

HI-PERFORMANCE EPOXY POLYAMIDE INTERMEDIATE

(Based on IPS - M - TP 220)

Parsiguard 4204X2

DESCRIPTION

* 2K high build epoxy intermediate coating is formulated with carefully selected raw materials in a balanced ratio to meet high performance expectations. It has good barrier effect, so it works well in both atmospheric and immersion anti-corrosion paint systems.

This version typically and sufficiently meets resistances and performances required in SSPC Paint No. 22 equivalent to **IPS- M -TP 220** , but because of the higher volume solid and lower VOC, it is actually more economical and environmentally friendly.

USES

* As an epoxy intermediate layer in multi-layer anti-corrosion paint systems for atmospheric applications at the request of ISO 12944-5, IPS, TOTAL, POGC and SPGC referenced systems.

* As an epoxy intermediate in paint systems in tank lining for oil & oil products according to IPS - M - TP220 standard.

FEATURES

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

TECHNICAL DATA

Finish	Flat
Colour	White, Gray (RAL 7035) & other colour ¹
Specific gravity (at 20 °C , Mix)	1.50 ± 0.05 (gr/cc)
Volume solid	60 ± 2 %
Recommended DFT	100 - 200 (mic)
Flash point	35 °C
Shelf life (at 20 °C)	12 months
Package	20 Liters, others on request

¹ 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

Atmospheric Paint Systems :

P : 7411 ² , 4424 (all series) ,4192	OR	60 - 80	micron
P : 4143X2		70 -120	micron
I : 4204X2		100 -200	micron
T1 : 4304X2		50 -100	micron
T2 : 6591		50 -70	micron

Internal Paint Systems :

P : 4143X2		70 -100	micron
I : 4204X2		100 -200	micron
T : 4304X2		50 -125	micron

² See note J when selecting or using zinc ethyl silicate .
7411 needs 4252 as tie-coat or a thin mist coat of intermediate layer like 4204X2 before applying main specified 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	Base : 21 Kg + Hardener : 3 Kg	
Pot life (at 20 °C)	4 hrs		

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

Theoretical Coverage :

Dry film thickness (mic)	100	150	200
Coverage (m ² / lit)	6	4	3
Coverage (m ² / kg)	4	2.67	2

Touch dry (100 mic , 20 °C)	4 hrs
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)	24	16	10
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 .