

PRODUCT DATA SHEET

Epoxy Primer/Finish

DESCRIPTION

Surface tolerant, two pack epoxy primer/finish offering corrosion protection in one coat. Suitable for properly prepared carbon steel, stainless steel, aluminium, galvanised steel and thermally sparyed zinc substrates.

PRINCIPAL CHARACTERISTICS

- Excellent durability in marine atmosphere.
- Resists splash, spillage and fumes of mild acids, alkalis, salts solutions and solvents
- Build coat or finish coat for the protection of steel and concrete in structure exposed to aggressive atmospheric condition.
- Accepts polyurethane or acrylic topcoats where improved gloss and colour retention are required.

RECOMMENDED USE

As an anticorrosive primer/finish for decks, deck fittings and cargo holds. For use at Maintenance & Repair or On Board Maintenance.

SPECIFICATION DATA

Gloss Semi Gloss.

Colour Aailable on Request. Specific gravity 1.45 \pm 0.5 kg/litre.

Solid by volume $80 \pm 2 \%$.

Recommended Dry film thickness : 100 -150 microns.

Wet film thickness : 130 -175 microns.

Coverage theoretical

Dry time

7.5 m2/ litre - 100 microns.: 5 m2/ litre - 150 microns

Full cure 7 days

Painting interval Min: 8 hours; max: 6 days.

VOC Max. 316.8 g/litre.

Flash point (DIN 53213)

25°C for base and 26°C for hardener

Pot life

8 hours (after mixing the components).

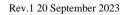
Shelf life

12 months (cool and dry place)

SURFACE PREPARATION

Steel: blast cleaned in situ to at least SSPC-SP 10 and free from rust, scale, shop primer and any other contamination.

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CONDITION OF APPLICATION

Temperature: minimum 5°C; maximum 50°C.

Relative humidity: maximum 85%.

Substrate temperature should be at least 3°C above dew point.

SYSTEM SPECIFICATION

Can be top coated with all paint types (alkyd, epoxy, coal tar epoxy, vinyl, chlorinate rubber or polyurethane, etc.)

INSTRUCTION FOR USE

- Mixing ratio by volume: Base; Hardener = 4:1
- The temperature of the mixed base and hardener should be above 150C, otherwise extra solvent may be required to obtain application viscosity.
- Stir well before use preferable by means of mechanical mixer. Thinner should be added after mixing the components.
- Too much solvent result in lower sag resistance and slower cure.
- Thinner should be added after mixing components.

APPLICATION DETAILS

Method of application	Airless spray	Air Spray	Roller/brush
Thinner No.	KEN TH 012	KEN TH 012	KEN TH 012
Volumer of thinner	Max. 10%	Max 15%	Max. 5%
Nozzle orifice	0.018 (0.46 mm)	1.5-2 mm	-
Nozzle pressure	150 Bar (2100 psi)	3-4 Bar / 57 psi	-
Cleaning solvent	KEN TH 011	-	-

ADDITIONAL DATA

Over Coating table for other products.

Description	Subtrate Temp.			
	10°C	20°C	32°C	40°C
Min. Interval	10 Hours	5 Hours	3 Hours	2 Hours
Max. Interval	21 Hours	10 Hours	7 Hours	7 Hours

Film thickness and spreading rate.

Max DFT without sagging with airless spray	250 microns	2.4 m2/L
Max DFT when Brushing	50 microns	12 m2/L
Max DFT for closed film with airless spray	25 microns	24 m2/L

Pot Life (at application Viscosity)

Themperature	Pot Life	
15°C	10 Hours	
20°C	8 Hours	The figures are valid for
26°C	6 Hours	quantities of t liter and more
32°C	5 Hours	
36°C	4 Hours	

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SAFETY PRECAUTION

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use. Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

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