
HI-PERFORMANCE GLOSS EPOXY POLYAMIDE TOP COAT

Parsipox 4392

DESCRIPTION

* Two component polyamide cured top coat formulated with selected epoxy resins and polyaminoamide hardeners. Pigmentation is done with high light fastness pigments which ensures the weather resistance and color retention.

USES

- * Excellent protective top coat for weather resistant multi-layer epoxy coating systems ,if it is not directly exposed to sunlight.
- * Selected as a top coat for indoor areas in mild to severe industrial and marine atmospheres, or outdoor areas when chalking due to sunlight is not a problem.
- * Versatile top coat for paint systems which are used for steel structures, hand rail and ladders.

FEATURES

- * Outstanding corrosion resistance in industrial and coastal application.
- * Good colour retention .
- * Good resistance to weak acids .
- * Excellent resistance to alkalis .
- * Good mechanical properties .
- * Chalking and gloss reduction in exposure to sunlight is due . **See note D**

TECHNICAL DATA

Finish	Gloss ¹
Colour	Wide range of colours are available ¹
Specific gravity (at 20 °C , Mix)	1.5± 0.05 (gr/cc)
Volume solid	55 ± 2 %
Recommended DFT	50 - 100 (mic)
Flash point	35 °C
Shelf life (at 20 °C)	12 months
Package	20 Liters, others on request

¹ Technical data might be changed in different colored paints.

The RAL number comes after code . For example the code of epoxy top coat with RAL 9010 is 4392-9010

SURFACE PREPARATION

1 - The primed surface shall be free of any dirt , dust , oil & moisture .

RECOMMENDED PAINT SYSTEMS

P : 7411 ² , 4424 (all series), 4433	OR	60 - 80	micron
4143 (series), 4142 (series)		70 - 100	micron
I : 4211 (series) , 4204 (series) 4205ZP, 4212 (series)		100 - 200	micron
T : 4392		50 - 80	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 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 :14.28	Base : 21 kg + Hardener : 3 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)	50	70	80
Coverage (m ² / lit)	11	7.86	6.88
Coverage (m ² / kg)	7.33	5.24	4.58

Touch dry (50 mic , 20 °C)	1 hr
Fully Cured (50 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	18	16
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 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.

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 .