Catalyzed Epoxy Paint

A highbuild anti-corrosive primer based on epoxy resin, anti-corrosive pigments incorporated and polyamide hardener

Steel structure at marine or industrial severe corrosive environment

- Highbuild coating
- Excellent resistance to water and sea water
- Tough, hard and high abrasion resisting
- Excellent adhesion to zinc or non-zinc epoxy primers
- Good resistance to oils and chemicals

Brown and Dark Brown Matt

50%

60 microns / coat

8.4 m²/L at 60 microns DFT

Practical coverage vary depending on loss factors.

13°C, Hardener : 25°C

1.34 g/cm³ (Brown)

429 g/L

Non-continuous : 200°C, Continuous : 100°C

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

- 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 (ISO 8501-1:2007 Sa 2 1/2 or SSPC SP-10) or power tool cleaning (ISO8501-1 St 3 or SSPC SP3).
- Adequate ventilation shall be provided in confined spaces to ensure proper drying.

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

Base/Hardener = 6/1 by weight

15 minutes after mixing base and hardener when ambient temperature is below 10°C.

Airless spray

- Thinner : Tect EP Thinner (0–10% by weight)
- Nozzle pressure: Not less than 10Mpa
- Nozzle Tip : No.163-515～721

Brush/Roller

- Thinner : Tect EP Thinner (0–10% by weight)
- Power mix thinner if required.

Practical coverage vary depending on loss factors.

*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</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>12 hour(s)</td>
<td>8 hour(s)</td>
<td>6 hour(s)</td>
<td></td>
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</tbody>
</table>

*Use all mixed paint within pot life.

Drying Time

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface dry</td>
<td>3 hour(s)</td>
<td>2 hour(s)</td>
<td>2 hour(s)</td>
</tr>
<tr>
<td>Touch dry</td>
<td>16 hour(s)</td>
<td>10 hour(s)</td>
<td>8 hour(s)</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</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>28 hour(s)</td>
<td>16 hour(s)</td>
<td>10 hour(s)</td>
</tr>
<tr>
<td>Maximum</td>
<td>6 month(s)</td>
<td>3 month(s)</td>
<td>2 month(s)</td>
</tr>
</tbody>
</table>

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

Typical undercoat
ZINCTECT

Typical topcoat
EPOTECT, RETANTECT UNDERCOAT E, FLONTECT UNDERCOAT

SAFETY PRECAUTIONS
Detail information is given on Safety Data Sheet (SDS). 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
Base: 24 months  Hardener: 12 months from date of production

GENERAL REMARKS
- This product is not recommended for continuous water immersion.
- This product is epoxy resin based paint. Same as common other epoxy paint, EPOMARINE PRIMER will chalk and discolour 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.

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