912 EPOXY COAT

Description

Two component anticorrosive, epoxy-polyamide coating. It is designed for the coating of primed or non-primed metallic structures (e.g., zinc rich substrate) as a primer or an intermediate coating presenting long lasting anticorrosion protection. Suitable as a self-primed coating. Ideal for metallic and cement industrial constructions that demand strong chemical resistance. It is offered after request in MIO (micaceous iron oxide), which contains organometallic iron oxide (micaceous) for extra anticorrosion protection. In MIO version, it offers permanent conductivity that prevents static electricity charges on industrial metallic surfaces (i.e., steel pipes, tanks etc.). It has a conductivity resistance < 10^7 Ohm.
It is certified by a European Institute according to ISO 12944, regarding its corrosion-protective properties.

Technical Information

Shade	Any RAL after request - micaceous	
Gloss	Mat	
Specific Weight	A component	1,50 - 1,54 kg/lt (depending on the base)
	B component	0,90 kg/lt
	A+B	1,35 ±0,05 kg/lt
Solids A+B	62% (±2) by volume	
Theoretical Coverage	4,60 m^2/kg (100 µm A+B)	
Temperature Resistance	Up to 120 °C (service temperature)	
Mixing Ratio	A:B - 5:1 by weight (A:B–2,92:1 by volume)	
Pot Life	10-12 hrs (25ºC)	
VOC*	Ready for use maximum (+10% thinner): 495 g/lt EU LIMITS (2010): 500 g/lt SUBCATEGORY: j – Two pack reactive performance coating, primer coat for ferrous substrates, anticorrosion finish, Type SB	

Drying Time 100µm, 60%RH

	Pot life	Touch dry	Dry	Dry to recoat (Min)	Dry to recoat (Max)	Full Dry
(5˚C)		6 hrs	14 hrs	15 hrs	12 days	8 days
(15˚C)		3 hrs	7 hrs	8 hrs	7 days	5 days
(25˚C)	10-12 hr	2 hrs	5 hrs	5 ½ hrs	5 days	96 hrs
(35˚C)		1 ½ hrs	3 ½ hrs	4 hrs	4 days	72 hrs

The above pot lifetimes refer to material without addition of thinner. After adding thinner, a small increase in the pot life is expected. The above times are indicative and depend on the thinning percentage, substrate conditions, film thickness, weather conditions (relative humidity, wind, sunshine).

Surface Preparation

All applications on steel, including welding, cut with flame and smoothing, must be terminated before the preparation of the surface. Cleaning of the surface from dust and other materials like oil, grease etc. using special detergent and fresh water under high pressure. The alkaline remnants of the recent welding joints as well as the traces of soap, must be removed with fresh water and rubbing. For better results, sandblast is recommended at least Sa 2 ½, ISO 8501-1. If it is necessary, the surface could be treated with a two-component anticorrosive primer (i.e., 812 epoxy primer or 751 zinc rich epoxy primer or 851 inorganic zinc rich primer).

Application

Mix A:B-5:1 by weight. Then thinner is added. Proposed use mechanical stirrer. It is important to stir both around the walls and at the bottom of the mixing container, so the hardener is evenly distributed. **Apply approximately 20 minutes after mixing**.
It is applied with:
Airless (nozzle 0,38 – 0,53 mm, 0,015-0,021 in) after 5-10% thinning with thinner.
Air pistol, (diameter: 1,8-2,2 mm, pressure: 3-5 bar) after the thinning of the product, 10%, with thinner.

Suggested film thickness	50-150 µm
Application temperature	5-35˚C

Substrate temperature	5-35˚C
Dew point	The substrate temperature must be at least 3 ºC higher than the dew point.
Relative humidity	< 80 %
Suggested thinners	1131-1120-1015 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company.

The above conditions must be followed both during the application process and throughout the drying.
It should not be applied when rain is expected (at least 24h).
It is necessary to protect the coating from the moisture (>80%) and the rain for about 24 hours after the application. Moisture can cause white or/and sticky surface and can affect drying and recoating time.
The surface where the product will be applied on must be clean and dry.
If the maximum recoat time is exceeded, the surface should be mechanically treated before repainting.

Note:
When applicable, products primarily meant for use as primers may have slight color variations from batch to batch.
Like all epoxy paints (during external use), prolonged exposure to weather conditions provokes chalking and color alteration. This fact affects only the surface and not the anticorrosive-protective properties of the product.
If the color stability and the aesthetic result are important, recoating with polyurethane finish coat is required.

Storage

Up to 12 months in a dry and cool place (5-30˚C) protected from direct solar radiation and adverse weather conditions, stored in the original unopened containers.

Safety

Please consult the Material Safety Data Sheet. Available upon request.