



## Technical Data Sheet

### HIGH BUILD COAL TAR EPOXY

#### Scope

A high solid coal tar epoxy coating with outstanding performance in highly saline, chemical and most severe corrosive environments. The product has superb water resistance properties and is also unaffected by alkalinity or sulphates in soil water and is suitable for use in conjunction with cathodic protection.

#### Uses

Recommended for use on structural steel, pipelines and equipment of fertilizer, refineries, chemical and coastal installations. An ideal coating for application on barrage gates and hydel penstocks.

#### Product Data

<b>Type</b>	:	Two Pack, cured with Amine Adduct
<b>Composition</b>	:	Epoxy coal tar suitably pigmented
<b>Mixing Ratio</b>	:	Base: Catalyst. 55:45 by volume
<b>Pot life</b>	:	4-6 hours
<b>Application</b>	:	Brush, roller or airless spray
<b>Recommended DFT</b>	:	150-200 microns per coat
<b>Corresponding WFT</b>	:	192-256 microns per coat
<b>Theoretical spreading Rate</b>	:	3.9-5.2 Sq.Mtr./Ltr.
<b>Drying Time</b>	:	<b>TOUCH</b> : Overnight <b>HANDLE</b> : 24 hours <b>HARD</b> : 48 hours
<b>Curing Time</b>	:	6-7 days

#### Overcoating Interval :

<b>Min</b>	:	24 Hours
<b>Max</b>	:	5 Days
<b>Flash Point</b>	:	Above 22°C
<b>Colour</b>	:	Black
<b>Packing</b>	:	25 Ltrs.
<b>Thinner / Cleaner</b>	:	Thinner
<b>Finish</b>	:	Low Sheen

**Storage Life:** Up to twelve months as long as the sealed containers are kept under cover in a dry place under normal temperature conditions.

#### Resistance Guide

##### Chemical Resistance

Exposures	Splash and spillage	Mild Fumes/ Outdoor Resistance
Acids	Very Good	Very Good
Alkalis	Very Good	Very Good
Solvents	Good	Good
Salt	Excellent	Excellent
Water	Excellent	Excellent

##### Temperature Resistance :

Continuous : 93°C Dry Heat  
Intermittent: 120°C



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<b>Weatherability</b>	:	Good Chalks
<b>Flexibility</b>	:	Good
<b>Abrasion Resistance</b>	:	Very Good

### Surface Preparation

**STEEL** : Remove grease, oil and other contaminants preferably by using Degreasing Solvent. Blast clean to a minimum of Sa 2 V2 Swedish Standard SIS 05 5900. For severe corrosive conditions, blast to Sa3 with a surface profile not exceeding 65 microns.

If blasting is not practical, make full use of mechanical tools along with manual chipping and wire brushing to remove loose rust and scale to St. 2 Swedish Standard SIS 05 5900. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. Best results can be achieved if the manually cleaned surface is primed with Protectomastic Self Priming Surface Tolerant Coating; otherwise treatment with Metal Conditioning Solution will also produce satisfactory results.

The surface should be clean and dry before application of appropriate primer coat.

**CONCRETE:** New concrete: Ensure that the concrete is cured for a minimum of three months. The surface is to be made rough and free from laitance and other contaminants by sand sweeping. Old concrete: Remove all ° salt deposits from the surface by water jet washing. Light sand blast the surface to remove all loosely bound coatings and roughening up of firmly adhering coatings to ensure anchorage with recommended system. Ensure all dust/other particles are fully removed by suction or air blast and the surface is fully clean and dry before application of paints.

In non-critical areas where blasting is not possible, water jet washing and hard wire brushing are minimum requisites.

### Application

Stir the base thoroughly and then mix the base and catalyst in recommended proportion to uniform consistency. Allow it to mature for 30 minutes and stir again before use and during application.

**Brush/Roller:** Apply preferably without thinning. However, if required during application, add upto 5% Thinner.844.

**Airless Spray:** Apply preferably without thinning. However, upto 5 % Thinner ill may be added if absolute/essential depending on conditions. Use any standard equipment having pump ratio 40:1. Tip Size 0.48-0.68 mm. Tip Pressure 110-160 Kg/cm<sup>2</sup>.

### Notes

1. Use off the mixed paint within the stipulated pot life period.
2. Do not apply when temperature falls below 10°C or rises above 50°C and when relative humidity-rises above 90%. Do not apply during rain, fog or mist
3. Brushes and spray equipment should be cleaned with Thinner otherwise equipment is liable to be damaged.

**Health & Safety:** Please refer to the separate safety data sheet available with detailed information.



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