

# HI-BUILD EPOXY POLYAMIDE INTERMEDIATE FOR AGED PRIMERS

( Based on IPS - M - TP 220 )

## Parsiguard 4204T1

### DESCRIPTION

- \* Two components epoxy intermediate coating formulated with selected epoxy resins and special polyaminoamide hardeners based on IPS-M-TP 220 but with additional features , so is usable on epoxy primers which their recoating interval time has been passed over and they got aged .  
It is a modified version of Parsiguard 4204 ( IPS-M-TP 220) to provide enough affinity to aged epoxy films , but other properties are kept .

### USES

- \* As an special designed intermediate epoxy layer in multi-layer anti-corrosive coating systems . when there is a long period gap between primer application and next coat .
- \* Due to different weather and pollution conditions in sites , it is highly recommended before applying paint on whole surfaces , after a suitable surface preparation ,first take a patch test and apply it in a small area , so ensure of suitable intercoat adhesion .
- \* It is offered with different thickness as an intermediate in table 7 of IPS -E -TP100
- \* It is used for atmospheric surfaces and not for immersion services .

### FEATURES

- \* Excellent adhesion to most new primers .
- \* Good and enough adhesion on aged epoxy primers .
- \* Good weather resistant .
- \* Good barrier property .
- \* High build .
- \* Thick layer in one coat is attainable .

### TECHNICAL DATA

<b>Finish</b>	Flat
<b>Colour</b>	Gray & Colored <sup>1</sup>
<b>Specific gravity ( at 20 °C , Mix )</b>	1.50 ± 0.05 ( gr/cc )
<b>Volume solid</b>	55 ± 2 %
<b>Recommended DFT</b>	100 - 200 ( mic )
<b>Flash point</b>	35 °C
<b>Shelf life ( at 20 °C )</b>	12 months
<b>Package</b>	20 Liters, others on request

<sup>1</sup> Technical data an code of colored paint might be changed.

### 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 - When recoating interval time has been passed for a long time , degreasing with suitable detergent , sanding or sweep blast to get roughness is necessary .

### RECOMMENDED PAINT SYSTEMS

P : 4424 (series) , 7411	70 - 100	micron
I : 4204 T1	100 - 200	micron
T : 6591( Series ) , 4392	50 - 80	micron

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### APPLICATION DATA

Method Air / Airless spray , Brush (just for inaccessible area or touch up)  
Thinner / Cleaner  
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)	100	125	150	200
Coverage ( m <sup>2</sup> / lit )	5.50	4.4	3.67	2.75
Coverage ( m <sup>2</sup> / kg )	3.67	2.93	2.44	1.83

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 )	12	8	4
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 .