



Product Description

Polyamide Cured Epoxy Clear Coat is a two component polyamide cured epoxy clear coat witch has high glass transparent top coat.

Recommended Use

This coating is used where an attractive appearance and a wide range of corrosion resistance is required for example on industrial structures and machinery.

Surface Preparation

Surface to be coated clean dry and free from contamination prior to paint application ,all surface should be assessed and treated in accordance with ISO8504 :1992.

Product Description

Shade:	Clear
Percentage of Volume solid:	63%±2%
Percentage of Weight solid:	68%±2%
Wet film thickness:	45-65μ
Dry film thickness:	30-40μ
Theoretical Coverage:	15-22 m ² /kg
Mixing ratio by weight: B/A	20:5
Specific gravity :	0.8-1.1 Kg/Lit
Viscosity:	100-110 k
Salt spray chamber test:	250h(ASTM B-117)
Humidistatic chamber test:	250h(ASTM D -2247)
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:	23°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	Pot life
15°C	8-7 hours	Minimum 8 days	10 hrs
25°C	4-5 hours	7 days	8 hrs
40°C	3-4 hours	7-5 days	6 hrs





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: 0.013-0.015 inch Total out put pressure at spray tip not less than 141 bar.
Air spray	Nozzle orifice:1.6-1.8 mm Nozzle pressure:2-4 bar
Brush	Not recommended.
Roller	Not recommended.

Application Procedure

- 1: Flush all equipment with recommended cleaner before use.
 - 2: 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.
- 3: For air spray, thin with no more than 5% of recommend thinner for workability for airless spray 3-5% of thinner is normally sufficient.
 - 4: Stir during application to maintain uniformity of materials apply wet coat by parallel passes overlap each pass 50% to avoid bare areas.
 - 5: 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.

