

429 GLASS FLAKE EPOXY

PRODUCT DATA:

- ◆ *Excellent Anti-Corrosive Performance*
- ◆ *Excellent resistance to immersion in sea water*
- ◆ *Excellent resistance to moisture*
- ◆ *Moderate resistance to corrosive chemicals (acid/alkali)*
- ◆ *Moderate resistance to petroleum solvents and aliphatic solvents*
- ◆ *Excellent resistance to abrasion and weather*

PRODUCT INFORMATION

Designed to be a anti-corrosive self priming coating of blast cleaned structures surfaces and also as a maintenance coating where abrasive blasting is not possible.

The barrier effect of the glass flake makes this product a highly corrosion resistant protective coating.

Suitable for use on cathodically protected steel. For immersed structures a suitable primer may be required.

APPLICATION:

PRACTICAL APPLICATION RATES

Micron Per Coat	Airless Spray
Dry	200
Wet	222

AVERAGE DRYING TIME

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		Potlife
			Minimum	Maximum	
15°C	12 hours	24 hours	24 hours	10 days	1.5 hours
25°C	8 hours	16 hours	16 hours	8 days	1 hours
35°C	6 hours	12 hours	12 hours	4 days	1 hours

Application Method Airless Spray.
Mixing Ratio (by volume) 3 Parts Resin to 1 Parts Cure.
Thinner Thinner No. 2. (Maximum 5% addition)

Airless Spray Nozzle Size : 0.38-0.53mm (18-21 thou)
 Fan Angle : 65°
 Operating Pressure : 210 kg/cm² (3000 psi)



65° Spraying Tip



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APPLICATION CONDITIONS AND OVERCOATING

This product should preferably be applied at temperature in excess of 10°C, In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point.

At application temperature below 10°C, drying and curing time will be significantly impaired.

Application at temperature below 5°C is not recommended.

The maximum air and substrate temperature for application is 40°C providing conditions allow satisfactory application and film formation. If the air and substrate temperature exceed 40°C 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.

In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10°C during curing.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice from **Alspect** representative.

PHYSICAL DATA:

Volume Soild	90%
Theoretical Coverage	4.5 m ² /litre @ 200 microns DFT
Type	2 components
Packing Ratio	3.75 litres Resin : 1.25 litres Cure or 2-5 litres Resin : 2.5 litres Cure
Colour Availability	Selected Colour Range
Flash Point	31°C (mixed)
Recommended Thickness	200 microns DFT
Recommended Thinner	Thinner No. 2

SURFACE PREPARATION:

Steel : Abrasive blast clean to a minimum standard of Sa2.5 (ISO8501-1:1988) or SSPC-SP10. For optimum performance and for highly corrosive conditions, blasting to Sa3/First Quality or SSPC-SP5 is recommended.

Average surface profile of 50-75 microns is required.

The surface to be coated must be clean and dry and free from all visible traces of surfaces contaminants.