface profile of 70-100 microns is recommended.

EP-254 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized areas should be reblasted to the standard specified above.

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

Surfaces may be primed with EP-200 or EP-301 to 30-40 microns (D.F.T) before oxidation occurs. Alternatively the blast standard can be maintained by use of dehumidification.

EP-200 can hold a blast for up to 28 days in the semi-protected environment of a tank interior. If moisture is present on the surface, oxidation will occur and reblasting will be required.

Surface preparation shall not take place in the following conditions:

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

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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 0.034 - 0.036 inch Total output pressure at spray tip not less than 211 Bar (3000 psi)
Air Spray	NOT RECOMMENDED
Brush	Typically 150-250 mic can be achieved.
Roller	Typically 150-250 mic can be achieved.

Flush Equipment with recommended Cleaner before and after us

ENVIRONMENTAL CONDITIONS:

- To prevent moisture condensation during application, surface temperature must be at least 3 °C above 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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