

CODE: EP-264

PRODUCT NAME:

Polyamide Cured Coal Tar Epoxy

DESCRIPTION:

EP-264 is a multi purpose high performance economical topcoat in industrial atmospheres with excellent mechanical properties and durability in both marine and industrial environments for maintenance works, metal surfaces and concrete.

This paint with suitable primer gives excellent adhesion and anti-corrosive film to long term protect steel structures permanently or partly submerged in water , inside crud oil tanks , buried concrete structures etc.

TECHNICAL DATA:

Binder	Epoxy- tar resin
Pigment	Suitable Pigments
Finish	Semi flat
Shade	Black, Brown
Specific gravity after mixing	1.3±0.1 Kg/Lit
Volume solid	60 ±2%
Flash point	26 °C
Typical dry film thickness	100-125 Microns
Number of coat	One or Two
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Primed steel or concrete
Application Method	Airless or Air spray, Roller, Brush
Thinner /Cleaner	T-200
Weight of added thinner	15-20 %
Induction Time	15-20 minutes
Theoretical spreading rate (at 100 microns)	6 M ² /Lit
Packing	Base : 25 kg Hardener : 4 kg
Shelf life	12 Months

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Drying Time

Temp	Touch dry	Hard dry	Overcoating		Full cure
			Min	Max	
15°C	7 hours	26 hours	24 hours	-	14 days
25°C	4 hours	18 hours	18 hours	-	8 days
40°C	2 hours	12 hours	16 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	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 ISO 8504:1992. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning

Abrasive Blast Cleaning

For immersion service, EP-264 must be applied to surfaces blast cleaned to a minimum of Sa2½ (ISO 8501-1:1988) or SSPC-SP10. However, for atmospheric exposure EP-264 may be applied to surfaces prepared to a minimum of SA 2 ½ (ISO8501-1:1998) 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.

Primed surfaces

EP-264 can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination, and EP-264 must be applied within the overcoating intervals specified.

Area of breakdown, damage, etc., should be prepared to the specified standard (eg. Sa 2 ½ (ISO 8501-1:1998), or SSPC-SP6, abrasive blasting, or SSPC-SP11, (hand/ power cleaning) and patch primed prior to the application of EP-264.

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 and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also sweep blasted (preferred) or acid etched to remove laitance. Apply a first coat of EP-208; thinned 15% with T-200 at approximate 100 mic dry film thickness to ensure good penetration.

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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

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 spray tip not less than 141 Bar (2000 psi)	Total output pressure at
Air Spray	Nozzle orifice 1.8-2mm Nozzle pressure: 3-5 Bar (43-72 psi)	
Brush	Typically 40-60 mic can be achieved.	
Roller	Typically 40-60 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 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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