

# APCODUR CF 655



## PRODUCT DESCRIPTION

Two components, high build, high solid, polyamide cured coal tar epoxy coating

## FEATURES & RECOMMENDED USE

- Outstanding water and crude oil resistance
- Excellent corrosion resistance to continuous water immersion, marine exposure and subsoil conditions
- Good abrasion and chemical resistance
- Resistant to well-designed cathodic protection

## TECHNICAL DATA

Colour	Black
Gloss	Eggshell
Volume Solids	Approx. 80%
Recommended DFT / Coat	100 - 200 $\mu$ m
Theoretical Coverage Capacity	7.8 sq.mtr/ltr @ 100 $\mu$ m DFT 3.9 sq.mtr/ltr @ 200 $\mu$ m DFT
Drying time at 30°C	Surface Dry : 5 hours Hard Dry : 24 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 24 hours Max. : 5 days, provided surface is dry and clean from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances  
The volume solids indicated are as per ASTM D 2697 air drying method  
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.  
The information provided above is at 30°C and 65% relative humidity

## DIRECTIONS FOR USE

### Surface Preparation

#### General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

#### For immersion condition

#### Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of Apcodur CF 655, the surface should be re-blasted
- A blasting profile of (Rz) 50-75  $\mu$ m is recommended

### For atmospheric exposure condition

- Steel; blast cleaned to Sa 2.5 of Swedish specification
- If blast cleaning is impractical, remove loose rust/ scale using power tools/ hand tools to achieve St3/St2 grade of surface preparation as per Swedish standards
- Suitable zinc primer, epoxy primer or epoxy intermediate coat; dry & free from all surface contamination. In case of aged epoxy coating, the surface should be sufficiently roughened and cleaned prior to painting

### Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

### Mixing

- Apcodur CF 655 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance

<b>Mixing Ratio (by volume)</b>	Base : Hardener 5 : 1
<b>Induction Time</b>	None
<b>Pot Life at 30°C</b>	4 hours

### Application

<b>Airless Spray</b>	
Recommended thinner	T 141
Volume of thinner	0 - 15% *
Nozzle orifice	0.53 - 0.66 mm (21 – 26 Thou)
Nozzle pressure	20 – 24 MPa (= approx. 200 – 240 atm; 2800 – 3400 p.s.i.)
Cleaning Thinner	T 141
<b>Brush</b>	
Recommended thinner	T 141
Volume of thinner	0 - 10% *

**\*Note:** Depending on recommended thickness & application condition

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

## Product Characteristics

- The maximum performance is achieved after complete curing
- While over coating with other paints, tar bleeding can occur. Consult Asian Paints PPG representative for suitable topcoats
- As common to all epoxy, Apcodur CF 655 will chalk and discolour on exterior exposure. However these phenomena are not detrimental to anti-corrosive performance

<b>PACK SIZE</b>	20 L (Base : 16.67 L & Hardener : 3.33 L)
<b>STORAGE</b>	<b>Shelf Life:</b> At least 12 months at 30°C for original unopened pack, subject to inspection thereafter Store in a cool, dry place and in accordance with local regulations
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base : Not less than 24°C Hardener : Not less than 24°C <b>VOC:</b> Approx. 225 ± 50 gm/ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.39 ± 0.07 kg/ltr (depending on shades)

## SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

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