

# PEACOPOXY TARCOAT (Marine Grade)

Product Code: 6531

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## PRODUCT INTRODUCTION

- Two component high build polyamine cured coal tar epoxy coating
- Used as build coat for underwater and water immersion area
- Good resistance against chemically polluted water
- Can be applied and cures at low  $-5^{\circ}\text{C}$
- Good abrasion resistance
- Can be spray up to  $500\text{ }\mu\text{m}$  at overlaps without sagging
- Resistant to well designed cathodic protection

## PHYSICAL PROPERTIES

Colours and gloss	Brown and Black - eggshell
Mass density	approx. $1.5\text{ g/cm}^3$
Solids content (by volume)	approx. 73%
Recommended dry film thickness	$125\mu\text{m}$ - $500\mu\text{m}$
Theoretical spreading rate	$5.8\text{m}^2/\text{l}$ for $125\mu\text{m}$ $2.9\text{m}^2/\text{l}$ for $250\mu\text{m}$ $2.4\text{m}^2/\text{l}$ for $300\mu\text{m}$ $1.8\text{m}^2/\text{l}$ for $400\mu\text{m}$ $1.5\text{m}^2/\text{l}$ for $500\mu\text{m}$
Touch dry	3 hours
Overcoating interval	min. 5 hours max. 13 days
Shelf life(cool and dry place)	at least 12 months
Flash point	base $26^{\circ}\text{C}$ , hardener $26^{\circ}\text{C}$

## APPLICATION CONDITIONS AND TEMPERATURE

- Substrate temperature should be at least  $3^{\circ}\text{C}$  above dew point
- In order to obtain the maximum resistance against chemical and mechanical influences the substrate temperature should be above  $5^{\circ}\text{C}$  during application and curing

### *For under water area, with cathodic protection*

- Steel; blast cleaned to ISO-Sa2.5, blasting profile; (Rz)  $49\text{-}70\mu\text{m}$
- Steel; with Zinc Silicate shop primer; sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt3
- Existing coal tar epoxy coating; sufficiently roughened and free from any contamination

### *For under water area, without cathodic protection*

- Steel; blast cleaned to ISO-Sa2.5, blasting profile; (Rz)  $49\text{-}70\mu\text{m}$
- Steel; with approved shop primer; sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt3
- Existing coal tar epoxy coating; sufficiently roughened and free from any contamination

### *For above water area*

- Steel; blast cleaned to ISO-Sa2.5, blasting profile; (Rz)  $49\text{-}70\mu\text{m}$
- Steel; with approved shop primer; sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt3
- Existing coal tar epoxy coating; sufficiently roughened and free from any contamination

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## APPLICATION INSTRUCTION

### *mixing ratio*

base to hardener 90: 10 *by weight*

base to hardener 85: 15 *by volume*

- The temperature of the mixed 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
<b>Recommended thinner</b>	Thinner 070 (flash point 26 °C)	Thinner 070 (flash point 26 °C)
<b>Volume of thinner</b>	<10%	<5% for dft 250 µm <15% for dft 125 µm
<b>Nozzle orifice</b>	1.5-3 mm	0.48-0.53 mm
<b>Nozzle pressure</b>	0.2-0.4MPa (approx. 3-4 at; 43-57 P.S.I.)	15MPa (approx. 150 AT; 1700-2100 P.S.I.)

### BRUSH AND ROLLER

<b>Recommended thinner</b>	Thinner 070(flash point 26 °C)
<b>Volume of thinner</b>	<5%

### CLEANING SOLVENT

Thinner 068(flash point 30 °C )

## OVERCOATING TABLE FOR DFT UP TO 250µm

<b>substrate temperature (°C)</b>	5	10	15	20	30
<b>minimum interval (hours)</b>	20	15	10	5	4

## PEACOPOXY TARCOAT and PEACOPOXY TARSEALER

<b>maximum interval (days)</b>	24	24	18	13	10
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### *others*

- |                                |    |    |   |   |   |
|--------------------------------|----|----|---|---|---|
| <b>maximum interval (days)</b> | 25 | 15 | 9 | 5 | 3 |
|--------------------------------|----|----|---|---|---|
- Then overcoated with other paints, tar bleeding will occur
  - Then overcoating work is to be carried out on coats thicker than 250 µm applied in one coat, the minimum overcoating interval must be Extended as follows;  
For 300 µm ; 2 times as long  
For 400 µm ; 3 times at long  
For 500 µm ; 4 times as long
  - Adequate ventilation is required during application and curing

## CURING TABLE FOR DFT UP TO 250 µm

<b>substrate temperature</b>	<b>for underwater area and slightly polluted atmosphere</b>	<b>for underwater and polluted water or crude oil</b>
	<i>initial cure</i>	<i>full cure</i>
5 °C	80 hours	-
10 °C	42 hours	14 days
15 °C	28 hours	9 days
20 °C	20 hours	6 days
30 °C	18 hours	3 days
40 °C	12 hours	2 days

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	POT LIFE (AT APPLICATION VISCOSITY)	INDUCTION TIME
15 °C	8 hours	30 min.
20 °C	6 hours	15 min.
25 °C	5 hours	10 min.
30 °C	4 hours	-
35 °C	2 hours	-

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