

APCODUR CF 699



PRODUCT DESCRIPTION

Two components, self-priming, high build, polyamine adduct cured epoxy coating

FEATURES & RECOMMENDED USE

- Designed as a tank lining for storage of fresh & salt water, brine, sweet and sour crude, other refined petroleum products and solvents
- Excellent chemical resistance
- Can be used for potable water tanks
- Self-priming coating

TECHNICAL DATA

Colour	Off White and Greys
Gloss	Eggshell
Volume Solids	Approx. 60%
Recommended DFT / Coat	75 - 125 μm
Theoretical Coverage Capacity	8.0 sq.mtr/ ltr @ 75 μm DFT 4.8 sq.mtr/ ltr @ 125 μm DFT
Drying time at 30°C	Surface Dry : 2 hours Hard Dry : 12 hours Full cure : 7 days
Over coating interval at 30°C	Min : 12 hours Max : 5 days, provided surface is dry and clean from all contamination.

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances. The volume solids indicated are as per ASTM D 2697 air drying method. The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc. The information provided above is at 30°C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General

- Can be applied directly over blasted steel substrate
- Suitable epoxy primer (Apcodur CP 689 / Apcodur CP 682); dry and free from all contamination
- In case of recoating interval exceeds 5 days, the painted surface should be thoroughly roughened & cleaned well prior to painting
- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming
- Where necessary remove weld spatter, weld seams and sharp edges prior to application of primer

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of primer, the surface should be re-blasted
- A blasting profile of (Rz) 50-75 µm is recommended
- Any surface defect revealed by the blast cleaning process should be corrected or treated appropriately (grinding, filling etc.)

For New concrete surface

- Ensure that the concrete surface is cured for minimum 3 months
- In case of large areas and for severe exposure conditions, the surface has to be prepared by light blasting. In less critical areas where blasting is not practical, wire brushing has to be adopted to remove lattices, followed by treating with dilute (10%) hydrochloric acid
- Remove acid and contaminants by liberal wash with water. Ensure that acid solution does not retain on the surface & joints
- Allow the surface to dry thoroughly before applying primer

For Old concrete surface

- Remove the surface contaminants like grease, oil etc., by solvent wiping or by 10% caustic solution
- Preferably the surface has to be prepared by light blasting. In case, blasting is not practical, etch the surface to get a good profile by treating with dilute (10%) hydrochloric acid
- Remove acid and contaminants by liberal wash with water. Ensure that acid solution does not retain and penetrate through the joints and concrete surface
- Allow the surface to dry thoroughly before applying primer

Note: Surface should be thoroughly dried before application of primer. This will have a major influence on the performance of the coating

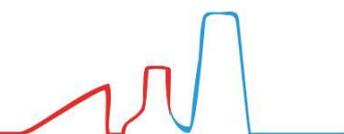
Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcodur CF 699 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base: Hardner 4 : 1
Induction Time	30 minutes
Pot Life at 30°C	3 hour



Application

Airless Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle Pressure Cleaning Thinner	T - 141 5 – 20 % * 0.41 - 0.46 mm (16 – 18 Thou) 20 – 24 MPa (= approx. 200 – 240 atm; 2800 - 3400 p.s.i.) T - 141
Brush / Roller Suggested only for stripe coating and small area applications Recommended Thinner Cleaning Thinner	T 141 T 141

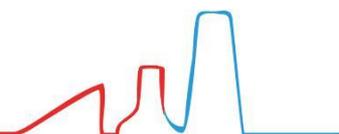
Note : 1) For single feed airless spray is advisable to use pump ratio 68 : 1
2) *Depending on recommended thickness & application condition

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Product Characteristics

- Full cure must be allowed prior to subjecting coating system to service conditions
- Product will tend to discolour on exposure to sunlight. Discoloration may also be visible on immersion and submerged conditions without affecting the performance
- For system recommendation or any specific query, please consult Asian Paints PPG technical representative
- The application parameters to be adjusted at site depending on line conditions
- In confined tank/areas, relative humidity to be controlled using de-humidification unit



PACK SIZE	20 L (Base : 16 L & Hardener : 4 L)
STORAGE	Shelf Life: At least 12 months at 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Base: Not less than 24°C, Hardener: Not less than 24°C VOC: Approx. 390 ± 20 gm/ltr as per USA-EPA Method 24 Product Weight: Approx. 1.36 ± 0.05 kg/ltr

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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