EPOMARINE EX 600

CODE : 471-601/600

DESCRIPTION

A high build modified epoxy coating with polyamide hardener

USE

Steel structure and tank at marine or industrial severe corrosive environment

COLOR AND GLOSS LEVEL APPEARANCE

- Grey
- Gloss Level : Sheen

BASIC DATA

Data for mix product	
Application Method	Airless spray, Air spray, Brush or Roller
Specific Gravity	1.38 g/ml (mixtures)
Volume Solids	78% (mixtures)
VOC	270 g/Liter (Method 24 analysis)
Flash point	Base : 23°C Hardener : 5°C
Mixing Ratio	Base : Hardener = 7 : 1 by weight
Recommended DFT	250 micron/ coat
Theoretical Coverage	2 m^2/Kg at DFT 250 micron 2.76 m^2/Liter at DFT 250 micron *Practical coverage vary depending on loss factor
Pot Life	At temperature 10°C 20°C 30°C 12 hours 8 hours 6 hours *Use all mixed paint within pot life
Packaging	4.9 Kg (3.38 Liter) Base in 5 Liters container 0.7 Kg (0.76 Liter) Hardener in 1 Liter container

SURFACE PREPARATION SUMMARY TABLE

Substrate	Surface Preparation	
	Minimum	Recommended
Carbon Steel	St 3 (ISO 8501-1)	Sa 2 ½ (ISO 8501-1)
Shop Primed Steel	Clean, dry and undamaged approved shop primer	Clean, dry and undamaged approved shop primer

APPLICATION

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

Mixing	This material is a two component coating. Always mix a complete set unit in the proportion supplied. After mix, use all mixed paint within pot lifespecified 1). Stir Base (Part A) with power agitator 2). Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator	
Airless Spray	Recommended	Nozzle Tip : 0.43 – 0.53 mm Nozzle Pressure : Not less than 10MPa
Air Spray (Conventional)	Not Recommended	-
Brush	Recommended	Typically 40 – 50µ can be achieved
Roller	Recommended	Typically 40 – 50µ can be achieved
Thinner	Tect EP Thinner	Max 10% depend on application method

Over coating interval for DFT 250 micron				
Over-coating with	Interval	10°C	20°C	30°C
Chlorinated rubber, and alkyd coating	Minimum	24 hours	16 hours	16 hours
	Maximum	1 month	1 month	1 month

Over coating interval for DFT 250 micron				
Over-coating with	Interval	10°C	20°C	30°C
Various two-pack epoxy and polyurethane	Minimum	24 hours	16 hours	16 hours
	Maximum	1 month	1 month	1 month

Curing time DFT to 250 micron			
Substrate temperature	Dry to touch	Dry to handle	Full cure
10°C	12 hours	24 hrs	7 days
20°C	8 hours	16 hrs	7 days
30°C	4 hours	12 hrs	7 days

SAFETY PRECAUTIONS

For paint and recommended thinners, see safety sheet and relevant material safety data sheet This is a solvent borne paint and care should be taken to avoid inhalation of spray mist of vapor as well as contact between the wet paint and exposed skin or eyes

- Avoid at all times inhalation or aerosol spray-mist
- Harmful by inhalation and in contact with skin
- Highly flammable liquid and vapor
- Harmful to aquatic organism, may cause long-term adverse effects in the aquatic environment

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

DISCLAIMER

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TECHNICAL DATA SHEET KANSAI PAINT