

# Technical Data

## ESCO



Kansai Paint Protective Coatings

<b>GENERIC TYPE</b>	Catalyzed Epoxy Paint
<b>DESCRIPTION</b>	An anti-corrosive primer based on epoxy resin and moisture-curing ketimine type hardener.
<b>RECOMMENDED USE</b>	Steel structure at marine or industrial severe corrosive environment
<b>FEATURES</b>	<ul style="list-style-type: none"> <li>- High performance corrosion control by penetrating into the rusty surface.</li> <li>- Good applicability.</li> <li>- Quick drying in low temperature.</li> </ul>
	Product ID No (PN) Brown base: PN215 Hardener: PN216
<b>PHYSICAL PROPERTIES</b>	
Colour	Oxide Red, White and Pale colours
Finish	Matt
Volume Solids	60 %
Typical Thickness	Dry : 100 microns / coat
Theoretical Coverage	6.0 m <sup>2</sup> /L at 100 microns DFT
	*Practical coverage vary depending on loss factors.
Flash Point	23°C(Base) 5°C(Hardener)
Specific Gravity	1.37 g/cm <sup>3</sup>
VOC	343 g/L
Temperature Resistance	Non-continuous : 200°C, Continuous : 100°C
	*These numerical values are subject to normal manufacturing tolerances, colours and testing variances.
<b>SURFACE PREPARATION</b>	<ul style="list-style-type: none"> <li>- All surfaces to be coated should be completely clean, dry and free from contamination. Surface preparation method shall be in accordance with ISO 8504: 2000.</li> <li>- Remove salt and other water-soluble contaminants by fresh water.</li> <li>- Remove oil and grease with suitable detergent or solvent (SSPC-SP-1).</li> <li>- Remove rust, mill scale and other loose material completely by abrasive blasting (ISO 8501-1:2007 Sa 2 1/2 or SSPC SP-10) or power tool cleaning (ISO8501-1 St 3 or SSPC SP3).</li> </ul>
<b>APPLICATION</b>	
Application Conditions	Ambient temperature shall be above 5°C and relative humidity shall be below 85%. Surface temperature shall be a minimum of 3°C above dew point. Adequate ventilation shall be provided in confined spaces to ensure proper drying.
Mixing	Stir each component with power agitator well before mixing. Then power mix two components.
Mixing ratio	Base/Hardener = 9/1 by weight
Induction Time	Not required
Application Method	Airless spray Thinner : Tect EP Thinner (0-10% by weight) Nozzle pressure: Not less than 10Mpa Nozzle Tip : No.163-517~621 Air spray - Thinner : Tect EP Thinner (0-15% by weight) Brush/Roller Thinner : Tect EP Thinner (0-10% by weight) Power mix thinner if required.
	*Too much thinning results sagging and slower cure.

Clean Up	Clean all the equipment with thinner immediately after use.		
Pot Life	5 °C	20 °C	30 °C
	12 hour(s)	7 hour(s)	5 hour(s)
	*Use all mixed paint within pot life.		
Drying Time	5 °C	20 °C	30 °C
	Surface dry	2 hour(s)	1 hour(s) 0.5 hour(s)
	Touch dry	12 hour(s)	4 hour(s) 2 hour(s)
	*Drying time may vary depending on film thickness, ventilation, humidity, undercoat paint condition etc.		
Overcoating Interval	5 °C	20 °C	30 °C
	Minimum	16 hour(s)	8 hour(s) 6 hour(s)
	Maximum	1 month(s)	1 month(s) 1 month(s)
	*The overcoating intervals are based on overcoating with same or same type of paint.		
Typical undercoat	SD ZINC		
Typical topcoat	EPOMARIN, RABATECT UNDERCOAT, SD MARINE, CELATECT U UNDERCOAT, SILICOTECT AC UNDERCOAT, CELATECT F UNDERCOAT		

**SAFETY PRECAUTIONS**

Detail information is given on Material Safety Data Sheet (MSDS). Avoid inhalation of spray mist or vapour. Avoid skin and eye contact. Paint contacted with skin should be immediately removed with water and/or suitable cleanser. Eyes should be flushed with water and seek immediate medical attention. Since this product contains flammable solvents, keep away from sparks and open flames. Application and handling of this product should be in compliance with relevant national regulations.

**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.

**SHELF LIFE**

Base: 24 months Hardener: 12 months from date of production

**GENERAL REMARKS**

- This product is not recommended for continuous water immersion.
- This product is epoxy resin based paint. Same as common other epoxy paint, ESCO will chalk and discolour with direct outdoor exposure. Top coat with durable finish is recommended to obtain longer term gloss and colour retention.
- Water or moisture such as rainfall during drying stage may make the paint film surface colour whitish. Once such phenomena is observed, light sanding is required to remove the surface layer before subsequent painting.
- Vivid colour may not be obtained.

\*If any inquiries, please consult Kansai Paint representative for further information.

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