

INTRODUCTION

Epoxy paints are the derivative of Epoxide conjunction with Amine Adducts, Poly amide, Polyamines etc. They provide air drying, Chemical Resistant Finish and anti-Corrosive coating

SCOPE

The product possesses good flexibility, adhesion and oil resistance. Epoxy Paint can safely be used for internal lining of ATF & Other light petroleum product tanks.

PRODUCT DATA

Type	: Two Pack cured with Polyamide
Composition	: Suitable pigmented catalyzed epoxy resin
Mixing Ratio	: Base:Catalyst:3:1 by volume
Pot Life	: 4 to 6 hours
Application	: Brush, rollers, airless or conventional spray
Recommended DFT	: 25-35 microns per coat
Corresponding WFT	: 61-85 microns per coat
Theoretical Spreading Rate	: 9-11sq.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	: 1.01
Softening Point	: 175°C
Solid Contents	: 45% to 55%
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	: Epoxy 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 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	Good	Very Good
Water	Good	Excellent

TEMPERATURE RESISTANCE

Continous : 170°C
Intermittent : 270°C

WEATHERBILITY

Very Good in combination with Epoxy 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 Epoxy 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% Epoxy thinner
- Conventional Spray** : Depending on conditions dilute by adding 10% Epoxy Thinner. Use any standard equipment at an atomising pressure of 3.5 - 4.2 kg/cm².
- Airless Spray** : Preferable apply without thinning. If conditions dilute by adding 10% Epoxy Thinner. Use any standard equipment at an atomising pressure of 3.5 - 4.2 kg/cm²
- Tip Size** : 0.33 - 0.38 mm, Tip Pressure - 110 - 140 Kg/cm²

TYPICAL PAINTING SPECIFICATIONS

Surface	1st Coat	2nd Coat	3rd Coat	4th Coat
Steel	Epoxy Primer/Epoxy Zinc Rich Primer	Epoxy Primer	Epoxy Paint	Epoxy Paint
Galvanised Iron & Aluminium	Degrease and Scrape off the surface. Apply High Build Epoxy Primer followed by Top Coat of Epoxy 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%. Do not apply during rain, fog or mist.
3. To avoid any undue damage to the Paint and Spray equipments clean them with thinner.
4. No Inflammable activity should be carried out when application is under process.

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