EPODUX 294

Epoxy phenolic coating

DEFINITION

Epoxy phenolic topcoat.

INTENDED USES

Anti corrosion protection for any kind of metal structure subject to aggressive environments and thermal stress.

- Chemical, petroleum or nuclear industrial process.
- Piping.
- Metallic frame structures...

PRINCIPAL CARACTERISTICS

Quick drying.
Chemical resistance (Please contact our Technical Department).
Resistance to dry heat (150°C continuous and up to 200°C as peak temperature). The film properties are not affected by the heat, however it can be observed a color change.

CERTIFICATIONS / APPROVALS

EDF : Is used in the following systems registered in the FNP under number 1038.

TECHNICAL DATA

Gloss level	: Satin
Colours	: according to RAL color charts and AFNOR
Number of components	: 2
Mix ratio, by weight	: 89,7/10,3
Mix ratio, by volume	: 85/15
Specific gravity	: 1,42 +/- 0,05 g/cm³
Solids volume	: 67,4 +/- 3%
Solids weight	: 79,3 +/- 2%
Typical thickness (dry)	: 50 µm
Typical thickness (wet)	: 75 µm
Theoretical spreading rate	: 13,5 m²/l for 50 µm dry

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INSTRUCTIONS

SURFACE PREPARATION

The surface must be clean, dry and have two layers of EPODUX 292 (contact our Technical Department).

APPLICATION

Mixing : The product is sold as pre-prepared kits. For the hardener portion in the base coat container and mix. Take care not to create air bubbles. The minimal recommended temperature of the mixture must be at least 10°C, or a thinner may be required in order to achieve adequate viscosity. Please note that an excessive amount of thinner may induce a dripping phenomenon.

Induction time : None

Working pot life :

Temperature	Time
10°C	6 hours
20°C	3 hours
30°C	1 hour and 30 mn

Substrate temperature : Between +5°C and +40°C and at least 3°C higher than the dew point in order to eliminate any risk of condensation.

Weather conditions : The temperature should be between 10°C and 45°C
The relative humidity should be between 0% and 85%

Technical note : Do not keep the spraying equipment loaded for longer than the lifespan of the product in a container. Rinse the equipment with the 67-232 v02 thinner and rinse thoroughly with a cleaning solvent. The container containing the prepared and unused mixture must not be hermetically sealed. In case of prolonged interrupted use, it may be preferable to prepare a new kit.

AIRLESS SPRAY

Thinner : 67-232 v02
Dilution : 0 to 7,5 %
Nozzle : 0.015-0.017
Pressure at nozzle : 150-200 bars
Report pump Min: 45 / 1

AIR SPRAY

Thinner : 67-232 v02
Dilution : 7 to 15%
Nozzle : depending on equipment
Pressure at nozzle : 3-4 bars

BRUSH

Thinner : 67-232 v02
Dilution : 7 to 15%

ROLLER

Thinner : 67-232 v02
Dilution : 7 to 15%

CLEANING SOLVENT : D 600 or 67-232 v02

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CURING TIME

	Drying time		Overcoating interval		
Temperature	Touch dry	Hard dry	Minimum	Maximum	Ready for use
10°C	15 hours	20 hours	24 hours	120 days	14 days
20°C	6 hours	10 hours	12 hours	90 days	7 days
30°C	2 hours and 30 mn	4 hours	6 hours	60 days	5 days

COMPATIBILITY

Previous coat(s)	Itself, EPODUX 292, EPODUX 291.
Subsequent coat(s)	Itself.

REGULATORY SPECIFICATIONS

AFNOR RATING	AFNOR NFT 36 005 rating Family I Class 6b
VOC (Directive 2004/42/EC)	EU limit value for this product (cat. A/i) : 500 g/l (2010) This product contains max 380 g/l VOC

HEALTH AND SAFETY

Flash point	BASE : between 23°C and 55°C HARDENER : between 23°C and 55°C
Transport and labelling	Refer to the safety data sheet established as per applicable European directives
Shelf life	3 years in original full, sealed packaging. Store in a cool, ventilated place.
Precautions	Refer to the current material safety data sheet

PACKAGING

KIT	BASE	HARDENER
15 l	12.75 l	2.25 l
5 l	4.25 l	0.75 l

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