

EPODUX ST 86-31

"Tolerant " Epoxy

DEFINITION

Primer or intermediate epoxy paint, two components, high build, tolerant to humidity. Contains zinc phosphate.

INTENDED USES

Long lasting coating used to protect metallic structures exposed to marine or industrial environments.
Can be used for new work, repair or renovation of existing systems.

PRINCIPAL CHARACTERISTICS

Boasts good adhesion on :
- Sa 2 1/2 abrasive blasted steel.
- High pressure water jet blasted steel with a previous coating.
- Previous undamaged glycerophthalic and epoxyidic coats.
- damp surface (non dripping) and cold (3°C minimum)
Properties enabling to apply 250 µm-thick layers with no sagging.

Notes : The film properties, excluding the colour, are not affected by actinic radiation.

CERTIFICATIONS / APPROVALS

ACQPA : Brand ACQPA 26792
Is used in the following certified systems : C3ANV1337, C3ANV1339, C4ANV1336 and C4AMV 1338

TECHNICAL DATA

Gloss level	: Satin
Colours	: Grey, red-brown; please contact us for other colours
Number of components	: 2
Mix ratio, by weight	: 83/17
Mix ratio, by volume	: 3/1
Specific gravity	: 1,53 +/- 0,05 g/cm³
Solids volume	: 86,00 +/- 3%
Solids weight	: 91.5 +/- 2%
Typical thickness (dry)	: 120 µm
Typical thickness (wet)	: 140 µm
Theoretical spreading rate	: 7,2 m²/l for 120 µm dry

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INSTRUCTIONS

SURFACE PREPARATION

New steel « heavy duty use »

Abrasive blast cleaning at Sa 2 ½ according to ISO 8501-1 : 2007.

Roughness profile : Mid G according to ISO 8503-2 (Ra 10-12,5 µm).

High pressure water jet cleaning (UHP) at Wa 2 1/2 -L according to ISO 8501-4 : 2006.

Old coat

EPODUX ST 86-31 is adapted to recoat some old and undamaged paints. In all cases, it is necessary to perform a test of convenience (application followed by an adhesion test after complete drying) to validate the compatibility of products and surface preparation chosen.

APPLICATION

Mixing : The product is supplied in pre-measured kit form. Pour the hardener part into the base tub and mix, taking care not to incorporate air. The mixing temperature should be at least 10°C. If not, it is necessary to add thinner to get the application viscosity. N.B. excess thinner increases the risk of sagging.

Induction time : None

Working pot life :

Temperature	Time
10°C	1h30
20°C	1 hour
30°C	30 minutes

Substrate temperature : Between +3°C and +40°C

Weather conditions : The temperature should be between 7°C and 45°C
The relative humidity should be between 0% and 100%

Technical note : Do not leave paint in spray equipment for longer than the pot life. Rinse equipment with 67-232 v02 thinner then clean it carefully with cleaning solvent. Prepared mix that is not used should not be sealed hermetically. For an extended stop, it is better to prepare a new kit.

AIRLESS SPRAY

Thinner : 67-232 v02

Dilution : 0 to 20 %

Nozzle : 0.013-0.019

Pressure at nozzle : 250-300 bars

Report pump Min: 60 / 1

AIR SPRAY

Not applicable

BRUSH

Thinner : 67-232 v02

Dilution : 0 to 5 %

Thickness achievable after several passes

ROLLER

Thinner : 67-232 v02

Dilution : 0 to 5 %

Thickness achievable after several passes

CLEANING SOLVENT : 67-232 v02

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CURING TIME

Temperature	Drying time		Overcoating interval	
	Touch dry	Hard dry	Minimum	Maximum
10°C	10 hours	15hours	12 hours	not critic.
20°C	4 hours and 30 mn	5 hours	4 hours	not critic.
30°C	3 hours	4 hours	2hours and 30 minutes	not critic.

COMPATIBILITY

Previous coat(s) Itself, CHIMICOTE, EPODUX PRIMER 61-134 v01, EPODUX ZINC 62-208, PRIMODUX H, EPODUX BR 100, EPODUX IM 209...

Subsequent coat(s) Itself, POLYSTRIA v01, FERROTHANE...

REGULATORY SPECIFICATIONS

AFNOR RATING AFNOR NFT 36 005 rating Family I Class 6b

VOC (Directive EU limit value for this product (cat. A/j) : 500 g/l (2010)

2004/42/EC) This product contains max 500 g/l VOC

HEALTH AND SAFETY

Flash point BASE : Between 23°C and 55°C
HARDENER : Greater than 61°C

Transport and labelling Getting closer to the safety data sheet prepared in accordance with current 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	11.25 l	3.75 l