ROPOXY TAR HB 651

Description

two component high build poly amine adduct cured coal tar epoxy coating.

Principal Characteristics

- Easy to apply by spray, roller or brush.
- Good water and corrosion resistance
- Resistant to splash and spillage of mild chemicals and solvents
- Good adhesion properties on steel structures
- Suitable on wet blast cleaned substrates.
- Excellent corrosion resistance.
- Good resistance against chemically polluted water.
- Recognized corrosion control coatings.
- Resistance against temperatures up to 120 ºC in dry surroundings.

Technical data

Color & gloss	Black and brown / eggshell
Flash point (DIN 53213)	Base 25 ºC hardener 26 ºC.
Mass density	Approx. 1.5 gm / cm3
Solid content	Approx. 73% ± 2 by volume
Theoretical spreading rate	5 m2/ltr for 150 microns D.F.T.
	3.2 m2/ kg for 150 microns D.F.T.
Touch dry after	Approx. 3 - 4 hours
Recommended Dry film thickness	150 – 500 ums
Over coating interval	Min. 8 hours. max. 15 days.
Full cure after	7 days

Shelf life (cool and dry place)	At least 12 months
Recommended substrate conditions	❖ For immersion in water, with cathodic protection. • steel; blast cleaned to ISO- Sa 2.5. • steel with zinc silicate shop primer; sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt3. • Existing coal tar epoxy coating; sufficiently roughened and free from any contamination ❖ For immersion in water, without cathodic protection: • steel; blast cleaned to ISO- Sa 2.5. • steel with approved shop primer; power tool cleaned to SPSS-Pt2 or SPSS-Pt3. • Existing coal tar epoxy coating; sufficiently roughened and free from any contamination. ❖ For atmospheric exposure conditions: • steel; blast cleaned to ISO- Sa 2 or ISO-Sa2.5. • steel with approved shop primer; power tool cleaned to SPSS-Pt2 or SPSS-Pt3. • Existing coal tar epoxy coating; sufficiently roughened and free from any contamination.

In order to obtain the maximum resistance against chemical- and mechanical influences the substrate temperature should be above 5 ºC during application and curing.

- Application at temperatures down to –5 ºC is possible but curing to hardness takes considerably longer and complete resistance will be reached when temperature increases.
- Substrate temperature should be at least 3 ºC above dew point.
- If ROPOXY TAR HB 651 is applied in a one coat application at a D.F.T. of 400 – 500 microns, this must preferably be done on a preheated substrate of 40 ºC, in order to achieve faster curing, better solvent release and earlier resistance to handling.

Instruction for use

mixing rate by volume: base to hardener 86: 14

the temperature of the mixed base and hardener should be above 15 ºC other wise

extra solvent may be required to obtain application viscosity

- too much solvent results in lower sag resistance and slower cure.
- thinner should be only added after proper mixing of the base and hardener.

Induction time allow minimum induction time before use:

15 0C 30 min.

25 0C 10 min.

Pot life at 20 C 6 hours

Recommended thinner Roots Thinner No. RO10455 (flash point 26 °C)

Airless spray

Volume of thinner 0 -5 % depending on required D.F.T.

Nozzle orifice approx. 0.48 mm (= 0.019 inch)

Nozzle pressure 0.5 MPa (= Approx. 150 at; 2100 p.s.i)

Air spray

Volume of thinner 5-10 % depending on required D.F.T.

Nozzle orifice 1.5 – 3 mm

Nozzle pressure 0.3 – 0.4 MPa (= Approx. 3 - 4 at ; 43-57 p.s.i)

Brush / Roller

Volume of thinner 0-5 %

Cleaning solvent Roots thinner No. RO1003 (flash point 26 °C)

Additional data

Film thickness and spreading rate

theoretical spreading Rate	**m2/ltr**	5.7	2	1.5
	dft in um	125	400	500

Max. dft without sagging with airless spray : 650 um

Min. dft for closed film with airless spray : 80 um

Max. dft when brushing :125 um

Over coating table with Epoxy paint

substrate temperature	20 ºC	30 ºC	40 ºC
min interval .	6 hours	4 hours	3 hours
max interval .	5 days	3 days	2 days

Curing table	**substrate temperature**	Dry to handle	full cure handle
	30 ºC.	18 hours	3 days
	40 ºC .	12 hours	2 days

Pot life (at application viscosity)

30 ºC	4hours
40 ºC .	2 hours