

ASIAN EPOXY HB FINISH / APCODUR 220



PRODUCT DESCRIPTION

A high build, two component epoxy finish

FEATURES AND RECOMMENDED USE

- Designed as an epoxy topcoat for marine and industrial environment
- Can be used as a coloured intermediate/ undercoat for high performance coating system
- Resistant to water and splashes of mild chemicals
- Excellent abrasion resistance
- Easy application by conventional/ airless spray and brush

TECHNICAL DATA

Colour	Range
Gloss	Satin
Volume Solids	Approx. 48%
Recommended DFT/ Coat	50 - 100 μ m
Theoretical Coverage Capacity	9.6 sq.mtr/ltr @ 50 μ m DFT 4.8 sq.mtr/ltr @ 100 μ m DFT
Drying Time at 30°C	Surface Dry : 2 hours Hard Dry : 16 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 16 hours Max. : 1 month, provided surface is dry and clean from all contamination
Method of Application	Brush, Air spray & Airless spray

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances.
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

Primed Surface

- Suitable zinc primer, epoxy primer or epoxy intermediate coat; dry and free from all surface contamination.
Asian Epoxy HB Finish / Apcodur 220 must be applied with the specified over - coating interval of the primer/ under – coat
- 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

- Asian Epoxy HB Finish / Apcodur 220 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 too much thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardner 3 : 1
Induction Time	15 minutes
Pot Life at 30°C	6 Hours

Application

Brush/ Roller	
Recommended thinner	T - 141
Volume of thinner	0 - 25% *
Air Spray	
Recommended thinner	T - 141
Volume of thinner	5 - 25% *
Nozzle orifice	1.5 - 3.00 mm
Nozzle pressure	0.3 - 0.4 MPa (= approx. 3-4 atm; 43-57 p.s.i)
Airless Spray	
Recommended thinner	T - 141
Volume of thinner	0 - 15% *
Nozzle orifice	0.41 - 0.46 mm
Nozzle pressure	16 - 20 MPa (= approx. 160 - 200 atm; 2300 - 2800 p.s.i)

**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 of in accordance with appropriate regional legislation

Product Characteristics

- Maximum film build in one coat is best attained by airless spray. When applying by air spray/ brush, it may be necessary to apply multiple coats to achieve the maximum specified dry film thickness
- For certain shades in red, yellow and orange, by brush application, 2 coats may be required to give complete hiding especially when applied over dark undercoats
- As common with all epoxies Asian Epoxy HB Finish / Apcodur 220 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti - corrosive performance. The actual rate of chalking will depend upon climatic conditions and will normally be limited to a thin surface layer
- For requirement of durable cosmetic finish with good gloss and colour retention, overcoat with recommended durable topcoats
- Condensation occurring during or immediately after application may result in a matt finish and an inferior film
- Premature exposure to ponding water will cause a colour change, especially in dark colours

Over-coating and Topcoats

- Asian Epoxy HB Finish / Apcodur 220 can be applied over an extremely wide range of priming systems. It is recommended over inorganic/ organic zinc primers and epoxy/ polyurethane primers and intermediates
- Asian Epoxy HB Finish / Apcodur 220 can be top-coated with itself and with most conventional/ two component paints
- For suitable primer/ topcoats consult Asian Paints PPG representative

PACK SIZE	20 L (Base: 15 L & Hardener: 5 L)
STORAGE	Shelf Life: 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
REGULATORY INFORMATION	Flash Point: Base - Not less than 24°C; Hardener - Not less than 24°C VOC: 440 - 475 gm/ ltr (depending on shades) as per USA - EPA Method 24 Product Weight: 12.4 – 13.6 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 is always recommended while 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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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