

# SURFACE TOLERANT EPOXY COATING

## Parsikraft 4246S2

### DESCRIPTION

\*Hi-performance self-primed single coat epoxy with high tolerance to moist and low degree prepared surfaces. It has good penetration and wetting properties to bond to old and aged coatings at atmospheric conditions.

### USES

- \* Excellent self-primed and surface tolerant coat in atmospheric paint systems when blasting is not allowed and tool cleaning is due.
- \* Excellent repairing primer for old and aged paints.

### FEATURES

- \* Excellent wetting property to old paints.
- \* Excellent adhesion to mechanically cleaned surfaces.
- \* Good barrier properties for water, Oxygen and ions.
- \* High tolerance to damped surfaces prepared by hydro jetting.
- \* High tolerance to tool cleaned surfaces.

### TECHNICAL DATA

<b>Finish</b>	Flat
<b>Colour</b>	Grey, Red-Oxide
<b>Specific gravity ( at 20 °C , Mix )</b>	1.6 ± 0.05 ( gr/cc )
<b>Volume solid</b>	80 ± 2 %
<b>Recommended DFT</b>	100 - 600 ( mic )
<b>Flash point</b>	35 °C
<b>Shelf life ( at 20 °C )</b>	12 months
<b>Package</b>	20 Liters, others on request

### SURFACE PREPARATION

- 1 - The best result is attained by SA2½, but when desired, the power tools up to at least ST2 is acceptable.
- 2 - Remained moisture on hydro jetting prepared surfaces is acceptable.
- 3 - Old and aged paints should be cleaned from oil and dirt and sanded to get some roughness.
- 4 - As an intermediate, the primed or previous layer should be free of any oil, grease and dirt
- 5- Pay attention to nature and maximum recoating interval of previous layer.

### RECOMMENDED PAINT SYSTEMS

<b>A : As mid coat</b>			
P : 7411 <sup>1</sup> , 4424 (all series)	70 - 90	micron	
<b>I : 4246S2</b>	1 or 2 × (100-200)	micron	
T : 6591(all series), 4392, 3391	50 - 100	micron	
<b><sup>1</sup> See note J when selecting or using zinc ethyl silicate .</b>			
<b>B : As surfave tolerant primer and Intermediate</b>			
<b>P &amp; I : 4246S2</b>	1 or 3 × (100-200)	micron	
T : 6591(all series), 4392, 3391	50 - 100	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 4246S2 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 : 13.64	<b>Base : 22 kg</b>	<b>Hardener : 3 kg</b>
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)	100	300	600
Coverage ( m <sup>2</sup> / lit )	8	2.66	1.33
Coverage ( m <sup>2</sup> / kg )	5	1.68	0.83

Touch dry ( 150 mic , 20 °C )	10	hrs
Fully Cured ( 150 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 )	30	24	18
Max. Interval ( days )	7	6	5

- For having required interchemical bonding, maximum interval must be strictly followed for immersion uses, but for atmospheric application it is possible to recoat it after few weeks .

**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.
- \* 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			

## 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 .