
SOLVENT FREE EPOXY COATING

(Complies EN 10289 : 2002)

Parsizone 4522A

DESCRIPTION

* Two component solvent free epoxy coating designed to serve long term protection for external surfaces of above and under ground piping and also lining of water tanks . It is an excellent selection for lining of oil and oil derivatives reservoirs .

USES

* External surfaces of pipes .
* Oil and oil derivatives tank lining .
* Process water tank lining .

FEATURES

* High cross-linking density .
* High anti - corrosive effect .
* Dry service temperature : - 20 to 80 °C
* Excellent immersion resistance.
* Discoloration & chalking will be occurred in exposure to sunlight , but no malfunction .

TECHNICAL DATA

Finish	Gloss
Colour	Gray
Specific gravity (at 20 °C , Mix)	1.4 ± 0.05 (gr/cc)
Volume solid	100
Recommended DFT	400 - 1500 (mic)
Flash point	110 °C
Shelf life (at 20 °C)	12 months
Package	20 Liters, others on request

SURFACE PREPARATION

1- Blast up to SA2½ with 60 - 90 microns roughness.
2- Remove any oil, accumulated dirt, dust and soluble salts from surface.

RECOMMENDED PAINT SYSTEMS

1) As a single coat for pipes external coating		
P & I & T : 4522A	400 - 1500	micron
2) As tank lining		
P1 : 4255 (optional as holding primer)	50 - 70	micron
P & I & T: 4522A	800 - 1000	micron

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APPLICATION DATA

Method	Air / Airless spray , Brush (just for inaccessible area or touch up)		
Cleaner	T-404		
Mixing ratio by weight	100 : 20	Base : 18.33 kg + Hardener : 3.67 kg	
Pot life (at 20 °C)	1 hr		

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

Theoretical Coverage :

Dry film thickness (mic)	400	1000	1500
Coverage (m ² / lit)	2.5	1	0.67
Coverage (m ² / kg)	1.79	0.71	0.48

Touch dry (200 mic , 20 °C)	4 hrs
Fully Cured (200 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	40°C
Min. Interval (hrs)	24	8	4	2
Max. Interval (days)	14	7	5	1

- The maximum recoating times are for reaching the maximum chemically intercoat adhesion, but it is possible to reach a reasonable adhesion even up to one months . **See note E**
- * 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.
- 2 In hot weather, there is no need to thinner when it is applied by airless . In cold area it can be applied by adding up to 5% thinner .
- * Stirring the material in low speed during painting is necessary . **See note H**

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

	Pump Ratio	Orifice	Tip Range	Thinner (vol%)
Air less	> 45 :1 preferably 68:1	23 - 45 (mic)	323 - 445 , 545	Max. 1 %
Brush / Roller	only for inaccessible areas			

APPLICATION INSTRUCTIONS

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 .