



Paints Limited

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FOR SALES & TECHNICAL SUPPORT

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Product Name:	EPIDAC 2 HS RED OXIDE – ITEM 111
Reference Number:	90-199
Coating Type:	High solids epoxy with zinc phosphate rust inhibitor (<u>with low temperature curing properties</u>).. Compliant To Environmental Protection Act (1990) (Clause 20(d), Guidance Note PG6/23 (97)
Typical Uses:	Long term protection of steel
Colours Available:	Red Oxide
Appearance Of Dried Film:	Low sheen finish.
Volume Solids:	70%.
Dry Film Thickness:	Typical: 75 microns. Range: 70-150 microns.
Theoretical Coverage:	9.3m ² per litre at 75 microns dry film thickness.
Drying Time At 20°C: (Will Vary With Temperature, Air Movement etc.).	Touch Dry: 2-3 hours. Firm Dry: 6 hours. Overcoat: 6 hours with epoxy or polyurethane finishes.
V.O.C.	246 grams/litre.
Packaging:	5 litre composite pack.
Shelf Life:	2 years or longer in unopened containers when stored under cover in good storage conditions.
Storage:	Under cover within temperature range of 5°C to 32°C.
Surface Preparation:	<u>Steel</u> Abrasive blast to ISO 8501-1 to SA 2.5 grade.

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Application Conditions:**Humidity**

Do not apply at relative humidities above 90%. Substrate temperature must be at least 3°C above dew point.

Temperature

Do not apply at temperatures below 5°C.

Note: Epidac 2 HS Primer will cure at temperatures down to 0°C, however at temperatures below 15°C, the base and hardener will thicken considerably and affect application characteristics. At low ambient temperatures we would advise that base and hardener are warmed separately to 20°C before use to ensure optimum application properties.

Effect of Temperatures on Drying/Overcoating Times

		5°C	10°C	20°C	30°C
	Surface Dry	6 Hours	3 Hours	2 Hours	1 Hour
	Hard Dry	10 Hours	6 Hours	4 Hours	2 Hours
Overcoating Times	Minimum	10 Hours with Epoxy Coatings	6 Hours with Epoxy Coatings	4 Hours with Epoxy Coatings	2 Hours with Epoxy Coatings
	Maximum (Without Abrading)	10 Days	7 Days	5 Days	3 Days

Mixing: Due to the high solids content of this product, it is essential to use a power stirrer for mixing prior to application. The addition of the curing agent at the commencement of the mixing process will considerably ease this operation.

Application:

Apply by brush or airless spray.

Airless Spray

Tip size: 15-17 thou (0.38 mm to 0.43 mm).

Tip pressure: Not less than 2000 psi (135 Bar).

Brush

Apply to the specified wet film thickness using a "full" brush. Do not 'brush-out' or 'lay-off'.

(A wet film thickness of approximately 110 microns will give a dry film thickness of 75 microns.)

Usable Pot Life (at 20°C)

2 hours.

Mixing Ratio By Volume

3 part Base : 1 part Activator.

Clean-Up:

Dacrylate Thinner R5.

Health And Safety:

Please see relevant MSDS sheet.

Data sheets are issued to supply **general information** on the product but without warranty. Since conditions of service and application are beyond our control we cannot accept claims for loss, damage etc., based on this information. Dacrylate will not accept any claim for consequential or incidental damages.

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LD/DAE/WHC