

DESCRIPTION

* Two component high solid , high build epoxy intermediate coating formulated with selected epoxy resins and special hardeners to provide lower VOC , higher DFT in one pass application and high corrosive passage resistance .

USES

* As an excellent intermediate epoxy in multi-layer anti-corrosive coating systems in industrial , chemical and marine environments .
* As an excellent intermediate in complete paint systems which is designed for severe atmospheric conditions.

FEATURES

* High solid and High build .
* Excellent adhesion to most primers .
* Good adhesion to mechanically cleaned surfaces.
* It is usable as intermediate in immersion paint systems with suitable primer & topcoat
* Thick layer in one coat is attainable easily .
* Self primed coat for maintenance .

TECHNICAL DATA

Finish	Matt
Colour	White & Colored ¹
Specific gravity (at 20 °C , Mix)	1.72 ± 0.05 (gr/cc)
Volume solid	70 ± 2 %
Recommended DFT	100 - 300 (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 -As an intermediate, the primed or previous layer should be quite free of any oil grease ,dirt , dust and moisture .
- 2 - As a self primer ,the best result is attained by SA 2 ½ , but when it is impossible , the power tool cleaning up to SP11 is acceptable .
- 3 - Pay attention to maximum recoating interval of previous layer .

RECOMMENDED PAINT SYSTEMS

P : 7411 ² , 4424 (all series), 4433	60 - 80	micron
OR 4142 IT, 4143 (all series)	70 - 100	micron
I : 4205 ZP	100 - 200	micron
T : 6591 (all grades) , 4392, 3391, 2932	50 - 100	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 4205ZP before applying main specified thickness of intermediate.

APPLICATION DATA

Method Air / Airless spray , Brush (just for inaccessible area or touch up)
 Thinner / Cleaner T-404
 | Mixing ratio by weight 100 : 10 **Base : 24 kg + Hardener : 2.4 kg**
 | 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 ² / lit)	7	4.67	3.5
Coverage (m ² / kg)	4.01	2.71	2.04

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)	16	15	12
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 .