



Product Description

Polyamide Cured Coal Tar Epoxy is a two component polyamide cured epoxy coating with modified tar. It is suitable for use in cold and hot climates and excellent rust preventing, chemical resistance against hydrochloric acid, sodium hydroxide, salt water and sour crude.

Recommended Use

This coating is used for protection of steel in marine structures, cured oil tanks, ships bottom, pipe coating, petrochemical and oil refining plants.

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. where necessary, remove weld spatter, and where required smooth weld seams and sharp .oil or greases should be removed in accordance with SSPC-SP1 solvent cleaning .
- 2: For immersion service, Polyamide Cured Coal Tar Epoxy must be applied to surfaces blast cleaned to a minimum Sa 2 1/2 (ISO 8501-1:1988) or SSPC-SP10, however, for atmospheric exposure Polyamide Cured Coal Tar Epoxy may be applied to surfaces prepared to a minimum of Sa 2 1/2 or SSPC-SP6 and if oxidation has occurred between blasting and application of this coating, the surface should be re blasted to the specified visual standard.
- 3: If this coating is applied in one layer, for increase adhesion 40-60% minimum D.F.T of this coating for angular surface profile is recommended.

Product Description

Shade:	Black ,Brown
Percentage of vehicle:	45%-50%
Percentage of pigment & Tar :	50%-55%
Percentage of Volume solids:	55%-60%
Dry film thickness	110-130 μ
Wet film thickness:	175-225μ
Theoretical Coverage:	4-5 m ² /kg
Mixing ratio by weight: B/A	25:5
Specific gravity :	1.2-1.3 Kg/Lit
Viscosity:	95-105 k
Salt spray chamber test:	400h(ASTM B-117)
Humidistatic chamber test:	400h (ASTM D -2247)
Recoating interval time:	1-7 days
Curing mechanical :	Solvent vaporization and reaction between two components
Thinner :	Epoxy Thinner Rangin Zereh Sepahan
Shelf life:	A= 12 month , B= 12 month
Flash point:	28°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	7 hours	14 days	24-36 hours	10 hours
25°C	4 hours	8 days	24 hours	8 hours
40°C	2 hours	4 days	16 hours	6 hours

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: 0.015-0.021 inch Total out put pressure at spray tip not less than 141 bar.
Air spray	Nozzle orifice:1.8-2.2 mm Nozzle pressure:3-5 bar
Brush	50-60μ (touch up)
Roller	50-60μ (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 5-10% of recommended 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 recoating time of coal tar epoxy 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 coal tar epoxy 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.

