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

425 COAL TAR EPOXY

PRODUCT DATA:

- ***Excellent Anti-Corrosive Property***
- ***Excellent resistance to moisture***
- ***Excellent resistance to crude oil immersion***
- ***Good resistance to chemicals, abrasion and weather***
- ***Most suitable use as a finish coating for surfaces in contact with fresh salt water***

PRODUCT INFORMATIOM

Designed to provide protection of steel/concrete pipelines for harbour and shore installtions. An anti-corrosive protection coating for submerged and semi-submerged marine environment application areas : piling, jetties and dock gates.
Also used as internal tank lining for crude oil storage tanks.

APPLICATION:

PRACTICAL APPLICATION RATES

Micron Per Coat	Airless Spray	Brush
Dry	125	75
Wet	212	127

AVERAGE DRYING TIME

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		Potlife
			Minimum	Maximum	
15ºC	8 hours	24 hours	24 hours	3 days	12 hours
25ºC	4 hours	16 hours	16 hours	3 days	6 hours
35ºC	2 hours	8 hours	8 hours	3 days	3 hours

Application Method Brush and Airless Spray.
Mixing Ratio (by volume) 3 Parts Resin to 2 Parts Cure.
Thinner Thinner No. 5 (maximum 5% addition)
Thinner Consumption Brush – 0-5%
Air Spray – 0-5%

Airless Spray
Nozzle Size : 0.53-0.66mm (21-26 thou)
Fan Angle : 80º
Operating Pressure : 150 kg/cm² (2200 psi)

Brush This product is suitable for brush application. Applicationof minimum two coats to give an even application and ensure consistent performance.


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	59%
Theoretical Coverage	4.7 m²/litre @ 125 microns DFT
Type	2 components
Packing Ratio	3.0 litres Resin : 2.0 litres Cure
Colour Availability	Black
Flash Point	36ºC (mixed)
Recommended Thickness	125 microns DFT
Recommended Thinner	Thinner No. 5

SURFACE PREPARATION:

Steel : Remove all wax, oil and grease by solvent cleaning in accordance with the guideline given by SSPC-SP1.
When necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
Abrasive blast clean to a minimum Sa2.5 of ISO8501-1:1:1988
Any surface defects revealed by blast cleaning should be grounded, filled or treated in a suitable manner.
An average surface profile of 50 microns is acceptable but this average surface profile should not exceed 75 microns.
After blasting, all dust must be removed from the surface prior to coating application.
Noted: This product should be applied to a surface that has been blast cleaned. It can be applied either directly to steel or to a suitably primed surface.

Concrete
To ensure the surface is sound prior to coating. Remove laitance by thorough wire-brushing, acid etching or sweep blasting. Blowholes and other defects should be filled with solventless epoxy filler. This product may be applied direct to the clean sound concrete surface providing the first coat is thinned.

Aluminium
The surface should be degreased and abraded with thinner and wet or dry sand paper before the application. If the primer shows signs of breakdown then a full sweep blast may be required prior to coating application.