

## EPOXY FINISH

### PRODUCT DESCRIPTION

Product with a proven track record to give maximum protection against abrasion, solvents and chemicals in high wear and aggressive exposure conditions. Ideal for marine, industrial and chemical environments on steel and concrete. Polyamide cured two part epoxy system of medium-high build pigmented with light stable, chemically resistant and durable colours.

### USES

In conjunction with epoxy primers and intermediate coats, the product is suitable for metal fabrications, gas bottles, offshore structures, pipes, drainage systems and most steel and concrete surfaces.

### TECHNICAL PROPERTIES

<b>Colour</b>	RAL, BS 4800, BS 381C + Specials		
<b>Finish</b>	Full Gloss		
<b>Curing Agent</b>	Epoxy Standard Finish Curing Agent		
<b>Mix Ratio</b>	3 : 1 v/v		
<b>Specific Gravity</b>	1.1 typical		
<b>Volume Solids</b>	55% typical		
<b>Recommended Film Thickness</b>	91µm WFT / 50µm DFT		
<b>Theoretical Spreading Rate</b>	11m <sup>2</sup> /litre		
<b>Application Method</b>	Brush, Roller, Spray		
<b>Flash Point</b>	25°C		
<b>VOC</b>	400 g/litre		
<b>Drying Times</b>	<b>10°C</b>	<b>20°C</b>	<b>30°C</b>
Touch Dry	3 hours	2 hours	1 hour
Hard Dry	6 hours	4 hours	2 hours
Full Cure	5 days	3 days	3 days
Minimum Overcoat	12 hours	8 hours	4 hours
Maximum Overcoat*	Indefinite	Indefinite	Indefinite

\* Surface to be dry and free from contamination prior to overcoating. Best intercoat adhesion is achieved when subsequent coat is applied before preceding coat is fully cured. After prolonged exposure it may be necessary to roughen the surface to ensure intercoat adhesion.

### CERTIFICATION/APPROVALS

#### RECOMMENDED SYSTEMS

Epoxy Primers, Floorcote Epoxy Sealer

## SURFACE PREPARATION

- Steel:** Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blast cleaning to minimum SA2½. Power tool cleaning to minimum ST2. Please note that better surface preparation always results in longer lifetime expectations. Apply Epoxy Primer immediately after the steel has been blasted and the quality of preparation has been approved. Apply Epoxy Finish to recommended film thickness.
- Repair:** Existing systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating. Corroded and/or damaged areas should be power tool cleaned to ST2 or better or blast cleaned to SA2. Apply Bondon 115 as a surface tolerant epoxy primer followed by Epoxy Finish to recommended film thickness.

## PRODUCT APPLICATION

- Mixing** Mix 3.75 litres Base with 1.25 litres Curing Agent. Mix thoroughly, and allow 30 minutes prior to application. Pot life 3 hours @ 20°C.
- Thinners** Thinner No.5
- Brush** Suitable.
- Roller** Suitable.
- Conventional Spray** Thin with up to 10% Thinner No.5 Use 40-60 psi pressure and 1.4-1.8 mm diameter nozzle.
- Airless Spray** Thin with up to 5% Thinner No.5 Use 0.28-0.38 mm tip, 50-65° angle, and 2000-2500 psi pressure.
- Air Assisted Airless Spray** Thin with up to 10% Thinner No.5 Use 1000-1800 psi pressure and 1.4-1.8mm nozzle.
- Cleaner** Thinner No.5
- Cleanup Considerations** All equipment should be cleaned immediately after use with Thinner No.5  
It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied.  
Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

## HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited. The user must observe local health, safety and environmental regulations when using this product. Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

## PACK SIZES

5 litre composite packs

## PACK WEIGHTS

5 litre: 5.95 Kg.

## STORAGE CONDITIONS

Store in sealed containers at 10-25°C. Shelf life 18 months (unmixed).

## LIMITATIONS

Do not apply when RH exceeds 85% or the surface is less than 3°C above dew point.

## DISCLAIMER

The information given in these specifications and technical advice - whether verbal, or in writing or by way of trials is for guidance only and is given in good faith, but without warranty. This also applies where proprietary rights or third parties are involved. Any person using Spencer products without first making further enquiries as to the suitability of the products for the intended purpose and testing the products to assess their fitness for the purpose does so at their own risk. The application, use and processing of the products are beyond our control and are therefore your own responsibility, and we can accept no liability for the performance of the products arising out of such use, beyond the value of the goods delivered by us. The information contained in these data sheets is liable to modification from time to time in the light of experience and our policy of continuous development.

It is the user's responsibility to ensure that this sheet is current prior to using the product.