

## INTRODUCTION

Marine paints are the derivative of Epoxite conjunctions with Amine Adducts, Poly amide, Polyamines etc. They provide air drying, salt water Resistant Finish and anti-Corrosive coating, it also give anti-fungal properties

## SCOPE

The product possesses good flexibility, adhesion and salt water resistance. Marine Paint can safely be used for ,ship ,water boats ,costal structure ,internal lining of ATF & Other light petroleum product tanks.etc

## PRODUCT DATA

Type	: Two Pack cured with Polyamide
Composition	: Suitable pigmented catalyzed epoxy resin
Mixing Ratio	: Base:Cataylst:3:1 by volume
Pot Life	: 4 to 6 hours
Application	: Brush, rollers, airless or conventional spray
Recommended DFT	: 40-50 microns per coat
Corresponding WFT	: 81-85 microns per coat
Theoretical Spreading Rate	: 5-6 sq.mtr/Ltr
Drying Time	: Touch 2-3hrs., Handle-6-8 hrs. Hard - Over Night
Curing Time	: 6-7 Days
Over coating Interval	: Min-Overnight / Max - 5 days
Flash Point	: Above 22°C
Colour	: As per Amex / RAL Shade Card
Solubility	: Soluble in high boiled aromatic solvent
Specific Gravity at 25°C	: 1.12
Softening Point	: 175°C
Solid Contents	: 55% to 65%
Hardness Test	: After 72 hrs
Distensibility (Ericlisem)	: 8 m.m.
Freezing Point	: 2°C

Effect on skin	: Nil
Packing	: 20 Ltrs. (15+5)
Thinner/Cleaner	: Marine Thinner/Cleaner
Finish	: Glossy/Matt

#### STORAGE LIFE

Upto 12 months as long as the sealed containers are kept under cover in a dry place under normal temperature conditions

#### USES

Recommended as a Primer/Paint/Clear for Steel structure exposed to salt water ,sea ,chemical and industrial environment in fertilizers, refineries, petrochemicals, paper and pulp, food and pharmaceutical units.

#### RESISTANCE GUIDE

### Chemical Resistance

Exposures	Splash and Spillage	Mild Fumes/Outdoor Resistance
Acids	Fair	Very Good
Alkalis	Good	Very Good
Solvents	Good	Very Good
Salt	v.Good	Very Good
Water	v.Good	Excellent

### TEMPERATURE RESISTANCE

Continous : 170°C  
Intermittent : 270°C

### WEATHERBILITY

Very Good in combination with Marine Primer

### FLEXIBILITY

Very Good

### ABRASION RESISTANCE

Very Good

### SURFACE PREPARATION

STEEL: Remove grease, oil and other contaminants by using Amex 3 in 1 chemical or Sand Blast a minimum of Sa 2.5 Swedish Standard SIS 05 5900 with surface profile not exceeding 65 microns. If blasting is not practical, remove loose rust and dirt by manual chipping and wire brushing scale to St-2 Swedish standard SIS 05 5900. Don't Polish the steel excessively. To obtain best result treat the manually cleaned surface with Amex Metal Conditioning Sol. Apply Marine Primer only on a clean and dry surface.

### APPLICATION

Stir the base thoroughly, Mix 3 parts of base and 1 part of catalyst by volume to uniform consistency. Let the mixture mature for 30 minutes. Stir it again before and during application.

- Brush / Roller : Apply without thinning. If required during application add maximum upto 5% Marine thinner
- Conventional Spray : Depending on conditions dilute by adding 10% Marine Thinner. Use any standard equipment at an atomising pressure of 3.5 - 4.2 kg/cm<sup>2</sup>.
- Airless Spray : Preferable apply without thinning. If conditions dilute by adding 10% Marine Thinner. Use any standard equipment at an atomising pressure of 3.5 - 4.2 kg/cm<sup>2</sup>
- Tip Size : 0.33 - 0.38 mm, Tip Pressure - 110 - 140 Kg/cm<sup>2</sup>

TYPICAL PAINTING SPECIFICATIONS				
Surface	1st Coat	2nd Coat	3rd Coat	4th Coat
Steel	Marine Primer/Marine Zinc Rich Primer	Marine Primer	Marine Paint	Marine Paint
Galvanized Iron & Aluminums	Degrease and Scrape off the surface. Apply High Build Marine Primer followed by Top Coat of Marine Paint			

- NOTES**
1. The mixed paint should be used within the stipulated pot life period.
  2. Don't apply when temperature falls below 10°C or rises above 50°C and when relative humidity rises above 90%
  3. . Do not apply during rain, fog or mist.
  4. To avoid any undue damage to the Paint and Spray equipment's clean them with thinner.
  5. No Inflammable activity should be carried out when application is under process.

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