



## Product Description

It is a two component polyamide High Build Intermediate Epoxy Coating with high percent of solid materials which has excellent adhesion and mechanical properties, excellent resistance against splash and fumes of acid, alkalis, water salt solutions and other corrosive chemicals.

## Recommended Use

This coating (in the epoxy system) is used for protection storages, steel structures in marine and industrial environments. Pay attention this product with suitable polyurethane topcoat is recommended for exterior exposure.

## Surface Preparation

- 1: All surface to be coated should be clean, dry and free from contamination prior to paint application, all surfaces should be assessed and treated in accordance with ISO8504:1992.
- 2: To follow of interval coating of primer, areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa 2 1/2 (ISO 8501-1:1998) or SSPC-SP6) and patch primed prior to the application of Polyamide Cured High Build Intermediate Epoxy Coating.

## Product Description

Shade:	RAL colors
Percentage of Vehicle:	37%-42%
Percentage of Pigment & extender :	58%-63%
Percentage Of Volume solids:	70%±3%
Wet film thickness:	100µ
Theoretical Coverage:	4-5 m <sup>2</sup> /kg
Mixing ratio by weight: B/A	25:5
Specific gravity :	1.7-1.8 Kg/Lit
Viscosity:	140-150 k
Salt spray chamber test:	250h( ASTM B-117)
Humidistatic chamber test:	250h(ASTM D -2247)
Recoating interval time:	1-30 days
Curing mechanical :	Solvent vaporization and reaction between two components
Thinner :	High Build Epoxy Thinner Rangin Zereh Sepahan
Shelf life:	A= 12 month , B= 12 month
Flash point:	26°C

Dry times are dependent on applied film thickness, all data in this catalogue are reported at recommend D.F.T in laboratory conditions.

Temperature	Touch dry	Full cure	Interval coating	Pot life
15°C	Minimum 6hours	13 days	24-30hours	8hours
25°C	4-6hours	Minimum 7 days	16-24 hours	6hours
40°C	3-5hours	Minimum 5 days	16hours	4hours

## Environmental Conditions

To prevent moisture condensation during application surface temperature must be at least 3 °C above the dew point. In hot climate, material temperature should be 20 to 25°C. For satisfactory cure air and surface temperature must be above 10°C. Never apply coatings under reverse environmental condition. Paint shall not be applied when wind speed is in excess of 7 m/s.





## Application Details

Airless spray	Tip range: 0.017-0.021 Total out put pressure at spray tip not less than 141 bar.
Air spray	Nozzle orifice:1.8-2.2 mm Nozzle pressure:2-4 bar
Brush	70-80μ (touch up)
Roller	70-80μ (touch up)

## Application Procedure

- 1: Flush all equipment with recommended cleaner before use.
  - 2: Stir part A with a power mixer.
  - 3: Add curing agent (part B) to part A, and continue stirring for 5 minutes.
- Note: since the pot life is limited and shortened by high temperatures, do not mix more material than will be use.
- 4: For air spray, thin with no more than 5-7% of recommend thinner for workability for airless spray 5% Of thinner is normally sufficient.
  - 5: Stir during application to maintain uniformity of materials apply wet coat by parallel passes overlap each pass 50% to avoid bare areas.
  - 6: Double coat all welds, rough spots, sharp edges, rivets, bolts, etc., to ensure proper thickness.
  - 7: If the minimum interval coating of this coating is exceeded, roughening of the surface is necessary to ensure inter coat adhesion. (If the adhesion is reduced, one layer of sealer epoxy or mist coat of after layer is recommended.)
- Note: Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.
- 8: Clean all equipment with recommend cleaner immediately after use.

## Safety

This product is flammable keep away from heat and open flame operator (accordance MSDS of this product) must use special mask and safety gloves and operation should be performed in environments which is equipped with suitable air conditions.

## Storage Conditions

Store in closed container and away from direct sunlight at temperature of 5-35 °C.

