

PLASCOTUFF 3500 SURFACE TOLERANT EPOXY

PRODUCT CODE: PEX 3500 Series (Base) & PEH 3500 (Catalyst)

TECHNICAL DATA SHEET

Product Description	A two-component high build; high solids surface tolerant epoxy coating.																													
Intended Uses	<ul style="list-style-type: none">For application to a wide variety of substrates including hand and mechanically prepared, abrasive blast cleaned and hydro blasted steel.For use on a wide range of intact, aged coatings (tested for compatibility).																													
Features & Benefits	<ul style="list-style-type: none">Surface tolerant.Fast drying timeExcellent corrosion resistance.Good resistance to splash and spillage of a wide range of chemicalsA high dry film build can be obtained																													
Product Information	Appearance	Semi-gloss																												
	Colour	SABS G35 Navy Light Grey and a range of colours on request (PEX 3500)																												
	Volume solids	81 %																												
	Recommended DFT	100 – 200 µm per coat.																												
	Recommended WFT	123 – 247 µm per coat																												
	Theoretical Spreading rate	8.1 m²/L at 100 µm DFT. at stated volume solids.																												
	VOC	199.53 g/L																												
	Flash Point:	27 °C for both components & mixed paint																												
Application Details	Mixing ratio	4 parts PEX 3500 (base) to 1-part PEH 3500 (catalyst) by volume																												
	Mixing	Stir both components separately with a power mixer until homogenous. Add the curing agent to the base and mix thoroughly together. Mix only in proportions shown above. Do not split packs.																												
	Method	<u>Airless spray:</u> Recommended Tip size: 17-21 thou Nozzle pressure: 172 – 207 bar (2.500-3000 psi) <u>Brush:</u> Min: 100(µm) Max: 125 (µm) can be achieved. <u>Roller:</u> Typically, 75-100 (µm) can be achieved. Multiple coats may be necessary to achieve the specified film build.																												
	Application Environment	<table><tr><th>Surface Temperature</th><th>Ambient Temperature</th><th>Relative Humidity</th></tr><tr><td>Min: 10 °C</td><td>Min: 10 °C</td><td>Min: 10 %</td></tr><tr><td>Max: 40 °C</td><td>Max: 40 °C</td><td>Max.: 85 %</td></tr><tr><td colspan="3">Or 3 °C above dew point</td></tr></table>				Surface Temperature	Ambient Temperature	Relative Humidity	Min: 10 °C	Min: 10 °C	Min: 10 %	Max: 40 °C	Max: 40 °C	Max.: 85 %	Or 3 °C above dew point															
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	Thinner	Can be thinned with EPOXY REDUCER (EPT 2) if necessary.																												
	Cleaner	EPOXY REDUCER (EPT 2)																												
	Pot life	2 hours @ 23 °C																												
	Drying time	<table><tr><th>Temp</th><th>Touch dry</th><th>Hard dry</th><th colspan="2">Overcoating Interval</th></tr><tr><td></td><td></td><td></td><th>Min</th><th>Max</th></tr><tr><td>10 °C</td><td>12 Hrs</td><td>16 Hrs</td><td>16 Hrs</td><td>4 Weeks</td></tr><tr><td>23 °C</td><td>2 Hrs</td><td>5 Hrs</td><td>5 Hrs</td><td>4 Weeks</td></tr><tr><td>40 °C</td><td>1 Hrs</td><td>5 Hrs</td><td>5 Hrs</td><td>4 Weeks</td></tr></table>				Temp	Touch dry	Hard dry	Overcoating Interval					Min	Max	10 °C	12 Hrs	16 Hrs	16 Hrs	4 Weeks	23 °C	2 Hrs	5 Hrs	5 Hrs	4 Weeks	40 °C	1 Hrs	5 Hrs	5 Hrs	4 Weeks
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Storage and Packaging	Store away from direct sun, heat, open flames, sparks or severe cold. Shelf life: 12 months Dual Packs: 5 L unit: 4 L in a 5L container Base (PEX 3500), 1 L in a 1 L container Catalyst (PEH 3500)																													

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Surface Preparation	<p>Prior to paint application all surfaces should be assessed and treated in accordance with 8504 -1:2000 and 8504 -2:2000</p> <p>MILD STEEL:</p> <ul style="list-style-type: none"> The surfaces to be over coated must be clean, dry and free from contamination. Oil and grease should be removed using PLASCON AQUASOLV DEGREASER (GR1) followed by clean water rinses. Dust and debris not to exceed 0, 3% when tested in accordance with SANS test method 769. Preferred surface preparation is abrasive blast cleaned to SA 2½ of the International standard ISO 8501-1:2007 to achieve a blast profile 50 - 75µm or mechanically abrade to Grade ST 3 of ISO 8501-1:2007. The primer must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be re-blasted to the standard specified above <p>GALVANISED IRON:</p> <ul style="list-style-type: none"> Preferred surface preparation: Sweep blast using Garnet Mica to achieve a blast profile of 20 – 30 µm. or if sweep blasting is not possible, clean surface area using PLASCON GALVANISED IRON CLEANER (GIC 1) and rinse until a water break free surface is obtained.
Caution	<ul style="list-style-type: none"> This product is not recommended for use in immersion environments. Will not cure adequately below 10 °C. For maximum performance curing temperature should be 3 °C above dew point. In common with all epoxies, these products will chalk on exterior exposure. Rate of chalking will depend on climatic conditions. Please Note maximum over coating intervals.
Safety Precautions	<ul style="list-style-type: none"> Always keep paint out of reach of children. Ensure good ventilation during application and drying. If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner. Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention. Harmful if swallowed. Seek medical attention and do not induce vomiting. Do not smoke while painting. Flammable. Store in a cool dry place away from heat and sparks. Refer to Safety Data Sheet for complete information.
Shipping Weight	<p>UN Shipping No: 1263</p> <p>Dual Pack: 5 L - 6,197 kg (PEX 3500), 1 L – 0.970 kg (PEH 3500)</p>

DISCLAIMER:

The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

N.B. Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the User to ensure that the latest TDS is being used.

NB: TO ORDER: Quote product name, product code number, packaging and colour.

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