

## Epoxy Metal Coating

### Description

**H**appilac Epoxy Metal Coating is a durable, 2 pack epoxy coating. It is designed to provide excellent abrasion, outstanding mechanical properties combined with resistance to mild acids, bases and other chemicals to metals. It has been especially formulated to provide fast drying. It can be applied at low temperature to provide hard wearing, to colorful surfaces. It cures to smooth semi-gloss finish which is easily cleaned.

### Features

- Excellent wear resistance
- Excellent chemical resistance
- Superior to chlorinated rubber
- Minimizes maintenance costs
- Brightens working environment
- Easy application
- Easy cleaning
- Available in high gloss, semi gloss and matt finish

### Recommended For

**H**appilac Epoxy Metal Coating is suitable for severe industrial Instruments, beverage plants, refineries, food process units, computer electronic accessories, pulp mills, construction and other chemical industries.

### Limitations

- It is not recommended for surfaces known to suffer from rising damp.
- Pot life is small.

Product Information															
General Properties	Coating Properties														
<b>Specific Gravity</b>															
Component A	1.25±0.05														
Component B	0.930±0.05														
Mixing ratio	3:1 (Vol/Vol)														
Volume Solids	70±3%														
Color	A good color range is available														
Pot Life	Approx. 1-1.5 hours @ 30°C														
Thinner	Epoxy Thinner														
Flash Point	27°C														
Covering	10-12m <sup>2</sup> /liter/Coat														
Recommended WFT	150-200 micron/Coat														
Recommended DFT	95-100 micron/Coat														
<b>Drying/Curing @ 30°C</b>															
Tack Free	2-3 hours														
Recoating time	6-12 hours														
Cure time	5-7 days														
	<table border="0"> <tr> <td>Flexibility</td> <td>Good</td> </tr> <tr> <td>Water resistance</td> <td>Excellent</td> </tr> <tr> <td>Abrasion resistance</td> <td>Good</td> </tr> <tr> <td>Corrosion resistance</td> <td>very good</td> </tr> <tr> <td>Shelf life</td> <td>1 year</td> </tr> <tr> <td>Temperature resistance</td> <td>up to 100°C</td> </tr> <tr> <td>Chemical resistance</td> <td>Good</td> </tr> </table> <p>Surface staining may result from exposure to some aggressive chemicals. Good housekeeping practice requires that spills be quickly removed and washed away.</p>	Flexibility	Good	Water resistance	Excellent	Abrasion resistance	Good	Corrosion resistance	very good	Shelf life	1 year	Temperature resistance	up to 100°C	Chemical resistance	Good
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### Surface Preparation

**Steel:**

Ensure that the surface is free from oil and grease. Abrasive blasts clean to a class 2 near white metal finish. Surface preparation guidelines cannot cover all sites or field contingencies and it is always recommended that on spot adhesion test be performed as part of the standard Quality Assurance audit for the project.

**Metals:**

In case of mild conditions of application, remove the previous coat with a mechanical tool, wire mesh or a mild sweep blast is to be done. In case of detailed surface preparation is warranted, remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1. Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface. Ideally abrasive blast clean to minimum standard of Sa 2-1/2 Swedish standard

SIS 05 5900 or ISO 8501-1:1988. Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner. After blasting, remove dust from the surface. The surface to be coated must be clean and dry with Happilac Epoxy Primer before applying the top coat.

**Aluminum:**

Degrease and abrade with Happilac Epoxy Thinner. Apply Happilac Metal Coating Epoxy Primer. Immediately follow with the top coat. Exclusions for successful application include perpetually wet surfaces and also large cavities on metal surfaces.

### Application

Mix Component A & Component B in the recommended ratio. Thorough care should be taken that excess air bubbles should not form. Give an indication period of 10-15 minutes prior to application. A normal brush or a roller may be used for different shapes or touch ups, however additional coats may be required to achieve the recommended film thickness. The method of application is recommended for stripe coating welds, edges, rivets etc.

Allow the coating to cure for 7 days prior to subjecting chemical exposure.

Application Guideline	Air Spray	Air Less Spray	Brush/Spray
Type of thinner	Happilac Epoxy Thinner	Happilac Epoxy Thinner	Happilac Epoxy Thinner
Volume of thinner	As per requirement	As per requirement	10-15%
Nozzle Orifice	1.3-2.0mm	00.15-20mm	.....
Nozzle Pressure	3-4 Bars	140-160 Bars	.....

### Recommended Sequence and No. of Coats

Steel Floors	1 Coat of Happilac Metal Coating Epoxy Primer 2 Coats of Happilac Epoxy Metal Coating
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### Packing and Storage

Happilac Epoxy Metal Coating is available in 4.00 liters gallon and 20 liters packing containing base and hardener in correct proportions.

Store in cool and dry place between 5-25°C, away from source of heat and ignition. Protect from frosting.

### Health and Safety Notes

- When applying paint, wear appropriate eye protection.
- In case of eye contact with product, rinse with plenty of water for at least 10 minutes.
- Don't breathe spray mist or dust.
- Ensure proper ventilation when applying paint.
- If swallowed, it may cause serious damage.
- When empty, don't use its container for edible storage.
- Place out of reach of the children.
- Pregnant women are advised to avoid breathing of paint mist or spray.
- In case of any emergency, undergo medical supervision as soon as possible.

**WARNING:** Scraping/sanding off previously painted surfaces may release lead dust or fumes. Lead is highly toxic; take protective measures thoroughly when rubbing off the old surfaces.