

# PLASCOTUFF 6000 CHEMICALLY RESISTANT EPOXY

PRODUCT CODE: PEX 6000 Range

## TECHNICAL DATA SHEET

<b>Product Description</b>	Two pack epoxy phenolic coating			
<b>Intended Uses</b>	<ul style="list-style-type: none"> <li>A high performance coating for mild steel corrosion protection used in chemical environments.</li> <li>A high quality chemical resistant coating for aggressive environments including those found in mining installations and industrial areas.</li> </ul>			
<b>Features &amp; Benefits</b>	<ul style="list-style-type: none"> <li>Excellent chemical resistance.</li> <li>Ideal for use in C5 environments.</li> </ul>			
<b>Product Information</b>	Colours:	Grey ( <b>PEX 6004</b> ), Aluminium ( <b>PEX 6005</b> ), Pastel base ( <b>PET 6001</b> ), Transparent base ( <b>PET 6003</b> ), Red base ( <b>PET 6005</b> ) and Yellow base ( <b>PET 6004</b> ).		
	Appearance	Gloss		
	Volume solids	71%		
	Recommended DFT	100 – 400 µm		
	Recommended WFT	140 – 563 µm		
	Theoretical spreading rate	3.6 m <sup>2</sup> /L at 200 µm DFT		
	TVOC	237.9 g/L		
<b>Application Details</b>	Mixing ratio	4 parts Base ( <b>PEX 6004</b> ) to 1 part Curing Agent ( <b>PEH 6</b> ) by volume.		
	Mixing	Stir each component with power agitator before mixing. Then mix two components well. Do not over mix to prevent air incorporation.		
	Method	<u>Airless spray</u> : Use the product un-thinned. Tip size 0.019" - 0.023" <u>Brush and roller</u> : small areas only.		
	Thinner	No thinning required for airless spray. For conventional spray thin with minimum amount of <b>EPOXY THINNER (EPT 2) (10% maximum)</b>		
	Cleaner	<b>EPOXY THINNER (EPT 2)</b>		
	Pot Life	2 hours @ 23 °C		
		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		
	Drying time	Temperature	Touch dry	Hard dry
		10 °C	14 Hrs	24 Hrs
		23 °C	3 Hrs	6 Hrs
		40 °C	2 Hrs	4 Hrs
			Over-coating interval	
			Min	Max
			24 Hrs	14 Days
			7 Hrs	7 Days
			4 Hrs	5 Days
<b>Storage and Packaging</b>	<b>Highly sensitive to air and moisture. Keep containers tightly closed.</b> Store away from direct sun, heat and severe cold. Shelf life: 6 months Packaging: Dual Packs: <b>20L unit</b> : 15L in a 20L container Base (PEX 6004), 5L in a 5L container Curing Agent (PEH 6) <b>5L unit</b> : 4L in a 5L container Base (PEX 6004), 1L in a 1L container Curing Agent (PEH 6)			

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<b>Surface Preparation</b>	<p>Substrate preparation is a deciding factor in product performance. The surface to be coated should be clean, dry and free from contamination. All surfaces before painting should be assessed and treated in accordance to ISO 8504 -1:2000 and 8504 - 2:2000.</p> <p><b>MILD STEEL SURFACES:</b></p> <ul style="list-style-type: none"> <li>The surfaces to be over coated must be clean, dry and free from contamination.</li> <li>Oil and grease should be removed using PLASCON AQUASOLVE DEGREASER (GR 1) followed by clean water rinses. Soluble chloride content may not exceed 75 mg per m<sup>2</sup></li> <li>Dust and debris not to exceed 0.3% when tested in accordance with SANS test method 769.</li> <li>Preferred surface preparation is abrasive blast clean to SA 2½ of the international standard ISO 8501-1:2007 to achieve an angular blast profile 50 – 75 µm.</li> <li>Where abrasive blasting is not possible, prepare to ST3 of ISO 8501-1:2007. Prime with PLASCOTUFF 3000 SURFACE TOLERANT EPOXY (PEX 3004). The primer must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized area should be re-blasted to the standard specified above</li> </ul>
<b>Application</b>	<ul style="list-style-type: none"> <li>Apply 2-3 coats at the recommended DFT.</li> </ul>
<b>Cautions</b>	<ul style="list-style-type: none"> <li>Hand prepared steel will limit the life expectancy of the product.</li> <li>Will chalk and yellow on outdoor exposure.</li> <li>Not suitable for immersion.</li> </ul>
<b>Safety Precautions</b>	<ul style="list-style-type: none"> <li>Always keep paint out of reach of children.</li> <li>Ensure good ventilation during application and drying.</li> <li>If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner.</li> <li>Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention.</li> <li>Harmful if swallowed. Seek medical attention and do not induce vomiting.</li> <li>Do not smoke while painting.</li> <li>Flammable. Store in a cool dry place away from heat and sparks. Keep container tightly closed at all times.</li> <li>Refer to Safety Data Sheet for complete information.</li> </ul>
<b>Shipping Weight</b>	<p>UN Shipping No. 1263</p> <p>Dual Pack: <b>20L</b> - 25.827kg (PEX 6004), <b>5L</b> - 5.050kg (PEH 6)</p> <p>Dual Pack: <b>5L</b> - 8.609kg (PEX 6004), <b>1L</b> - 1.010kg (PEH 6)</p>

### **DISCLAIMER:**

The recommendations contained herein are given in 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.

**NB:** 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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