

# APCOGUARD CF 707

## PRODUCT DESCRIPTION

Two component high build amine cured epoxy phenolic coating

## FEATURES AND RECOMMENDED USE

- Recommended as heavy duty tank lining for storage of products at an elevated temperature
- Excellent resistance to furnace oil, diesel, engine oil and wide range of petroleum solvents
- Designed as a tank lining for storage of brine, sweet and sour crude, other refined petroleum products and solvents
- Excellent corrosion resistance for steel work under thermal insulation subject to wet and dry cycles
- Suitable to exposure wet heat up to 150°C and dry heat up to 200°C
- Excellent abrasion and impact resistance

## TECHNICAL DATA

Colour	Greyish Black (Self Standard)
Gloss	Matt
Volume Solids	Approx. 70%
Recommended DFT / Coat	100 - 150 µm
Theoretical Coverage Capacity	7.0 sq.mtr/ ltr @ 100 µm DFT 4.7 sq.mtr/ ltr @ 150 µm DFT
Drying Time at 30°C	Surface Dry : 6 hours Hard Dry : 16 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 16 hours Max. : 5 days, provided surface is dry & cleaned 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:

- Suitable to apply directly over prepared bare steel. However it is suitable for application over epoxy primer (Apcodur HB Zinc Phosphate Primer)
- In case of aged epoxy coating, the surface should be roughened and cleaned thoroughly 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 or Apcoguard CF 707 directly, the surface should be reblasted
- 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

## Application Conditions

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

## Mixing

- Apcoguard CF 707 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 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.
- If required, thinner should be added after mixing the components. Addition of too much thinner will lead to reduced sag resistance.

<b>Mixing Ratio (by volume)</b>	Base : Hardener 5 : 1
<b>Induction Time</b>	10 minutes
<b>Pot Life at 30°C</b>	2 hours

## Application

<b>Airless Spray</b>	
Thinner	T 141
Thinner Intake	5 - 25%* by volume
Nozzle orifice	0.53 - 0.69 mm (21 - 27 Thou)
Nozzle pressure	20 - 24 MPa (= pprox. 200 - 240 atm; 2800 - 3400 p.s.i.)
Cleaning Thinner	T 141
<b>Brush/Roller</b>	
<i>Suitable for stripe coating and small areas.</i>	
Thinner	T 141
Thinner Intake	5 - 15%* by volume
Cleaning Thinner	T 141

\*Note: Depending on recommended thickness & application condition

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments 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 exposure of coating system to service conditions
- Product will tend to discolor on exposure to sunlight and immersion in certain chemicals/ solvents without affecting the performance
- Due to exothermic reaction, temperature after the mixing may increase. This will affect the pot life. Please ensure the mixed quantity is used immediately.
- As common with all epoxies Apcoguard CF 707 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti - corrosive performance. The actual rate of chalking will depend upon climatic conditions and will normally be limited to a thin surface layer
- The application parameters to be adjusted at site depending on line conditions
- In confined tank/areas, relative humidity to be controlled by using de-humidification unit
- Premature exposure to ponding water will cause a colour change
- Application of stripe coat on welded/edges/crивices to be done before full coat application
- For system recommendation or any specific query, please consult Asian Paints PPG technical representative

<b>PACK SIZE</b>	20 L (Base : 16.67 L & Hardener : 3.33 L)
<b>STORAGE</b>	<b>Shelf Life:</b> 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
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base : Not less than 25°C Hardener : Not less than 25°C <b>VOC:</b> Approx. 265 ± 20 gm/l as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.46 ± 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

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