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ISO 14001:2015 OHSAS 18001:2007 ISO 9001:2015



## Product Data Sheet and Application Instructions

TRPL

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### POLY GUARD - HBSFLE-FG-8248

#### BASE- 8248 -A with Hardener - 8248-B

**Description:** Poly Guard HBSFLE-FG-8248 is a solvent-free, two-component, high-build, Amine adduct cured epoxy paint, which cures to a coating with good resistance to fluids, such as portable water, sea water, crude oil, and to abrasion.

Applicable in thick coats by standard heavy duty airless spray equipment. Superior mechanical properties and excellent resistance water absorption with huge range of PH to transport water. Minimized surface flow resistance in cross countries pipelines with strong corrosion resistance.

#### Features:

- Abrasion and mild chemical resistant.
- Superior absorption resistance from fluids.
- Excellent and long life corrosion protection.
- Wide range of DFT in single run during heavy duty airless spray application.
- Excellent range with atmospheric as well as operation temperature.

**Recommended use:** As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Color retention will be of other importance. As an excellent lining strength to storage and transport of potable water through tanks and pipelines.

**Note :** Our product suitable for multi pass during continuous internal coating process to maintain desire uniform coating thickness.

#### Paint properties:

composition	Liquid epoxy suitable pigmented along with amine adduct.
Type	Two pack liquid epoxy cured with amine adduct.
color	Red and brown and as required standard.
Mixing ratio	Base : Hardener 3:1 By volume.
Pot life of mixed Material	2 to 5 Minutes at 65°C
Drying Time	Touch: 45 to 70 minutes. Stack : 2 to 4 hrs. Hard : Over Night
Full Cure Time	7 Days
Recommended WFT	250 TO 1000 Microns meter.
Theoretical spreading rate	10 m <sup>2</sup> /ltr @ 100 microns DFT. 1m <sup>2</sup> / ltr @ 1000 microns DFT

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Practical coverage	Allow appropriate loss factors.
Packing in metal barrels	Base : 15 liters and 200 liters Hardener : 5 liters and 200 liters
Finish	Smooth and glossy
Storage life	One year as long as sealed containers are kept under cover in a dry place with normal weather conditions.
Volume solid	100 percent
Flash point temp.	162°C (setaflash)
V.O.C	Nil

**Surface preparation:** All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

**Bare steel:** Cleanliness: Blast cleaning to min. SA 2 ½ (ISO 8501 1:2007). Roughness: using abrasives suitable to achieve Grade Medium G (50 - 75 µm, Rz scale) (ISO 8503-2).

**Other surfaces:** The coating may be used on other substrates. Please contact supplier office for more information.

**Condition during application:** The temperature of the substrate should be minimum 10°C and 3°C above the dew point of the air. Best coating adhesion is obtained by utilizing the induction time indicated after mixing of the two components and with relative Humidity below 85% during the application process. The temperature and the relative humidity should be measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until cured.

#### **Application methods:**

**Spray:** Use heavy duty multi components airless hot spray system with tip pressure minimum 200 bar.

**Brush and Roller:** Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness and uniform coated surface.

#### **Application method:**

Mixing 3 parts Comp. A (base) to be mixed thoroughly with 1 part Hardener, Comp. B (curing agent) through online static mixer and ensure paint shall be homogenous mixed before spray. It is must to 100 % ionization of spraying film during paint application.

**System cleaning:** Flush thoroughly the application equipment's with TRPL cleaning agent TH -8248 prior and after to application.





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**Pressure at nozzle:**

minimum 20 MPa (minimum 200 bars.)

**Nozzle tip sizes:**

35 to 43 thau.

**Spray angle:**

90° - 110°

**Filters size and cleaning procedure:** Filters should be removed, both in the pump and the spray gun after a certain frequency to avoid coating system chock-up and filters recommended sizes shall be 60 and 80 mesh to smooth and trouble free operation.

**Paint application temperature:** HBSFLE -FG -8248 Parts -A Base and Part-B Hardener shall be heat indirectly 65 to 95 °C as well as 60 to 85 °C respectively. Before transfer paint from main tank to application should be heat according above said temperature of part-A and part-B.

**Material Storage :** Material should be stored in shaded area and avoid direct sun light. Higher storage temperature cause a reduce self-life of epoxy paint. So, paint should be stored cool and shaded area.

**Note:**

- It is vital importance that the nozzle and other parts including static mixer of the spraying equipment are cleaned properly after the spray is done due to the short pot life high build liquid epoxy solvent less paint.
- The hoses should be used high temperature or heated hoses and pressure of good quality and no longer than necessary.
- Hose length between mixer and gun shall be less than 1.0 meter.
- Preferably store both paint components at ambient temperature. For stripe/repair coating, however, a lower paint temperature may be favorable, in order to get a sufficient pot life.

**Safety:** Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.

