



Polyguard E1669

EPOXY HIGHBUILD [F-6A]

Product Description A two-pack, low VOC, high solids, high build aromatic amine cured epoxy coating. Available with conventional pigmentation along with pigmented with micaceous iron oxide to provide enhanced overcoating properties and barrier protection.

Typical Uses Recommended for use as a self-primed paint system or as a high build Intermediate coat to improve barrier protection for steel structures, Piping, vessels, columns, reactors, pumps, compressors, exchangers, valves, Petrochemical plants, effluent treatment plants, Tanks, etc., and Industrial maintenance coatings. It is suitable for immersion service.

- Features**
- Superior absorption resistance from fluids
 - Excellent and long-life corrosion protection.
 - Wide range of DFT in a single run during heavy-duty airless spray application.
 - MIO gives better toughness and chemical resistance properties
 - Supplied in both MIO and non-MIO versions
 - Meets EIL specifications for F-6A

Technical Properties	Color / Shades	Grey, MIO, and a selected range of colors		
	Gloss	Matt / Eggshell Gloss		
	Volume Solids	57%		
	Specific Gravity	1.42 ± 0.03 Kg/L, mixed		
	Mix ratio	3:1 by volume		
	Typical Thickness	100-125 micron [4-5 mils] dry equivalent to 175-219 microns [7-8.6 mils] wet		
	Coverage	4.56 m ² /liter at 125 microns DFT (theoretical)		
	Flash Point (Typical)	35°C (95°F), mixed		
	VOC	< 248 g/L		
	Thinner/Cleaner	Thinner E1		
	Drying Time	Surface Temperature	30°C	
		Touch	3 Hours	
		Tack free	3-4 Hours	
	Hard dry	16 Hours		
	Cure to Service	7 days		
	Pot Life	3-6 Hours		

The drying times mentioned are based on a dry film thickness of 125 microns (5 mils) under standard conditions.



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Surface Preparation

All surfaces should be clean, dry, and free from contamination. The surface should be assessed and treated in accordance with ISO 8504:2000.

Iron & Steel

Abrasive blasting to Sa 2.5 Swedish Standards is the best method of surface preparation. In case blasting is not possible, then the surface of steel should be cleaned to St-2/5t-3 standard. The surface should be absolutely dry, moisture and oil-free before primer application.

Maintenance & Repair

- Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SSPC-SP6.
- Minor areas may be hand or power tool cleaned instead of abrasive blasting.
- Water jetting to min. Wa 2 (ISO 8501-4).
- Flash rust degree of maximum FR M (ISO 8501-4).
- Remove dust, blast media and loose materials.

Application

Application Method	Thinning	Application Parameters
Airless Spray	5-10%	Nozzle pressure: 225 bar [3300 psi] Nozzle orifice: 0.019 - 0.023
Brush / Roller	5-10%	Not Applicable

When using a brush or roller for application, you will need to apply additional coats to achieve the specified dry film thickness. The spray data given is only a guide and may require adjustments. The pressure measurements are based on a material temperature of 25°C (77°F).

Note

- Epoxy MIO Coating is supplied in two packs. Stir the base and Hardener separately. If settling is observed then mix it with the help of a Power-driven stirrer for quick and homogeneous mixing. Mix the 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.
- Thinner should be added after mixing the components and post the induction time.
- Addition of Thinner as per recommended approximately 5-10 %.
- Application will be done by following modes of method Conventional spray / Airless spray / Brush for small areas only
- Use off mixed paint within the stipulated pot life period.
- Use Thinner T1 for better results and product performance.
- Close the lid of containers tightly to avoid contact with atmospheric moisture.

Application Conditions

- Maximum relative humidity: 85%
- The material must be mixed at a minimum temperature of 13°C (55°F).
- The surface temperature should be at least 3°C above the dew point.



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Storage

Shelf Life

12 Months, unopened

Storage Conditions

Store indoors at 4.5°C [40°F] to 38°C [100°F]

The product must be stored in accordance with national regulations. Keep the containers in a cool and dry place and well-ventilated area with no direct source of heat or light. Containers must be kept tightly closed when not in use.

Safety: Handle with care. Before & 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 & 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.

Disclaimer: The information in this document is given to the best of TRPL's knowledge, based on laboratory testing & practical experience. TRPL products are considered semi-finished goods, as such products are often used beyond TRPL's control. TRPL can not guarantee anything but the quality of the product itself. Minor product variations may be implemented to comply with local requirements. TRPL reserves the right to change the given data without further notice. User should always consult TRPL for specific guidance on the general suitability of the product for their needs and specific application practices.