

GP HBSL EPOXY COATING		
SOLVENT FREE EPOXY COATING		
DESCRIPTION	Two-component air-drying Solvent less Epoxy Polyamine cured coating.	
RECOMMENDED USE	This product is recommended as a unicoat over Blast cleaned surface. The product exhibits excellent chemical, good solvent and abrasion resistance. Not recommended for exposure to direct sunlight. To retain aesthetics, it is recommended to apply aliphatic polyurethane topcoat.	
PHYSICAL DATA		
COLOUR	Limited range	
FINISH	Satin	
SOLIDS BY VOLUME	98 % Min	
VOC – Theoretical	NA	
Theoretical Spreading Rate	2 - 4 sq.mt/ Ltr at recommended DFT of 250 μ	
FLASH POINT	Base: Above 45 ^o C Hardener: Above 45 ^o C	
DRYING CHARACTERISTICS @ 250 - 500 μ DFT (At 65% Relative Humidity)		
Temperature	30°C (86 F)	40°C (104 F)
SURFACE DRY TIME	4 – 5 Hr's max	3 – 4 Hr's max
TACK Free TIME	7 – 8 Hr's max	4 – 5 Hr's max
DRY TO HANDLE	15 – 16 Hr's	10 – 12 Hr's
FULL CURE	7 Days	4 days
OVERCOATING INTERVAL	Min: 6 - 8 hr's Max: Indefinite	Min: 4-5 hr's Max: Indefinite
Pot Life	30 minutes	15 – 20 minutes
SHELF LIFE	6 months	
SURFACE PREPARATION		
<p>Abrasive blasting to minimum Sa 2.5 Swedish Standards is must with a roughness profile of 50 - 75 microns. The surface should be absolutely dry, oil and salt free before application of the coating. The coating should be applied preferably immediately or within 4 hours after blasting for best performance. In case it is extended; the surface should be cleaned, by sweep blast, to remove any flash rust that may have formed.</p> <p>Surface may be primed with GP SGNF primer to 20 –30 micron dry film thickness before oxidation occurs. Alternatively the blast standard can be maintained by use of dehumidification.</p> <p>GP SGNF can hold a blast for up to 28 days in the semi-protected environment of a tank interior. If moisture is present on the surface, oxidation will occur and reblasting will be required.</p>		
APPLICATION DATA		
MIXING RATIO	Base: Hardener - As per our recommendation	
APPLICATION	By Brush / By Airless Spray/ By Dual Component Spray	
POT LIFE	30 minutes at 30° C	
RECOMMENDED DFT	300 - 500 μ	

OVERCOATING INTERVAL	Second coat of same paint to be applied when first coat is near tack free. If recoating time is exceeded the surface should be roughened by through emery paper scuffing - grade 220,
APPLICATION METHOD	
Stir the Base part thoroughly. Mix the base and hardener as per our recommended ratio, by volume. Stir the mix thoroughly to attain homogeneity. Use of power stirrer is strongly recommended. Allow the mixture to stand still (maturation) for about 5 minutes max to initiate the reaction. Apply uniformly over the surface. All equipments used for above should be properly cleaned.	
Application: By Brush / By Trowel / By Airless Spray	
For Brush application, only for small touch up apply evenly in criss-cross manner and ensure the uniformity. Use quality brushes for paint application.	
For Airless Spray application: Thinner: GP Thinner 002 % Thinner: Max 7 % Nozzle Orifice: 0.575 – 0.63 mm Nozzle Pressure: 300 - 324 Bar	For Dual Component Spray gun: Dual component spray gun with static mixer arrangement like GRACO XP 70 is most suitable machine. Tip size: 425,427,431 & 435 Flush the line with cleaning thinner & flushing thinner after application.
ADDITIONAL INFORMATION	
Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following section of Grand Polycoats Data manual: ⇒ Guide to Product Data Sheet ⇒ Surface Preparation Details ⇒ Paint Application Details ⇒ MSDS	
Instruction: 1. Do not apply paint when temperature falls below 10 ⁰ C or rises above 50 ⁰ C and when Relative Humidity is above 85%. Do not apply during rain, fog, or mist. 2. Brushes and spray equipment should be cleaned with GP's recommended thinner otherwise equipment is liable to be damaged. 3. DFT variation can be obtained by change in application method. Contact Grand Polycoats' representative for further assistance. 4. Shelf life indicated is minimum for this Product and it is subjected to re-inspection thereafter. Individual component is required to be store in cool, dry and covered condition, away from heat and ignition..	
HEALTH & SAFETY	
This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapours as well as contact between the wet paint and exposed skin or eyes.	
LIMITATION OF LIABILITY	
To the best of our knowledge, the technical data in our literature are true and accurate at the date of issuance but are subject to change without prior notice. We guarantee our product to conform to the specifications contained herein. We Make No Other Warranty Or Guarantee Of Any Kind, Express Or Implied, Including Merchantability And Fitness For Particular Purpose. Liability, If Any, Is Limited To Replacement Of The Product Or Refund Of The Purchased Price. Labour Or Cost Of Labour And Other Consequential Damages Are Hereby Excluded	
R: 1: 10: 18 This supersedes all earlier versions of this product data sheet	

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