

GP PRIME 225 HB EPOXY COATING HB EPOXY COATING

DESCRIPTION	Two-component air-drying HB Epoxy Polyamine cured coating.	
RECOMMENDED USE	This product is recommended as a primer over well-prepared substrates either blast cleaned or manually prepared. The product exhibits excellent adhesion over both Ferrous and Non ferrous substrates like Aluminum, GI with excellent flexibility. It offers 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	70 ± 2 % Min	
Theoretical Spreading Rate	7 – 5.80 sq.mt/ Ltr at recommended DFT of 100 - 120 μ	
FLASH POINT	Base: Above 25° C Hardener: Above 25° C	
DRYING CHARACTERISTICS @ 100 - 120 µ DFT (At 65% Relative Humidity)		
TEMPERATURE	30°C (86 F)	40°C (104 F)
SURFACE DRY TIME	90 – 120 min max	70 - 90 min max
TACK Free TIME	6 – 8 Hr's max	4 – 5 Hr's max
FULL CURE	7 Days	4 days
OVERCOATING INTERVAL	Min: 6 - 8 hr's Max: Indefinite	Min: 4-5 hr's Max: Indefinite
Pot Life	3 – 3.5 hr's	2 – 3 hr's
SHELF LIFE	6 months	
SURFACE PREPARATION		

SURFACE PREPARATION

Ideally Abrasive blasting to minimum Sa 2.5 Swedish Standards is must with a roughness profile of 25-35 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. Incase it is extended; the surface should be cleaned, by sweep blast, to remove any flash rust that may have formed. As an alternate where blast cleaning is not feasible then the surface should be manually cleaned by mechanical

As an alternate where blast cleaning is not feasible then the surface should be manually cleaned by mechanical methods like coarse emery paper sanding, wire brushing, scraper, chisel, hand / power tools, etc. to achieve Sa2 / St 3 grade of surface cleanliness, as per Swedish specification. The surface should be absolutely dry and oil free before application

The chemical pretreatment method of Zinc phosphating/Iron phosphating or Tricationic phosphating is also accepted method of surface preparation. The surface should be free from oil, dust, moisture or any contamination.

It has excellent adhesion on GP Aqua prime (Water reducible paint).

APPLICATION DATA		
MIXING RATIO	Base: Hardener - As per our recommendation	
APPLICATION	By Brush / By Conventional / By Airless Spray	
RECOMMENDED DFT	100- 120 μ	
RECOMMENDED THINNER	Thinner Type 002	
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 Conventional / By Airless Spray

For Brush application, apply evenly in criss-cross manner and ensure the uniformity. Use quality brushes for paint application.

Thinner: 5 - 10 %

For Airless Spray application:

Thinner: 5 – 10 %

Nozzle Orifice: 0.48 – 0.53 mm Nozzle Pressure: 2700 – 3200 psi For Conventional Spray application:

Nozzle Orifice: 2.5 - 3 mmNozzle Pressure: 40 - 70 psi

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following section of Grand Polecats Data manual:

- ⇒ Guide to Product Data Sheet
- ⇒ Surface Preparation Details
- ⇒ Paint Application Details
- \Rightarrow MSDS

Instruction:

- 1. Do not apply paint when temperature falls below 10^o C or rises above 50^o 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

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Grand Polycoats Co.Pvt.Ltd.

204, Siddharth Complex, R.C.Dutt Road, Alkapuri, Vadodara - 390 007, (Gujarat), India.

Tel: +91 – 0265 – 6164200 / 6164201 **Fax**: +91-265-2337022

E-mail: marketing@grandpolycoats.com