APCODUR MIO 410 HS / APCODUR 410

PRODUCT DESCRIPTION

Two components, high build, high solid epoxy polyamide composition pigmented with lamellar micaceous iron oxide

FEATURES AND RECOMMENDED USE

- Designed as an Intermediate coat providing excellent barrier protection in high performance coating system
- Excellent resistance to moisture and saline conditions
- Good resistance to water and splashes of mild chemicals
- Good abrasion resistance
- Low volatile organic content

TECHNICAL DATA

Colour	Grey
Gloss	Matt
Volume Solids	Approx. 80%
Recommended DFT / Coat	100 – 200 µm
Theoretical Covering Capacity	8.0 sq.mtr/ltr @ 100 µm DFT 4.0 sq.mtr/ltr@ 200 µm DFT
Drying Time at 30ºC	Surface dry : 2 hours Hard dry : 5 hours Full cure : 7 days
Over-coating interval at 30ºC	Min : 5 hours Max : Unlimited, provided surface is dry and clean from all contamination (Minimum over-coating interval by brush application will be 8 hours at 30°C)

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30°C and 65% relative humidity

DIRECTIONS FOR USE

Surface Preparation

General:

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming
- Suitable zinc primer, epoxy primer; dry and free from all surface contamination. In case of aged epoxy coating, the surface should be sufficiently roughened prior to painting
- For application over weathered zinc primers, ensure white rust removal by thorough water scrubbing/ high pressure water cleaning. A mist coat is recommended when applied over zinc primers

Application Conditions:

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcodur MIO 410 HS / Apcodur 410 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix 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. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of too much thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 3 : 1
Induction Time	15 minutes
Pot Life at 30°C	3 hours

Application

Air Spray	
Recommended thinner	: T 141
Volume of thinner	: 5 – 25% *
Nozzle orifice	: 1.5– 3.0 mm
Nozzle Pressure	: 0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 47 p.s.i.)
Cleaning Thinner	: T 141
Airless Spray	
Recommended thinner	: T 141
Volume of thinner	: 5 - 15% *
Nozzle orifice	: 0.48 - 0.53 mm (19 – 21Thou)
Nozzle Pressure	: 17 – 20 MPa (= approx. 170 – 200 atm; 2500 – 2900 p.s.i.)
Cleaning Thinner	: T 141
Brush / Roller (Suitable for stripe coating and small areas)	
Recommended thinner	: T 141
Volume of thinner	: 5 - 15% *

***Note:** Depending on recommended thickness & application condition*

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed of in accordance with appropriate regional legislation

Product Characteristics

- Maximum film build in one coat is best attained by airless spray. Air spray (pressure pot) may require a multiple cross spray pattern to achieve optimum film build. By brush application 50-75 µm is achieved in one coat and multiple coats will be required to achieve the total specified thickness
- As common with all epoxies, the product will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance
- The maximum performance is achieved after complete curing

PACK SIZE	20 L (Base: 15 L & Hardener: 5 L)
STORAGE	**Shelf Life:** At least 12 months at 30ºC for original unopened pack, subject to inspection thereafter. Store in a cool, dry place, shaded conditions away from sources of heat, ignition and in accordance with local regulations
REGULATORY INFORMATION	**Flash Point:** Base: Not less than 24ºC ; Hardener: Not less than 24ºC **VOC:** Approx. 190gm/ltr (depending on shades) as per USA-EPA Method 24 **Product Weight:** Approx. 1.72kg/ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Head Office: Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, S.V. Road, Goregaon (W), Mumbai 400 062

Tel No: 022 62182700, CIN: U24110MH2011PTC220557, Email: customercare.apppg@asianpaintsppg.com , Website: www.asianpaintsppg.com