THE MAINTENANCE SOLUTOR
http://www.alspec.com

423 HIGH SOLID EPOXY

PRODUCT DATA:

- ***Excellent Anti-Corrosive Property***
- ***Excellent resistance to moisture***
- ***Excellent resistance to petroleum solvents and aliphatic solvents***
- ***Excellent resistant to abrasion and weather***

PRODUCT INFORMATIOM

Designed to provide tough barrier coating for steel where blast cleaning is practical or economical.
This product can be applied over aged single pack coating or existing two pack coating and capable of withstanding dry heat up to 120ºC.
Tolerant to a rusty surface that is only mechanically or hand and power tool cleaned surface.
Can be overcoated with conventional and two pack coatings.
A maintenance coating for non-blasted steel : process equipment, pipes and storage tanks etc.

APPLICATION:

PRACTICAL APPLICATION RATES

Micron Per Coat	Airless Spray	Conventional Spray	Brush	Roller
Dry	150	150	50	65
Wet	195	195	65	84

AVERAGE DRYING TIME

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		Potlife
			Minimum	Maximum	
15ºC	12 hours	48 hours	48 hours	Indenfinite	16 hours
25ºC	6 hours	24 hours	24 hours	Indenfinite	8 hours
35ºC	3 hours	12 hours	12 hours	Indenfinite	4 hours

Application Method Brush/Roller, Conventional Spray and Airless Spray.
Mixing Ratio (by volume) 1 Parts Resin to 1 Parts Cure.
Thinner Thinner No. 2.
Airless Spray
Nozzle Size : 0.48-0.58mm (19-23 thou)
Fan Angle : 80º
Operating Pressure : 110-160 kg/cm² (1600-2300 psi)

Conventional Spray
Nozzle Size : 1.27mm (50 thou)
Atomising Pressure : 3.5 kg/cm² (50 psi)
Fluid Pressure : 0.7-1.0 kg/cm² (10-15 psi)

Brush This product is suitable for brush application for small areas and for touch up purpose.
Roller This product is suitable for roller application.


Application Method

65° Spraying Tip


Pratice Proper Cleaning

GOLDEN ASIA AWARD FOR EXCELLENCE

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APPLICATION CONDITIONS AND OVERCOATING

This product should preferably be applied at temperature in excess of 10ºC, In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3ºC above the dew point.
At application temperature below 10ºC, drying and curing time will be significantly impaired. **Application at temperature below 5ºC is not recommended.**
The maximum air and substrate temperature for application is 40ºC providing conditions allow satisfactory application and film formation. If the air and substrate temperature exceed 40ºC and epoxy coatings are applied under this condition result paint film defects such as dry spray, bubbling and pinholing etc. can occur within the coating.
If it is desired to overcoat outside the times stated on the data sheet, please seek advice from **Alspec** representative.

PHYSICAL DATA:

Volume Soild	77%
Theoretical Coverage	5.15 m²/litre @ 150 microns DFT
Type	2 components
Packing Ratio	2.5 litres Resin : 2.5 litres Cure
Colour Availability	Aluminium and limited colour range
Flash Point	41ºC (mixed)
Recommended Thickness	150 microns DFT
Recommended Thinner	Thinner No. 2

SURFACE PREPARATION:

Steel : Remove all wax, oil and grease by solvent cleaning in accordance with the guideline given by SSPC-SP1.
Soluble salt, dirt and dust must be removed prior to coating, Dry brushing should be suffiecient. Afresh water wash must be followed to remove all soluble salts.
Mechanically clean the surface using hand and power tools to a minimum standard of St.2 (ISO8501-1:1988) or SSPC-SP2 to avoid polishing the surface.