

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 µm
Theoretical Covering Capacity	5.0 sq.mtr/ltr @ 200 µm DFT 2.5 sq.mtr/ltr @ 400 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. : 16hours 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

- To apply directly over prepared bare steel. However it is suitable for application over epoxy primer (Apcodur CP 682) epoxy intermediate
- 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 and 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 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.)

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be around 60 – 70%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- 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

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

Application

Airless Spray Nozzle orifice Nozzle Pressure Cleaning Thinner	0.64 - 0.89 mm (25 - 35 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
Brush / Roller (Suggested only for stripe coating and small areas) Cleaning Thinner	T 141

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 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
- 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
- In confined tank/areas, relative humidity to be controlled by using de-humidification unit
- For system recommendation or any specific query, please consult Asian Paints PPG technical representative

PACK SIZE	20 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 50°C Hardener : Not less than 50°C VOC: Approx. 60 gms/ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.65 kg/ltr (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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