



ASIAN EPOXY HB COATING

Two component, high build, polyamide cured epoxy coating

- Recommended as intermediate and/ or as a top coat in most of the epoxy systems
- Good adhesion on aged epoxy coatings
- Can be recoated with epoxy, polyurethane, chlorinated rubber, acrylic and conventional coatings even after long weathering period
- Good resistance to water and splash of mild chemicals

TECHNICAL DATA

Colour	Range	Drying time at 30° C	Surface dry : 2 hours
Gloss	Matt		Hard dry : 16 hours
Volume solids	Approx. 65%	Over coating interval at 30° C	Full cure : 7 days
Recommended DFT / Coat	60 - 125 microns		Min.: 16 hours
Theoretical covering capacity	10.8 sq. mtr/l at 60 microns DFT 5.2 sq. mtr/l at 125 microns DFT	Shelf life (cool and dry place at 30° C)	Max.: 1 month, provided surface is dry and clean from all contamination
Flash point	Base : Not below 24° C Hardener : Not below 24° C		At least 12 months

DIRECTIONS FOR USE

SURFACE PREPARATION & SUBSTRATE CONDITION:

- Suitable zinc primer, epoxy primer or epoxy intermediate coat; dry and free from all surface contamination. In case of aged epoxy coating, the surface should be sufficiently roughened prior to painting.
- For application over weathered zinc primers, ensure white rust removal by thorough water scrubbing/ high pressure water cleaning. A mist coat is recommended when applied over zinc rich primers.
- Substrate temperature must be at least 3° C above dew point but not above 50° C.

MIXING

Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base under continuous stirring.

Mixing Ratio (by volume)	Base : Hardener 13 : 1	Induction time Pot life at 30° C	30 minutes 8 hours
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APPLICATION

Application Method	Brush/Roller*	Air Spray	Airless Spray
Thinner	T 121 / T 141	T 121 / T 141	T 121 / T 141
Thinner intake	0 - 15% by volume	10 - 25% by volume	5 - 15% by volume
Nozzle orifice		1.5 - 3.0 mm	0.41 - 0.53 mm
Spray pressure		0.3 - 0.4 MPa (= approx. 3 - 4 atm; 43 - 57 p.s.i)	15 - 19 MPa (= approx. 150 - 190 atm; 2100 - 2700 p.s.i)

*The product will show retention of brush marks when applied on large flat or curved surface by brushing

Note: As common to all epoxy, the product will chalk and discolour on exterior exposure. However these phenomena are not detrimental to anti-corrosive performance.

STORAGE & PACKING

Storage : Store in a cool, dry place. Store in accordance with local regulations.

Packing : 20 litre packs

SAFETY INFORMATION

As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.

Please refer to our Material Safety Data Sheet prior to using the product.

Disclaimer: To the best of our knowledge the information provided herein is true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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