Technical Data

EPOTECT AL FE

Kansai Paint Protective Coatings

**GENERIC TYPE**
Epoxy Paint with aluminium

**DESCRIPTION**
A epoxy resin paint with aluminium

**RECOMMENDED USE**
Steel structure at marine or industrial severe corrosive environment

**FEATURES**
- Excellent resistance to water and sea water
- Tough and high abrasion resistance
- Good applicability
- Excellent adhesion property with zinc rich primer

**PHYSICAL PROPERTIES**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Silver, Bronze</td>
</tr>
<tr>
<td>Finish</td>
<td>Not applicable</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>60 %</td>
</tr>
<tr>
<td>Typical Thickness</td>
<td>Dry: 150 microns / coat</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>4.0 m²/L at 150 microns DFT</td>
</tr>
</tbody>
</table>

*Practical coverage vary depending on loss factors.*

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flash Point Base</td>
<td>28°C</td>
</tr>
<tr>
<td>Flash Point Hardener</td>
<td>26°C</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.19 g/cm³ (Pale Color)</td>
</tr>
<tr>
<td>VOC</td>
<td>345 g/L</td>
</tr>
<tr>
<td>Temperature Resistance</td>
<td>Non-continuous: 200°C, Continuous: 100°C</td>
</tr>
</tbody>
</table>

*These numerical values are subject to normal manufacturing tolerances, colours and testing variances.*

**SURFACE PREPARATION**

- All surfaces to be coated should be completely clean, dry and free from contamination.
- Surface preparation method shall be in accordance with ISO 8504: 2000.
- Remove salt and other water-soluble contaminants by fresh water.
- Remove oil and grease with suitable detergent or solvent (SSPC-SP-1).
- Remove rust, mill scale and other loose material completely by abrasive blasting (ISO8501-1:2007 Sa 2 1/2 or SSPC SP-10)

Product ID No.(PN) Silver base: PN207, Hardener: PN208

**APPLICATION**

**Application Conditions**
Ambient temperature shall be above 5°C and relative humidity shall be below 85%. Surface temperature shall be a minimum of 3°C above dew point. Adequate ventilation shall be provided in confined spaces to ensure proper drying.

**Mixing**
Stir each component with power agitator well before mixing. Then power mix two components.

**Mixing ratio**
Base/Hardener = 3.55/1 by weight

**Induction Time**
15 minutes when ambient temperature is below 10°C. Not required when over 10°C.

**Application Method**
Airless spray
- Thinner: Tect EP Thinner, Tect EP THINNER SLOW DRY (for summer use)
  - (0-10% by weight)
- Nozzle pressure: Not less than 10Mpa, Nozzle Tip: No.163-515-721
Air spray
- Thinner: Tect EP Thinner (0-15% by weight)
- Brush/Roller

**Volume Solids**

<table>
<thead>
<tr>
<th>Colour</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pale Color</td>
<td>4.0</td>
</tr>
</tbody>
</table>

*Too much thinning results sagging and slower cure.*
**Clean Up**

Clean all the equipment with thinner immediately after use.

**Pot Life**

<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>5</th>
<th>20</th>
<th>30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Time (hour(s))</td>
<td>6</td>
<td>3</td>
<td>2</td>
</tr>
</tbody>
</table>

*Use all mixed paint within pot life.

**Drying Time**

<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>5</th>
<th>20</th>
<th>30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface dry</td>
<td>30</td>
<td>30</td>
<td>15</td>
</tr>
<tr>
<td>Touch dry</td>
<td>5</td>
<td>4</td>
<td>2</td>
</tr>
</tbody>
</table>

*Drying time may vary depending on film thickness, ventilation, humidity, undercoat paint condition etc.

**Overcoating Interval**

<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>5</th>
<th>20</th>
<th>30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>9</td>
<td>8</td>
<td>6</td>
</tr>
<tr>
<td>Maximum</td>
<td>7</td>
<td>7</td>
<td>7</td>
</tr>
</tbody>
</table>

*The overcoating intervals are based on overcoating with same or same type of paint.

**Typical undercoat**

ZINCTECT 500, ZINCTECT 1500QD-85

**Typical topcoat**

RETANTECT 6000(M)

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**SAFETY PRECAUTIONS**

Detail information is given on Material Safety Data Sheet (MSDS). Avoid inhalation of spray mist or vapour. Avoid skin and eye contact. Paint contacted with skin should be immediately removed with water and/or suitable cleanser. Eyes should be flushed with water and seek immediate medical attention. Since this product contains flammable solvents, keep away from sparks and open flames. Application and handling of this product should be in compliance with relevant national regulations.

**STORAGE**

Store in dry, cool condition and away from sources of heat and ignition. Containers must be kept tightly closed. Store conditions shall be in accordance with national regulations.

**SHELF LIFE**

12 months from date of production

**GENERAL REMARKS**

- This product is epoxy resin based paint. Same as common other epoxy paint, EPOTECT HB (M) will chalk and discolor with direct outdoor exposure. Top coat with durable finish is recommended to obtain longer term gloss and colour retention.
- Water or moisture such as rainfall during drying stage may make the paint film surface colour whitish. Once such phenomena is observed, light sanding is required to remove the surface layer before subsequent painting.
- Vivid colour may not be obtained.

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