

**CODE: EP-272**

**PRODUCT NAME: Two Component High Build Epoxy Phenolic primer**

**DESCRIPTION:**

EP-272 is a two component high build epoxy phenolic primer coat in the tank coating system with excellent resistance to a wide range of organic acids, alcohols, edible oils, fats (free fatty acids) and solvents.

It has a good resistance to hot water and corrosive environments.

**TECHNICAL DATA:**

Binder	Modified phenolic resin
Finish	Flat
Shade	Grey, White, Green, Pink
Specific gravity after mixing	1.4 ± 0.1 Kg/Lit
Volume solids	60 ± 2 %
Flash point	26°C
Typical dry film thickness (Per one coat )	100-150 Microns
Number of coat	One
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Cleaned steel, Stainless steel, galvanized or Aluminum
Application Method	Airless spray and brush
Thinner / Cleaner	T-272
Weight of added thinner	5-8%
Induction Time	15 minutes
Theoretical spreading rate ( at 100 microns)	6 M <sup>2</sup> /Lit
Temperature resistance	Up to 160°C
Packing	Base : 25 kg Hardener : 4 kg
Shelf life	Base: 12 Months Hardener: 12 Months

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Approved b



## Drying Time

Temp	Touch dry	Hard dry	Overcoating		Full cure
			Min	Max	
15°C	7 hours	30 hours	40 hours	45 days	14 days
25°C	4 hours	20 hours	30 hours	30 days	7 days
40°C	2 hours	12 hours	24 hours	14 days	5 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	7 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.

Where necessary, remove weld spatter, and where required smooth Seams and sharp edges. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning

### Abrasive Blast Cleaning

Abrasive blast clean to SA 2 ½ (ISO 8501-1:1988) or SSPC-SP10. If oxidation has occurred between blasting and application of EP-272, the surface should be reblasted to the specified visual standard.

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

A surface profile of 35-50 microns is recommended.

Weld seams and damaged areas should be cleaned to Sa 2½ (ISO 8501-1:1988) or SSPC-SP10.

Surface preparation shall not take place in 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 dew point.

D- Out side day light hours on exterior locations.

- Apply EP-272 is soon as possible after surface preparation to prevent rusting.

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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.

### Application Equipments

Air less Spray	Tip range 0.019-0.021inch pressure at spray tip not less than 176Bar (2500 psi)	Total output
Air Spray		NOT RECOMMENDED
Brush		Typically 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.

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