

**HB EPOXY POLYAMINE INTERMEDIATE COATING**  **MP31413**

**It is an epoxy intermediate coating formulated with selected epoxy resins and special cycloaliphatic amine hardeners. It has good barrier effect, so serves well as intermediate in atmospheric anticorrosive paint systems.**

**PHSICAL PROPERTIES**

|  |  |  |  |
| --- | --- | --- | --- |
| 48±2% | Volume Solid (A+B) | chemical reaction | Curing mechanism |
| 40-50 | **DFT (µ)** | **2** | **No. of component** |
| 80-100 | **WFT(µ)** | **upon custom order** | **Color** |
| 9.6-12 | **Theoretical spreading rate(m²/lit)** | **Flat-semiflat** | **texture** |
| MP30008 | **Thinner/Cleaner code** | **-------------------------** | **Density A**(gr/cm3) |
| \*12 months | **Shelf life** | **1.35 ±0.1 gr/cc** | **Density (A+B)** (gr/cm3) |

**\* in storage temperature of 10-30°C**

**DRYING AND RECOATING TIME**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Drying time & Recoating time | | | | |
| Dry to coat | | **Full cure**  **(day)** | **Dry to handle**  **(hour)** | **Touch dry**  **(hour)** |
| Maximum(days) | **Minimum(hours)** |
| 6 | **12** | **7** | **8-10** | **2-3** |

**Note: Drying times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Maximum recoating time is highly dependent upon actual surface temperatures, not simply air temperatures, higher surface temperatures shorten the maximum recoat window.**

**APPLICATION DATA**

|  |  |
| --- | --- |
| 1 Can comp. A should be mixed by 1 Can comp. B | Mixing ratio |
| 10 minutes@25°C | **Induction time** |
| 4 hour@25°C | **Pot life** |

**APPLICABLE**

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|  |  |  |  |
| --- | --- | --- | --- |
| volume thinner | nozzle size(mm) | Pressure (bar) |  |
| 0-5% | **0.53-0,66** | **140-150** | **Airless spray** |
| 5-10% | **1,4-1.6** | **4-5** | **Air spray** |
| Suitable for touch-up and strip coats only | | | **Brush** |

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**APPLIACATIN CONDITIONS**

|  |  |  |
| --- | --- | --- |
| **Substrate Temperature** | **Temperature of the paint before application** | **Humidity** |
| **min 10°c-max.45°C** | **min.10°c ˓max.30°C** | **below 80% R.H.** |
| **The temperature of the substrate should be at least 3°C above the dew point of the air. Air temperature and relative humidity must be measured in the vicinity of the substrate.** | | |

**SURFACE PREPARATION**

|  |  |
| --- | --- |
| Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa 2½. Apply coating as soon as possible after surface preparation to prevent any contamination. | Steel surfaces |
| Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove salts and dirt by fresh water washing. Apply coating immediately after the quality of preparation has been approved. | **Primed surfaces** |
| Corroded and damaged areas should be power tool cleaned to ISO-St3 or blast cleaned to ISO-Sa2 or better and feathering edges of the intact coating. Thoroughly remove dust or abrasive residue before touch-up. | **Painted surfaces** |

**HEALTH AND SAFTETY**

**Observe the pre cautionary notice on the label of the container. A material safety data sheet is available upon request. This product in intended for use by professional applicator.as a general rule ˓avoid skin and eye contact by wearing overalls ˓gloves ˓masks ˓etc. Spillage on the skin should immediately be removed through washing with water and soap or industrial cleaner. Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapors and mist by wearing an air mask.**

**This product contains flammable materials and should be kept away from sparks and open flames˓ smoking in the area should not be permitted.**

**DISCALIMER**

**The information in this data sheet is provided to the best knowledge. However, we have no control over either quality or condition of the substrate and factors affecting the use and application of this product. Therefore ˓ we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from of this product**