

PEACOPOXY SEALER

Product Code: 6523

Date: Sept 2012 (Page 1 of 2)

PRODUCT INTRODUCTION

- Two component micaceous iron oxide pigmented polyamide cured epoxy sealer/coating
- Used as a primer, sealer or coating
- Excellent adhesion to and sealing of weathered, cleaned Zinc rich primers and Zinc sprayed steel
- Good adhesion characteristics for subsequent coats
- Excellent adhesion to blast cleaned steel
- Can be used in systems for atmospheric or water immersed exposure conditions
- Good resistance to industrial or chemical contaminated atmospheric exposure conditions
- Good abrasion and impact resistance
- Resistant to temperature up to 200°C in dry atmospheric exposure conditions

PHYSICAL PROPERTIES

| | |
|--------------------------------|--|
| Colours and gloss | Yellow |
| Mass density | approx. 1.8g/cm ³ |
| Solids content (by volume) | approx. 75% |
| VOC | 240 g/litre |
| Recommended dry film thickness | 50-100 µm |
| Theoretical spreading rate | 15.0 m ² /l for 50µm 10.0 m ² /l for 75µm 7.5 m ² /l for 100µm 6.0 m ² /l for 125µm |
| Touch dry | 2.5 hours |
| Overcoating interval | min. 10 hours max. 1 month |
| Fully cured | 6 days |

| | |
|--------------------------------|--------------------|
| Shelf life(cool and dry place) | at least 12 months |
|--------------------------------|--------------------|

| | |
|-------------|-------------------------------|
| Flash point | base 26°C, hardener 29.5°C |
|-------------|-------------------------------|

APPLICATION CONDITIONS AND TEMPERATURE

- Previous coat; dry and free from any contamination
- Substrate temperature must be above 10°C during application and curing and at least 3°C above dew point
- For atmospheric exposure conditions the minimum substrate temperature for application may be 5°C, but at low temperature the curing slows down according to the overcoating and curing tables

Steel; blast cleaned to ISO-Sa2½

Zinc primed steel: free from any contamination and Zinc salts

Galvanized steel; of atmospheric exposure conditions is sanding, free from any contamination and Zinc salts; for water immersed exposure conditions sweep blasting is required

Shop primed steel; sweep blasted to SPSS-Ss or power tool cleaned SPSS-Pt3

Remark

When used as an adhesion primer or when a long overcoating interval is expected a max. Dft of 50 µm must be specified in order to reserve the rough texture

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APPLICATION INSTRUCTION

Mixing ratio

base to hardener 7.8:1 *by weight*

base to hardener 9 :2 *by volume*

- The temperature of the mixture of base and hardener should be above 15°C, otherwise extra solvent may be required to obtain application viscosity
- Too much solvent results in lower sag resistance and slower cure
- Thinner should be added after mixing the components

| | AIR SPRAY | AIRLESS SPRAY |
|----------------------------|---|---|
| Recommended thinner | Thinner 066 (flash point 26°C) | Thinner 066 (flash point 26°C) |
| Volume of thinner | <30% | <10% for dft 100 µm <20% for dft 50 µm |
| Nozzle orifice | 1.5-2 mm | 0.43-0.53 mm |
| Nozzle pressure | 0.3-0.4MPa (approx. 3-4 at; 43-57 P.S.I.) | 12-15MPa (approx. 120-150 AT; 1700-2100 P.S.I.) |

BRUSH AND ROLLER

| | |
|----------------------------|-------------------------------|
| Recommended thinner | Thinner 066(flash point 26°C) |
| Volume of thinner | <5% |

CLEANING SOLVENT

Thinner 068(flash point 30°C)

OVERCOATING TABLE

| substrate temperature (°C) | 5 | 10 | 20 | 30 | 40 |
|------------------------------------|--------|--------|--------|--------|--------|
| minimum interval dft 50 µm | 30 hrs | 14 hrs | 10 hrs | 8 hrs | 6 hrs |
| minimum interval dft 100 µm | 2 days | 28 hrs | 16 hrs | 12 hrs | 10 hrs |
| maximum interval (days) | 28 | 28 | 28 | 14 | 2 |

surface should be dry and free from any contamination

CURING TABLE

| substrate temperature | touch dry | dry to handle | full cure |
|-----------------------|-----------|---------------|-----------|
| 5°C | 10 hours | 40 hours | - |
| 10°C | 7 hours | 36 hours | 15 days |
| 15°C | 5 hours | 30 hours | 9 days |
| 20°C | 2.5 hours | 24 hours | 6 days |
| 30°C | 4 hours | 20 hours | 5 days |

| | POT LIFE (AT APPLICATION VISCOSITY) | INDUCTION TIME |
|------|-------------------------------------|----------------|
| 10°C | 10 hours | 20 min. |
| 20°C | 8 hours | 10 min. |
| 25°C | 6 hours | 5 min. |
| 30°C | 5 hours | - |
| 35°C | 4 hours | - |