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# HI-BUILD EPOXY POLYAMIDE INTERMEDIATE

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## Parsiguard 4204IT

### DESCRIPTION

\* Two component high build epoxy intermediate coating formulated with selected epoxy resins and special polyaminoamide and partly amine adduct hardeners .  
It is formulated to meet relevant standards for paint systems defined by Iranian Steel Company, non-ferrous mining and beneficiation plants and projects.  
It also follows the requirements of contractors and constants' guidelines.

### USES

\* As an intermediate epoxy layer in atmospheric multi-layer anti-corrosive coating systems for metal works such as Iron & Steel , non ferrous, mining and beneficiating plants and projects.

### FEATURES

- \* Excellent adhesion to most primers .
- \* Excellent weather resistant .
- \* Excellent barrier property .
- \* High build .
- \* Thick layer in one coat is attainable .

### TECHNICAL DATA

<b>Finish</b>	Flat
<b>Colour</b>	White & Gray , Ochre , Colored <sup>1</sup>
<b>Specific gravity ( at 20 °C , Mix )</b>	1.5 ± 0.05 ( gr/cc )
<b>Volume solid</b>	55 ± 2 %
<b>Recommended DFT</b>	100 - 200 ( mic )
<b>Flash point</b>	35 °C
<b>Shelf life ( at 20 °C )</b>	12 months
<b>Package</b>	20 Liters, others on request

<sup>1</sup> Technical data and codes might be changed in colored paints.

### SURFACE PREPARATION

- 1 - The primed or previous layer should be quite free of any oil , grease , dirt , dust and moisture . Zinc primer should be free from any zinc salts .
- 2 - Pay attention to maximum recoating interval of previous layer .

### RECOMMENDED PAINT SYSTEMS

P : 7411 <sup>2</sup> , 4424 (all series), 4433	60 - 80	micron
OR 4142 IT, 4143 (all series)	70 - 100	micron
I : 4204 IT	100 - 200	micron
T : 6591(all series) , 6592 (all series) 4392, 3391, 2932	50 - 80	micron

<sup>2</sup> See note J when selecting or using zinc ethyl silicate .  
7411 needs 4252 as tie-coat or a thin mist coat of 4204IT before applying main thickness of intermediate.

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### APPLICATION DATA

Method	Air / Airless spray , Brush (just for inaccessible area or touch up)		
Thinner / Cleaner	T-404		
Mixing ratio by Weight	100 : 14.3	<b>Base: 21 kg + Hardener : 3 kg</b>	
Pot life ( at 20 °C )	8 hrs		

- Different thinner with different suffix maybe offered in hot and cold seasons.

#### Theoretical Coverage :

Dry film thickness (mic)	100	150	200
Coverage ( m <sup>2</sup> / lit )	5.5	3.7	2.7
Coverage ( m <sup>2</sup> / kg )	3.7	2.4	1.8

Touch dry (100 mic , 20 °C )	1 hr
Fully Cured (100 mic , 20 °C )	7 days

- At higher dry film thickness, lower temperature and poor ventilation drying time will be longer.
- Application in closed area results in long touch & tack drying time and therefore longer minimum intervals. So sufficient air draft is required for maintaining normal application condition.

#### Recoating interval :

Surface temperature	10°C	20°C	30°C
Min. Interval ( hrs )	12	8	6
Max. Interval ( days )	7	6	5

- The maximum recoating times are for reaching the maximum chemically intercoat adhesion, but it is possible to reach a reasonable adhesion even up to few months . **See note E**

### APPLICATION INSTRUCTIONS

- \* Check all equipments are dust, oil and moisture free. If needed , flush with cleaner thinner.
- \* It is recommended to use the paint with the temperature above 15°C, otherwise more thinner would be required to reach the application viscosity. Too much thinner may results in sagging, low thickness and poor hiding. In cold seasons it is recommended to keep the paint at a warmed up storage at least 3 days before use.
- \* Stir the paint well by a forced mixer before use and add the entire hardener to it and mix it again up to get a homogenous mixture.
- \* Thin the paint with defined thinner depend on required thickness & application viscosity.

#### The given data could be adjusted by applicator in practical situation by his own actual trial.

	Pressure (atm)	Orifice	Tip Range	Thinner (vol%)
Air spray	3 - 4	1.3 - 3 mm		5 - 20
Air less	6 - 7	19 - 23 mic	219 -323	5 - 10
Brush / Roller	Suitable for small areas only .			

### SURFACE TEMPERATURE

Must be at least 3°C above dew point, apply the coats when surface temperature is from 10°C to 40°C. Please consult Parsifam if the substrate temperature is lower or higher.

### SAFETY

- ▲ Due to high flammability , keep away the paints from heat , sparks and flames.
- ▲ Avoid contact the paints with eyes and skin.
- ▲ Use mask and gloves and provide suitable ventilation for the reasons of health and safety.

**REMARKS :** The information submitted in this data sheet is based on our best current knowledge and experience. The ultimate performance of this coating is quite related to performance of surface preparation, application procedure and conditions that limits our liability to the figures of submitted technical and application data .