

APCOMIN 145



PRODUCT DESCRIPTION

Single pack, fast drying, direct to metal modified alkyd primer cum finish

FEATURES AND RECOMMENDED USE

- Good anticorrosive properties
- Ability to achieve higher film built per coat
- Excellent mechanical properties
- Used as self - priming topcoat

TECHNICAL DATA

Colour	Range
Gloss	Satin
Volume Solids	Approx. 63%
Recommended DFT / Coat	75 - 120 μ m
Theoretical Coverage Capacity	5.25 sq.mtr/ ltr @ 120 μ m DFT 8.40 sq.mtr/ ltr @ 75 μ m DFT
Drying time at 30°C	Surface dry : 45 minutes Hard dry : 5 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 6 hours Max. : 3 months, provided the surface is dry and cleaned from all contamination

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

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification
- Any surface defect revealed by the blast cleaning process should be corrected or treated appropriately (grinding, filling etc.)

Application Conditions

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

Instruction for use

- If settling is observed in the drum, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Thinner should be added after mixing. Addition of excessive thinner will lead to reduced sag resistance

Application

Brush / Roller <i>Suitable for stripe coating and small areas.</i>	
Recommended thinner	T - 131
Volume of thinner	0 - 10% *
Air Spray	
Recommended thinner	T - 131
Volume of thinner	5 - 20% *
Nozzle Orifice	1.5 - 3.00 mm
Nozzle Pressure	0.3 - 0.4 MPa
Airless Spray	
Recommended thinner	T - 131
Volume of thinner	5 - 10% *
Nozzle orifice	0.28 - 0.43 mm (11 - 17 Thou)

*Note: Depending on recommended thickness & application condition

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 131. 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

- The gloss and finish are dependent on the application method
- A minimum of 75 µm per coat is recommended for proper hiding by spray application, however pastel shades and certain shades in red, yellow and orange will require two coats to give complete hiding especially when applied over dark undercoats
- Over a period of time, product may tends to yellow, chalk & reduction in gloss can be observed
- At higher humidity drying may get retarded
- When product is applied at excess thickness than recommended thickness, it will delay the drying time

- Skinning is the common phenomenon during partial quantity use. It is recommended to remove skinning before application
- Apcomin HB QD Finish/Apcomin 144 must be thinned with the recommended thinner only. Usage of alternate thinners will affect the drying and curing process
- Premature exposure to condensation and rain may cause change in color and gloss
- This product is not recommended for use in immersion condition. Extended exposure of strong chemicals, solvents, spillage may result in discoloration

PACK SIZE	20 L
STORAGE	Shelf Life: Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Not less than 30°C VOC: Approx. 330 ± 20 gm /l (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.45 kg/l (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

***Disclaimer:** To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.*

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