

# APCOGUARD SF 720

## PRODUCT DESCRIPTION

Two component solvent free, high build epoxy coating

## FEATURES AND RECOMMENDED USE

- High performance solvent free tank lining for highly aggressive environment
- Excellent resistance to wide range of alcohols, crude oil, edible oils, fats and solvents
- Excellent water resistance
- Excellent abrasion and impact resistance
- Certified to overall migration standard as per 21 CFR 175-300 of US –FDA by CFTRI India in contact with potable water
- Very low VOC helps eliminating the fire risk when applied in the confined area

## TECHNICAL DATA

Colour	White& Light Grey(self-standard)
Gloss	Semi-glossy
Volume Solids	Approx. 100%
Recommended DFT / Coat	100 - 200 $\mu$ m
Theoretical Covering Capacity	10.0 sq.mtr/ltr @ 100 $\mu$ m DFT 5.00 sq.mtr/ltr @ 200 $\mu$ m DFT
Drying Time at 30°C	Surface dry : 4 hours Hard dry : 16 hours Full cure : 7 days
Over-coating interval at 30°C	Min.: 16hours Max.: 5 days, provided the surface is dry and cleaned 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

- To apply over suitable epoxy primer / epoxy intermediate
- In case of aged epoxy coating, the surface should be roughened and cleaned thoroughly prior to painting
- 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
- Where necessary remove weld spatter and smooth weld seams and sharp edges prior to application of primer

## Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of primer, the surface should be re-blasted
- A blasting profile of (Rz) 50-70 µm is recommended
- Any surface defect revealed by the blast cleaning process should be corrected or treated appropriately (grinding, filling etc.)

## Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be around 60 – 70%
- Good ventilation is required in confined areas to ensure proper curing

## Mixing

- Apcoguard SF 720 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
- If required, thinner should be added (up to 5%) after mixing the components. Addition of excessive thinner will lead to reduced sag resistance

<b>Mixing Ratio (By volume)</b>	Base : Hardener 3 : 1
<b>Induction Time</b>	Nil
<b>Pot Life at 30°C</b>	30 minutes

## Application

<b>Airless Spray</b> Nozzle orifice Nozzle pressure Recommended thinner	0.58 - 0.68 mm (23 - 27 Thou) 20 – 24MPa (approx. 200 – 240 atm; 2800 – 3400 p.s.i.) T - 141 <i>Note: For single feed airless spray it is advisable to use pump ratio 68:1</i>
<b>Brush / Roller</b> Cleaning Thinner	<i>Suggested only for stripe coating and small area applications</i> T 141

## 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

- Full cure must be allowed prior to subjecting coating system to service conditions
- Product will tend to discolour on exposure to sunlight. Discoloration may also be visible on immersion and submerged conditions without affecting the performance
- Due to exothermic reaction, temperature of mixed paint may increase affecting the pot life. Ensure required quantity is mixed which can be applied within the pot life
- The application parameters to be adjusted at site depending on line conditions
- The application by twin feed gun is recommended as pot life is very short. For smaller job and at low temperature, application with regular airless spray is possible
- In confined tank/areas, relative humidity to be controlled by using de-humidification unit
- For system recommendation or any specific query, please consult Asian Paints PPG technical representative

<b>PACK SIZE</b>	4 L (Base : 3 L & Hardener : 1 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 28°C Hardener : Not less than 28°C <b>VOC:</b> Approx. 40 gm/ ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.28 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

**Disclaimer:** To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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