

PRODUCT DESCRIPTION

A High Build Epoxy polyamide coating with good resistance properties. The product is formulated using high quality inert pigments.

- This product is also available in micaceous iron oxide (MIO) version.
- It can be applied as a build coat for structural steel work in aggressive environments.
- Good resistance to fresh and salt water.
- High film builds in one coat.
- Low water permeability.

DESIGNED USE

- High build epoxy for the protection of steel and concrete.
- Suitable for application to structural steel, pipe exterior, tank exterior in moderate polluted area.
- Suitable as intermediate / undercoat for upto C5 Environment as per ISO12944 Part 2 along with suitable topcoats

PHYSICAL DATA

VOLUME SOLIDS (based on ASTM D2697)	80% $\pm$ 2%
TYPICAL DRY FILM THICKNESS	125 microns
WET FILM THICKNESS	160 microns
THEORETICAL COVERAGE	6.4 m ² /litre @ 125 microns DFT
VOC "As Supplied" (Based on ASTM D3960)	185 gms/ltr
COLOUR	Off White, Grey, MIO Grey
FINISH	Low Sheen

APPLICATION DETAILS

METHOD OF APPLICATION:

AIRLESS SPRAY

This is the recommended method of application:
Maximum 5% Thinner may be added.
Tip Size: 0.43-0.53 mm (0.017-0.021 in)
Pressure: 110-160 kg/cm² (1600-2300 psi)

CONVENTIONAL SPRAY

This is also a suitable method of application. Maximum 20% Thinner may be added
Tip Size: 1.80 mm - 2.20 mm (0.071-0.087 in) Pressure: 40-50 psi (2.75-3.45 kg/cm²)

BRUSH OR ROLLER

May be used for difficult shapes or touch-up; however additional coats may be required to achieve the recommended film thickness. It is recommended for stripe coating welds, edges, rivets etc.

DRYING TIME:

Surface Temperature	Touch Dry	Hard Dry	Over coating Interval		Pot Life min.
			Minimum	Maximum	
15°C	3 Hrs	24 Hrs	16 Hrs	7 Days	4 Hrs
25°C	2 Hrs	14 Hrs	8 Hrs	5 Days	2½ Hrs
35°C	1 Hr	8 Hrs	4 Hrs	3 Days	1½ Hrs
45°C	40 minutes	4 Hrs	2 Hrs	1 Days	30 minutes

NO. OF COMPONENTS

Two

Mixing Ratio

7 parts Base to 1 Part Hardener (by volume)

Application Conditions

Do not apply this product if the Relative Humidity exceeds 85% or if the substrate temperature is within 3°C of the dew point

ADDITIONAL INFORMATION

Thinner / Cleaning solvent	Solvalux 7-45
Storage Instruction	Store in a cool shaded dry area
Flash Point	Mixed 30°C
Packaging	20 Liters
Shelf Life	24 months from the date of manufacture.

SURFACE PREPARATION

This product should be applied to a surface that has been blast cleaned and suitably primed (e.g. with EPILUX or ZINCANODE Primers)

- Remove all wax, oil and grease by solvent cleaning in accordance with the guide lines given by SSPC-SPI.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- Surface to be coated should be free from contaminant like dew, or amine blush. Remove dust from the surface by air blow or dry wiping.
- ALUMINIUM: Degrease and abrade with Solvalux 7-45 and wet-or-dry paper. Apply LUXAPRIME 1500 followed by one coat of suitable EPILUX primers.
- **GI Surface:** Can be applied directly over suitably sweep blasted GI structures.

PRODUCT USE INSTRUCTIONS

- As common with all epoxy coating, this product will chalk on exposure to direct sunlight.
- If maximum over coating time is likely to be exceeded, apply a “tie coat”
- This product needs to be necessarily over-coated with suitable 2 pack or single pack Berger Products.
- Dry heat resistant up to 120°C
- May also be applied between 75 and 200 Microns DFT
- Contact Berger Representative for suggesting suitable paint system

SAFETY PRECAUTIONS

- Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust masks and gloves. Use a barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapor or spray.
- This product is flammable. Keep away from sources of ignition. Do not smoke. Take precautionary measures against static discharge. In case of fire – blanket flames with foam, carbon dioxide or dry chemicals
- Refer to MSDS for further information.