

EPIMASTIC 6000

Surface Tolerant Epoxy Primer/Finish

PRODUCT DESCRIPTION

A high solids high build self-priming epoxy coating which can be applied to old or new steel following the removal of loose rust and scale,

- Can be applied over most existing coatings systems including aged alkyd systems.
- Can be easily recoated if required.

DESIGNED USE

- As a single coat maintenance system.
- As a chemically resistant finish for process equipment, pipe work etc.
- As a general maintenance coating for offshore installations.

PHYSICAL DATA

VOLUME SOLIDS (Based on ASTM D2697)	82 % $\pm$ 2 %
TYPICAL DRY FILM THICKNESS	150 microns
WET FILM THICKNESS	185 microns
THEORETICAL COVERAGE	5.47 m ² /litre @ 150 microns DFT
COLOUR	As per Shade Card
FINISH	Semi-Gloss

APPLICATION DETAILS

METHOD OF APPLICATION :	
AIRLESS SPRAY	This is the recommended method of application: Maximum 5% Thinner may be added. Tip Size: 0.48 - 0.58 mm (0.019 - 0.023 in) Pressure: 110 - 160 kg/cm ² (1600 - 2300 psi)
CONVENTIONAL SPRAY	This is also a suitable method of application. Maximum 20% Thinner may be added Tip Size: 1.80 - 2.20 mm (0.071 - 0.087 in) Pressure: 2.75 - 3.45 kg/cm ² (40 - 50 psi)
BRUSH OR ROLLER	May be used for difficult shapes or touch-up. However, additional coats may be required to achieve the recommended film thickness.

DRYING TIME:					
Surface Temperature	Touch Dry	Hard Dry	Re coating Interval		Pot Life
			Minimum	Maximum	
15°C	12 Hrs	24 Hrs	24 Hrs	Indefinite	8 Hrs
25°C	6 Hrs	16 Hrs	16 Hrs	Indefinite	6 Hrs
35°C	3 Hrs	12 Hrs	12 Hrs	Indefinite	4 Hrs
45°C	2 Hrs	8 Hrs	8 Hrs	Indefinite	1 ½ Hrs

NO. OF COMPONENTS	Two
Mixing Ratio	1 parts Base to 1 part Hardener (by volume)
Application Conditions	Do not apply this product if the Relative Humidity exceeds 85% or if the substrate temperature is within 3°C of the dew point

ADDITIONAL INFORMATION

Thinner / Cleaning solvent	Solvalux 7-45
Storage Instruction	Store in a cool shaded dry area
Flash Point	Mixed 36°C
Packaging	5 litres & 20 litres
Shelf Life	12 months from the date of manufacture.

SURFACE PREPARATION

- The life-span and performance of this coating is directly related to the degree of surface preparation
- Remove all wax, oil and grease by solvent cleaning in accordance with the guide lines given by SSPC-SPI.
- Soluble salts, dirt and dust must be removed prior to coating. Dry brushing should be sufficient. A freshwater wash must follow to remove all soluble salts.
- Remove scale by chipping, needle gun or spot blasting. Any loose or flaking coatings should be taken back to a firm edge.
- Mechanically clean the surface using hand or power tools to a minimum standard of St 2 Swedish Standard SIS 05 59 00 or ISO 8501-1 : 1988 taking care to avoid polishing the surface.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.

PRODUCT USE RESTRICTIONS

- This product is designed as a primer-finish. If it is to be used as a surface tolerant primer with subsequent top coating, use only surface tolerance epoxy primer.
- Dry heat resistance up to 120°C
- May also be applied between 100 and 200 microns DFT.
- As common with all Epoxy products, this product also will tend to discolour and chalk on exposure to direct sunlight.

SAFETY PRECAUTIONS

- Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust masks and gloves. Use a barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapor or spray.
- This product is flammable. Keep away from sources of ignition. Do not smoke. Take precautionary measures against static discharge. In case of fire – blanket flames with foam, carbon dioxide or dry chemicals.
- Refer to MSDS for further information.

FIRST AID

- Eyes: In the event of accidental splashes, flush eyes with water immediately and obtain medical advice.
- Skin: Wash skin thoroughly with soap and water or approved industrial cleaner.
- DO NOT USE solvent or thinners.
- Inhalation: Remove to fresh air, loosen collar and keep patient rested.
- Ingestion: In case of accidental ingestion, DO NOT INDUCE VOMITING. Obtain immediate medical attention.

DISCLAIMER

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.