

PEACOPOXY ST-C COATING FD

Product Code: 6544FD

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PRODUCT INTRODUCTION

- Two component high build polyamine cured modified epoxy primer/coating
- Used as primer/coating for those surface can not be well prepared by sand blasting or extensive derusting. (Surface tolerant)
- Compatible with various aged coatings
- Good recoatability with epoxy-, Polyurethane- and most chlorinated rubber-, alkyd- and acrylic paints
- Excellent corrosion resistance
- Resistance to splash of a wide range of chemicals

PHYSICAL PROPERTIES

Colours and gloss	Green, Grey, Redbrown, White
Mass density	approx. 1.4g/cm ³
Solids content (by volume)	approx. 86%
VOC	226 g/litre
Recommended dry film thickness	125-250 µm
Theoretical spreading rate	8.6 m ² /l for 100µm 6.8 m ² /l for 125 µm 3.4 m ² /l for 250 µm
Touch dry	2.5 hours
Overcoating interval	min. 10 hours max. 5 months
Fully cured	4 days
Shelf life(cool and dry place)	at least 12 months
Flash point	base 31°C, hardener 45°C

APPLICATION CONDITIONS AND TEMPERATURES

- Power tool or hand tool clean to SSPC-SP2 & SSPC-SP3 or ISO St2 & St3 to remove loose rust, scale and deteriorated coatings.
- Substrate temperature should be above 5°C and at least 3°C above dew point.
- Maximum relative humidity during application and curing is 85°C.

APPLICATION INSTRUCTION

mixing ratio

base to hardener 86:14 *by weight*

base to hardener 80:20 *by volume*

- The temperature of the mixture of base and hardener should be above 10°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	<10%	<5%
Nozzle orifice	2.0 mm	0.48-0.53 mm
Nozzle pressure	0.4MPa (approx. 3-4 at; 43-57 P.S.I.)	15MPa (approx. 150 AT; 1700-2100 P.S.I.)

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BRUSH AND ROLLER

Recommended thinner Thinner 066(flash point 26°C)

Volume of thinner <5%

OVERCOATING TABLE

substrate temperature (°C)	5	10	20	30	40
minimum interval (hours)	33	16	10	5	3
maximum interval (months)	5	5	4	3	3

CURING TABLE

substrate temperature	touch dry	dry to handle	full cure
5°C	14 hours	33 hours	15 days
10°C	10 hours	16 hours	10 days
15°C	5.5 hours	13 hours	6 days
20°C	2.5 hours	8 hours	4 days
30°C	2 hours	5 hours	3 days
40°C	1 hours	3 hours	2 days

POT LIFE (AT APPLICATION VISCOSITY)

15°C	4 hours
20°C	2.5 hours
30°C	1.5 hours
40°C	1 hours

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