

APCODUR 141

PRODUCT DESCRIPTION

Two component, high solid, high build zinc phosphate based epoxy primer cum finish

FEATURES AND RECOMMENDED USE

- Suitable for New build Infrastructure application in areas like PEB's, metro & rail, airports, bridges etc.
- Self priming; eliminates the usage of primer
- Suitable as a touch up coat in projects for weld seams and damaged epoxy coating
- Good corrosion resistance and chemical resistance
- Can be over coated with epoxy & polyurethane topcoat
- Good adhesion to aged epoxy & polyurethane
- Available in MIO version for midcoat application

TECHNICAL DATA

Colour	Range
Gloss	Satin
Volume Solids	Approx. 80%
Recommended DFT / Coat	75 - 150 µm
Theoretical Coverage Capacity	10.7 sq.mtr/l @ 75 µm DFT 5.3 sq.mtr/l @ 150 µm DFT
Drying time at 30°C	Surface dry : 2 hours Hard dry : 5 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 5 hours Max. : 1 Month, 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.
For pastel shade, multiple coat may require for hiding purpose

DIRECTIONS FOR USE

Surface Preparation

General

- 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

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of Apcodur 141, the surface should be re-blasted
- A blasting profile of (Rz) 50-60 microns is recommended

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Instruction for use

- Apcodur 141 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
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (By volume)	Base : Hardener 5 : 1
Induction Time	15 minutes
Pot Life at 30°C	2 hours

Application

Brush / Roller <i>Suitable for stripe coating and small areas.</i>	
Recommended thinner	: T 141
Volume of thinner	: 0 - 10%*
Cleaning Thinner	: T 141
Airless Spray	
Recommended thinner	: T 141
Volume of thinner	: 0 - 10 %*
Nozzle orifice	: 0.33 - 0.53 mm (13 - 21 Thou)
Nozzle Pressure	: 20 - 24 MPa (= approx. 200 - 240 atm; 2800 - 3400 p.s.i.)
Cleaning Thinner	: T 141
Air Spray	
Recommended thinner	: T 141
Volume of thinner	: 10 - 20 %*
Nozzle orifice	: 1.6 - 2.0 mm
Nozzle Pressure	: 0.3 - 0.4 MPa (= approx. 2.96 - 3.94 atm; 44 - 58 p.s.i.)

*Note: Depending on recommended thickness & application condition

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment 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

- Maximum film build in one coat is best attained by airless spray. By brush application typical 75 microns is achieved in one coat and multiple coats will be required to achieve the total specified thickness
- The maximum performance is achieved after complete curing
- A minimum of two coats application is recommended over prepared surface
- Apcodur 141 is not recommended for immersion services
- for pastel/red/yellow/orange, thickness of minimum 120 µm is recommended
- As common to all epoxy, the product will chalk and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance
- Surface discoloration may occur upon exposure to sunlight, elevated temperatures or chemicals. However, this does not impact anti-corrosive performance
- Premature exposure to ponding water will cause a colour change
- Gloss & surface finish are dependent on the method of application
- For better colour & aesthetic stability, polyurethane / polysiloxane topcoat is recommended
- Application of stripe coat on welded/edges/crивices to be done before full coat application

PACK SIZE	20 L (Base : 16.67 L & Hardener : 3.33 L)
STORAGE	Shelf Life: Atleast 12 months @ 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. 210 ± 20 gm/l (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.60 ± 0.05 kg/l (depending on shades)

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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