



Product Description

Sealer and intermediate coat for maintenance operations, steel structures and primed metal surfaces particularly when recoating interval is passed due. This product is also used to promote bonding to non-ferrous metal, plastic and composite substrates to avoid paint dis bonding risk

Recommended Use

This coating (in the epoxy system) is used for protection steel structures, machinery, pipes and tanks exterior and oil refineries

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, arias of breakdown damage etc., should be prepared to the specified standard (e.g. Sa 2 1/2 (ISO 8501:1998) or SSPC-SP6) and patch primed prior to the application of Polyamide Cured Intermediate Epoxy Coating.

Product Description

Shade:	RAL colors
Percentage of Vehicle:	50%-55%
Percentage Of Pigment & extender :	45%-50%
Percentage Of Volume solids:	56%±2%
Dry film thickness:	50 µ
Theoretical spreading rate:	6-7 m ² /kg
Mixing ratio by weight:	25:5
Induction time at 25 °C:	20-30 minutes
Shelf life:	12 months
Pot life:	12 h
Thinner:	Epoxy Thinner Rangin Zereh Sepahan
Specific gravity :	1.4±0.03 Kg/Lit
Viscosity:	95-105k
Salt spray chamber test:	250h(ASTM B-117)
Humidistatic chamber test:	250h (ASTM D-2247)
Curing mechanical:	Solvent vaporization and chemical reaction between two components.

Temperature	Touch dry	Full cure	Interval coating	Pot life
15°C	3-4hours	Minimum 7 days	24-36 hours	10 hours
25°C	2-3hours	7 days	16-24 hours	8 hours
40°C	2hours	5-7 days	12-16 hours	6 hours

Environmental Conditions

T0 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: 0.017-0.021inch Total out put pressure at spray tip not less than 141 bar.
Air spray		Nozzle orifice:1.8-2.2 mm Nozzle pressur:2-4 bar
Brush		30-40μ (touch up)
	Roller	30-40μ (touch up)

Application Procedure

- 1-Flush all equipment with recommended clear 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 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 in 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.

