

# APCOGUARD SF 725

## PRODUCT DESCRIPTION

Two component solvent free epoxy phenolic tank lining

## FEATURES AND RECOMMENDED USE

- Designed as a chemically resistant heavy duty tank lining to provide corrosion protection to the internals of steel storage tanks
- Excellent resistance to crude oil, lubricating/ furnace oils, alcohols, aromatic/ aliphatic solvents, gasoline blends, gasohol and refined petroleum products like petrol, diesel, kerosene, aviation fuel, MTO etc
- Excellent water resistance
- Self-Priming having excellent adhesion on blasted steel
- Certified to overall migration standard as per 21 CFR 175 - 300 of US - FDA by CFTRI India for potable water
- Very low VOC which eliminates the fire risk when applied in the confined area

## TECHNICAL DATA

Colour	Grey & Off White (Self Standard)
Gloss	Semi - glossy
Volume Solids	Approx. 100%
Recommended DFT / Coat	200 - 400 $\mu$ m
Theoretical Covering Capacity	5.0 sq.mtr/l @ 200 $\mu$ m DFT 2.5 sq.mtr/l @ 400 $\mu$ m DFT
Drying Time at 30°C	Surfacedry : 6 hours Hard dry : 16 hours Full cure : 7 days
Overcoating interval at 30°C	Min. : 16 hours Max. : 5 days, provided the surface is dry and 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)
- 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, smooth weld seams and sharp edges prior to application of primer or Apcoguard SF 725 directly

## 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 SF 725 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 (grinding, filling etc.)

## 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

## Instruction for use

- ApcoGuard SF 725 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
- If required, thinner can be added (up to 10% by volume) after mixing the components. Addition of excessive thinner will lead to reduced sag resistance

<b>Mixing Ratio (By volume)</b>	Base : Hardener 7 : 2
<b>Induction Time</b>	Nil
<b>Pot Life at 30°C</b>	45 minutes

## Application

<b>Airless Spray</b> Nozzle orifice Nozzle Pressure Cleaning Thinner	0.58 - 0.74 mm (23 - 29 Thou) 20 - 24 MPa (= approx. 200 - 240 atm; 2800 - 3400 p.s.i.) T 141  Note: For single feed airless spray it is advisable to use pump ratio 66:1
<b>Brush / Roller</b> <i>Suggested only for stripe coating and small areas.</i> Cleaning Thinner	T 141

## 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 mixing may increase. This will affect the pot life. Please ensure the mixed quantity is consumed immediately.
- The application parameters to be adjusted at site depending on line conditions
- The application by twin feed gun is recommended as pot life is very short. For smaller job and at low temperature, application with regular airless spray is possible
- 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
- 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

<b>PACK SIZE</b>	20 L (Base : 15.55 L & Hardener : 4.45 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 50°C Hardener : Not less than 50°C <b>VOC:</b> Approx. 60 ± 20 gms/l (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.70 ± 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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