



EPOXY TAR ENAMEL

PRODUCT DATA SHEET

EPOXY TAR ENAMEL is a three pack polyamide cured epoxy tar paint for the protection of steel. It is highly resistant to water and salt water and can be used on structures which are permanently exposed to high humidity levels. **EPOXY TAR ENAMEL** can be applied in thick coats for improved weather and corrosion resistance. It cures to a hard, tough film with good elasticity flexibility and adhesion. **EPOXY TAR ENAMEL** is not resistant to acids, petroleum products and strong solvents.

THIS IS A TWO PACK SYSTEM. MIX THE TWO COMPONENTS THOROUGHLY BEFORE USE. DO NOT USE THE BLEND AFTER THE POT LIFE LIMIT.

USAGE

- For long-life protection of mild and galvanised steel.
- For submerged structures and pipelines.
- In mild to highly corrosive environment.

Note :-

Condensation or dew formation on metallic surfaces will result in poor adhesion and subsequent flaking of the paint. Avoid painting during early morning, late evening or during humid and wet periods.

For specialised application such as internal tank linings, permanent immersion and other specific conditions, please contact your supplier for advice on product selection.

PHYSICAL DATA

- **Product Code :** 4803
- **Finish :** Semi-gloss
- **Colour :** Black
- **Consistency :** Viscous Liquid, mixed
- **Specific Gravity :** 1.2, (Approx.) mixed
- **Volume Solids :** 65% (Approx.), mixed
- **Flash Point :** < 23 °C, closed cup
- **Hardener :** **EPOXY TAR ENAMEL HARDENER.**
- **Mixing Ratio :** 1 part BASE / 1 part TAR / 1 part HARDENER, by volume (Mix the tar to the hardener then mix in the base)
- **Pot Life :** 4 - 5 hours at 25°C depending on volume of mix
- **Shelf Life :** 12 months, kept in separate containers.
- **Packing :** 20 L, 5 L, 2 L, 1L

Paints should be stirred before use and occasionally whilst in use.

Contact your supplier for further information

APPLICATION

- **Surface preparation** : See method SP 003/SP 003 A for mild steel and SP 004 for galvanised steel.
- **Application method** : Apply two to three coats by brush or by airless spray. Check or calculate the dry film thickness in order to confirm the number of coats required.
- **Dilution** : 5-10% **EPOXY THINNER** for ease of application.
- **Spreading rate / Film thickness** : One litre of **EPOXY TAR ENAMEL** can be applied at a spreading rate between 6 and 10 m² of surface in one coat ; at this spreading rate the dry film thickness will vary between 95 and 58 microns on a completely smooth, non absorbent surface.
- **Drying time** : Dry to touch in approximately 6 hours at 25°C.
- **Recoating intervals** :

SURFACE TEMPERATURE	20 °C	25 °C	30 °C
Dry film thickness, microns	150	150	150
Recoating interval, minimum	8 hours	6 hours	4 hours

Best intercoat adhesion is obtained when the next coat is applied on a slightly tacky previous coat.

Full cure will be achieved after approximately 7 days. After this stage, it is advisable to roughen the surface to promote intercoat adhesion. A clean surface is mandatory to ensure good intercoat adhesion. Bleeding may occur into subsequent coats whilst re-coating. This effect is only cosmetic and does not impair properties of the system.

- **Cleaning solvent** : **EPOXY THINNER**.
- **Preceding coat** : Self priming on mild steel. On galvanised steel use **HT 332 METAL PRIMER GREY** .
- **Subsequent coat** : Not required.

SAFETY

- **EPOXY TAR ENAMEL** is flammable, keep away from ignition source. Do not smoke whilst using.
- Wear adequate protective equipment during application, remove splashes from skin with soap and water. In case of contact with eyes, rinse with ample water and seek medical advice if necessary.
- Ensure good ventilation during application and drying.
- Keep containers tightly closed and away from children.
- A complete Material Safety Data Sheet is available on request.

MAINTENANCE

Hose with fresh water and detergent or wash under high pressure water to remove all traces of contaminants. Sand down with fine abrasive paper to ensure adhesion, dust off before applying **EPOXY TAR ENAMEL**.

These recommendations are meant as a guide, no guarantee is implied since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.