



ICIINDI/4143/XX ICIINDI/4144/XX ICIINDI/4142/XX
ISO 14001:2015 OHSAS 18001:2007 ISO 9001:2015



TRPL

Poly Guard-HBWE-955

Product Name: Poly Guard-HBWE-955

Part A: 955

Base

Part B: 955

Hardener

Description: Poly Guard-HBWE-955 two component pure epoxy paint which cures to an abrasion and corrosion resistant coating. Suitable for application under humid conditions and for early water exposure.

Recommended Uses and features:

As a repair primer in severely corrosive environment. High build coating primarily for maintenance of e.g. jetty pilings, ballast tanks, splash zones, and ships' hulls.

- Tough and flexible.
- Excellent resistance from environment impact.
- Severely corrosive resistance.
- Weather proof protection.
- Petroleum storage tanks.
- Dam gates.
- Offshore drilling rigs.
- Penstocks.
- Liner for clarifiers.
- Non-potable water tank and pipe coatings.
- Marine applications.
- Heavy duty structural coating and moderately to severely corrosive environment such as sheet pilings, void spaces, chain lockers and waste water & sewage treatment plants etc.

Thakor Reductant Pvt. Ltd.

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Composition:	Suitable for application under humid conditions and for early water exposure.
Type	two component pure epoxy paint which cures to an abrasion and corrosion resistant coating.
color	Jet Black or any other required std.
Mixing ratio	Base: Hardener 4:1 By volume.
Pot life of mixed Material	1 hrs at 20 °C.
Drying Time: at 20 °C	
Touch Dry	3 to 4 hrs.
Hard Dry	7 hrs.
Full Cure Time	7 Days
Over coat interval	Minimum 7 hrs maximum 7 days
Indicated film thickness, dry:wet	350 micron : 425 micron
Theoretical spreading rate	2.4 m ² /ltr @ 350 microns
Packing in metal barrels	Base : 16 liters and 200 liters Hardener : 4 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	85±5percent
Flash point mixed.	35°C

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).

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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 5°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 200 to 230 bar.

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

Application data:

Mixing 4 parts Comp. A (base) to be mixed thoroughly with 1 part Hardener, Comp. B (curing agent) through online static mixer and ensure paint mixer shall be homogenous before spray. It should be 100 % ionization of spraying film during application on substrates.

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

Pressure at nozzle: 20 - 23 MPa (200 to 230 bar.)

Nozzle tip sizes: 35 to 43 thou depend on production rate.

Spray angle: 90° - 110°

Colours/Colour stability: Light shades will have a tendency to yellow when exposed to sunshine and darken when exposed to heat.

Weathering/service temperatures: The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

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Specialty of product: The product may be immersed after 4 hours of initial curing at 20°C/68°F. Curing will proceed under water. Early immersion may result in some discolouration. This does not affect the protective properties of the product.

Filters size and cleaning procedure: Filters should be clean, both in the pump and the spray gun after a certain frequency to avoid coating system chock-up and filters recommended sizes shall be 80 and 100 mesh to smooth and trouble free operation.

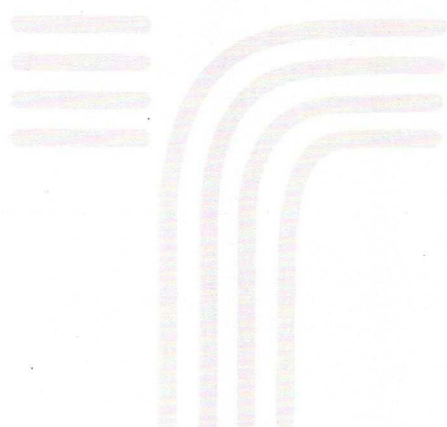
Paint transfer: High build epoxy Part -A Base and Part-B Hardener shall be

Heat indirectly 65 to 75 °C as well as 55 to 65 °C respectively before application of paint and passing through filters strainers without fail. Coating system shall be clean thoroughly after stoppage in case of 6 to 8 hrs. stay.

Note:

- It is of vital importance that the nozzle and other parts including static mixer of the spraying equipment are cleaned properly directly after the work is done due to the short pot life high build liquid coal tar epoxy paint.
- The hoses should be used high temp and pressure of good quality and no longer than necessary.
- Hose length between mixer and gun shall be maintained as much as minimum.
- Preferably store both paint components at 20 – 25 °C. We aware that higher storage temperature will shorten the life of the paint.
- 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.



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