

## EPOXY FINISH PAINT AA 56131



## PRODUCT DESCRIPTION

Two component polyamine adduct cured epoxy coating

## FEATURES AND RECOMMENDED USE

- Chemical Resistant finish in epoxy systems for steel exposed to atmospheric land and marine conditions
- Complies with AA 56131 standard of BHEL
- Good resistance to water & mild chemicals
- Easy application by brush and spray

## TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 44 %
Recommended DFT / Coat	30 - 40 $\mu\text{m}$
Theoretical Coverage Capacity	14.67sq.mtr/ ltr @ 30 $\mu\text{m}$ DFT 11.00sq.mtr/ ltr @ 40 $\mu\text{m}$ DFT
Drying Time at 30°C	Surface dry : 1 hour Hard dry : 12 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 12 hours Max. : 1 Month, 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
- Suitable epoxy primer or intermediate; dry and free from all surface contamination. In case of aged epoxy coating, the surface should be sufficiently roughened 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

- Product 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</b> (by volume)	Base : Hardener 4 : 1
<b>Induction Time</b>	15 minutes
<b>Pot Life at 30°C</b>	6 Hours

## Application

<b>Brush</b>	
Recommended thinner	T 141
Volume of thinner	0-5%
<b>Air Spray</b>	
Recommended thinner	T 141
Volume of thinner	5-10%
Nozzle Orifice	1.5 - 3.00 mm
Nozzle Pressure	0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 47 p.s.i.)
Cleaning Thinner	T 141
<b>Airless Spray</b>	
Recommended thinner	T 141
Volume of thinner	0-5%
Nozzle orifice	0.28 - 0.33 mm (11 – 13 Thou)
Nozzle pressure	10 - 13 MPa (= approx. 100 - 130 atm; 1400 - 1800 p.s.i.)
Cleaning Thinner	T 141

**Note :** As common to all epoxy, the product will chalks and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment 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 of in accordance with appropriate regional legislation

## Product Characteristic

- Maximum film build in one coat is best attained by airless spray. Air spray (pressure pot) may require a multiple cross spray pattern to achieve optimum film build
- The maximum performance is achieved after complete curing

<b>PACK SIZE</b>	20 L (Base : 16 L & Hardener : 4 L)
<b>STORAGE</b>	<b>Shelf Life:</b> Atleast 12 months @ 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. 475 ± 20 gm/ ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.18 ± 0.04kg/ 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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**Head Office:** Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, S.V. Road, Goregaon (W), Mumbai 400 062.

**Tel No:** 022-62182700, **CIN:** U24110MH2011PTC220557, **Email:** customercare.apppg@asianpaintsppg.com,

**Website:** www.asianpaintsppg.com